



General description

NM Tooling 179 / NM Hardener 179B is a metalpowder filled epoxy designed for manufacturing of press-tools.

The tools can either be made by a direct casting in a negative mould or by working with casted blocks. Surfaces that have been worked can be polished.

NM Tooling 179 has a very low reactivity which means that the heat progress during the curing can be kept on a low level.

The slow curing means that the air mixed in comes out before curing. The disadvantage with a low reactivity is a long curing time before optimum qualities.

By curing at higher temperatures, 80°C in 4 - 5 hours, after curing for 24 hours in room temperature the curing time will be reduced.

Typical applications:

- Manufacturing of press-tools

Typical properties

Resin:

NM Gjutharts 179

Hardener:

NM Härdare 179 B

Mixing ratio:

Resin-Hardener 100-13 by weight

<i>Density:</i>	1700 kg/m ³
<i>Potlife 100g 20°C:</i>	~5 hours
<i>HDT:</i>	45°C
<i>Pull out force 25 mm M6 screw:</i>	110 MPa
<i>Torque 22 mm M12 screw:</i>	55 Nm
<i>Compressing strength:</i>	97 MPa
<i>Tensile strength:</i>	66 MPa
<i>E-modulus:</i>	6.7 GPa
<i>Normal packing:</i>	5.0 + 0.650 = 5.65 kg
<i>Cleaning solvent:</i>	Acetone

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