

Cast-A-Form

TECHNICAL DATA BULLETIN

HOT MELT EUTECTIC SALT 9600, 9601, 9602

Cast-A-Form is a water soluble hot melt system suitable for creating mold and mandrel forms which may be used in the manufacture of various composite structures including hollow items such as ducts and tanks or pressure vessels. It is a powder, which only requires melting and subsequent pouring into a heat resistant mold. It solidifies on cooling and may be easily demolded without the use of mold release agents.

HANDLING PROPERTIES

	<u>9600</u>	<u>9601</u>	<u>9602</u>
Heat Resistance, °F	275	350	450
Melting and Pouring Temperature, °F	306-333	326-420	441-550
Mold Preheat Temperature, °F	150-200	175-225	300-350

PHYSICAL PROPERTIES

	<u>9600</u>	<u>9601</u>	<u>9602</u>
Color	White	Green	White
Compressive Strength at 75°F, psi	17,000	15,000	14,000
Compressive Strength at 300°F, psi		2,300	6,700
CTE at 75°F to Melting Temperature, in/in/°F	2.8×10^{-5}	2.9×10^{-5}	2.4×10^{-5}
CTE at Melting Temperature, in/in/°F	2.4×10^{-5}	2.8×10^{-5}	2.4×10^{-5}
Water Solubility Rate, 140°F, min/lb	5-10	5-10	5-10
Cast Density, lbs/ft ³	129-133	129-133	129-133

NOTE:

Always keep Cast-A-Form dry. Keep containers covered to prevent moisture absorption. Never add anything to Cast-A-Form in the powder or liquid state.

CAST-A-FORM MOLDS:

High temperature epoxy composites may be used for short run situations. For medium to long runs, Aluminum molds are suggested. Walls of the molds should be as uniform in thickness as possible. The pouring gate should open into the largest cavity of the mold. See Endurance Technologies' Guide to Cast-A-Form.

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Endurance Technologies, Inc. is not a patternmaker. We have experience only in the compounding of resins, not in the actual manufacture of the tools or patterns. Each part is different. The user should run tests to assure the suitability of the system for use in a particular application. The test data and results set forth herein are based on laboratory work and do not necessarily indicate the results that the buyer or user will attain.

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