



**epoxy tech**<sub>mcs inc.</sub>  
**east system**®

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Technical bulletin

**TOOLING**

**129**

**WHITE LAMINATING SYSTEM**

**Description:**

The 129 is a two component, room temperature cure epoxy system conceived to laminate fiberglass. It does not contain solvent (100% solid) or any other volatile product. It offers good wetting properties and rigidity. This system has been developed to meet the most severe standards of the aircraft industry.

**Uses:**

Recommended for laminating molds, F.R.P. molds, foundry patterns and foaming molds.  
 Also recommended for duplicating models.

**Typical uncured properties:**

Components	Mixing Ratio		Specific Gravity	Viscosity	Packaging			Color
	By weight # Parts	By volume # Parts			Kg			
Resin	100	100	1.44	2 000 - 2 400 Brookfield @ 25° C mPa.s (cps)	4.30	21.55	235.00	White
Hardener	16	23	1.01	1 600 - 1 800	0.70	3.45	37.60	Honey
Mix			1.36	2 000 - 2 300	<b>5.00</b>	<b>25.00</b>	<b>272.60</b>	White

**Gel time:**

Minutes	Temp. °C	Mass (gr.)
33 - 38	22	150

**Coverage:**

One (1) kg covers approximately 1.4 m<sup>2</sup> (15 ft<sup>2</sup>) with 9 ounce fiber glass cloth

**Typical cured properties:**

Minimum cure schedule for 48 hours @ 22°C

Tensile strength, psi:	25 085
Flexural strength, psi:	25 000
Compression strength, psi:	23 000
Hardness, Shore D:	90
Coefficient of thermal expansion (°F)	1.20 x 10 <sup>-5</sup>

**Pretreatment of surfaces:**

The surface of the mold should be properly prepared. Wood or plaster molds should be sealed with several coats of nitrocellulose brushing lacquer. Apply three or four coats of Epoxy Tech's film forming release agent #10. Gently remove any excess with a brush or a cloth.

**Mixing:**

1. Mix 129 resin only with 129 hardener.
2. Do not use damaged or leaking containers.
3. Premix resin and hardener separately. Then place the hardener into the resin container according to the required mixing ratio.
4. Blend the hardener into the resin thoroughly using a paddle attached to a low speed heavy duty electric drill at 300-600 rpm. Continue to mix for a minimum of 3 minutes or until the mix becomes homogeneous.
5. Never dilute with solvents.

**Cleaning of tools:**

Tools and equipment should be cleaned immediately after use with Epoxy Tech's #17 solvent or with Epoxy Tech's "Clean tool" #4 for a safer use.

**Storage:**

Keep containers closed until just before use at a temperature above 15°C.

**Caution:**

Keep resin and hardener away from eyes and skin. Avoid breathing of vapors and use good ventilation. Like any reactive material, uncured resin and hardener may irritate sensitive skin. Wear protective clothing, goggles and gloves.

**FIRST AID:**

**Eyes:**

Flush immediately with plenty of water for 15 minutes and obtain medical aid.

**Skin:**

Clean skin with warm water and a soft soap. Never use solvents to remove material from skin.

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**NOTE:**

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