EpoxAcast® 670 HT

Epoxy; Epoxide

Smooth-On, Inc

Message:

EpoxAcast® 670 HT (formerly 20-136) is an epoxy casting compound which offers high heat resistance up to350° F/177° C if post cure schedule is used. EpoxAcast® 670 HT features a relatively low viscosity that ensures minimal bubble entrapment. EpoxAcast® 670 HT also offers an extra long working time of 3 hours. Castings cure with negligible shrinkage and are very hard, very strong and heat resistant. EpoxAcast® 670 HT is ideal for making vacuum form molds, foundry patterns, forming dies & fixtures, hard rollers, industrial parts and high impact tools. EpoxAcast® 670 HT is also suitable for encapsulation applications or for use as a high temperature epoxy for bonding a variety of surfaces.

General Information	
Features	Bondability
	High Hardness
	High Heat Resistance
	High Strength
	Low Shrinkage
	Low Viscosity
Uses	Modeling Material
	Molds/Dies/Tools
	Patterns
	Rollers
Appearance	Beige
Processing Method	Casting
	Encapsulating

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.15	g/cm³	ASTM D1475
Specific Volume	0.741	cm³/g	ASTM D792
Cure Time [1]	1.0	day	
Hardness	**Nominal Value**	**Unit**	**Test Method**
Durometer Hardness (Shore D)	90		ASTM D2240
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	2290	MPa	ASTM D638
Tensile Strength (Break)	31.0	MPa	ASTM D638
Tensile Elongation (Break)	0.65	%	ASTM D638
Flexural Modulus	1750	MPa	ASTM D790
Flexural Strength	75.8	MPa	ASTM D790
Compressive Modulus	699	MPa	ASTM D695
Compressive Strength	89.6	MPa	ASTM D695

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed [2]	177	°C	
0.45 MPa, Unannealed [3]	122	°C	
Thermoset	**Nominal Value**	**Unit**	**Test Method**
Thermoset Components			
Part A	Mix Ratio by Weight: 100		
Part B	Mix Ratio by Weight: 16		
Pot Life	180	min	ASTM D2471
Thermoset Mix Viscosity	6000	cP	ASTM D2393

NOTE	
1.	followed by: Heat cure for 2 hrs at 175°F/80°C followed by 3 hrs at 300°F/150°C
2.	if post cured according to heat curing schedule
3.	If cured at room temperature

Recommended distributors for this material

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