



**ES-218  
EPOXY SURFACE COAT  
SERIES  
WHITE, SANDABLE**



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**DESCRIPTION**

ES-218 is white, thixotropic, room temperature cure, sandable epoxy surface coat designed for duplication work. The popular handling properties of ES-218 produce accurate, detailed, chip resistant surface coat duplications in epoxy laminate fabrications. The versatility of this resin system, when used with ES-218-1 Hardener, also doubles as a chemical resistant epoxy coating used to fill surface texture on composite parts. Typically one application applied using brush or roller is all that is required to fill in the texture or weave in cloth fabric. NOTE: Do not topcoat directly over ES-218-1 composite coating applications. Sand ES-218-1 and use surface primer products as recommended by topcoat manufacturer. Typical applications include: masters, models, patterns, duplicating, engineering tooling, checking and drill fixtures and as a composite coating.

**TYPICAL HANDLING CHARACTERISTICS @ 77°F (25°C)**

	<u>ES-218R/ES-218H</u>	<u>ES-218 R/ES-218-1H</u>
Mix Ratio (parts by weight) .....	100R/14H .....	100R/16H .....
Mix Ratio (parts by volume) .....	5.9R:1H .....	5R:1H .....
Work Life (228-232 gram mass) .....	22 minutes .....	16 minutes .....
Mixed Viscosity .....	25,000cps .....	14,500cps .....
Mixed Density .....	1.39 g/cc .....	1.28 g/cc .....
Cure-to-Demold Time .....	8-12 hours .....	8-12 hours .....
Cure-to-Sanding Time .....	N/A .....	4-6 hours .....
Complete Cure .....	3-5 days .....	3-5 days .....
Mixed Color .....	White .....	White .....
Shelf Life Resin (in original unopened containers) .....	2 years .....	2 years .....
Shelf Life Hardener (in original unopened containers) .....	2 years .....	2 years .....

**TYPICAL PHYSICAL PROPERTIES (Testing conducted on cured cast bar samples)**

Tensile Strength .....	4,132psi (29MPa) .....	5,973psi (41MPa) .....
Tensile Modulus .....	868,900psi (5,991MPa) .....	1,146,000psi (7,901MPa) .....
Tensile Elongation .....	0.7% .....	0.6% .....
Flexural Strength .....	7,110psi (49MPa) .....	10,070psi (69MPa) .....
Flexural Modulus .....	414,800psi (2,860MPa) .....	573,800psi (3,956MPa) .....
Compressive Strength .....	7,987psi (55MPa) .....	13,350psi (92MPa) .....
Compressive Modulus .....	149,600psi (1,032MPa) .....	244,700psi (1,687MPa) .....
Izod Impact Strength .....	5.7 in-lb/ft .....	5.1 in-lb/ft .....
Shore Hardness .....	83 Shore D .....	84 Shore D .....
Heat Deflection Temperature @ 264 psi .....	114°F (46°C) .....	167°F (52°C) .....
Shrinkage .....	0.002 in/in .....	0.002 in/in .....
Moisture Absorption (ASTM D-570.88) .....	N/A .....	0.29% .....

ES-218 Series Tech/Revised 1/13/15  
Supersedes 5/16/14

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