

Product Description

Vibra-Tite 951 is a two component, aluminum filled epoxy for making molds, patterns, and holding fixtures. When the two components are properly mixed, the epoxy cures at room temperature to a silvery grey material that can be machined, drilled, sanded or tapped.

Features and Benefits

- Pourable, self-levelling consistency
- Machinable
- Silver-grey metallic appearance
- Low shrinkage

Properties of Uncured Material (resin)

Chemical Type	Epoxy
Appearance	Silver-grey
Specific Gravity	1.84
Toxicity	Low
Solids	100%
Viscosity @ 25°C, cP	150,000

Properties of Uncured Material (hardener)

Chemical Type	Amine
Appearance	Amber
Specific Gravity	0.98
Toxicity	Low
Solids	100%
Viscosity @ 25°C, cP	1200

Properties of Mixed Material

Wt. Mix Ratio, Resin: Hardener	9:1
Vol. Mix Ratio, Resin: Hardener	5:1
Appearance	Silver-Grey
Mixed Viscosity @ 25°C, cP	15,000-25,000
Gel Time, 100g @ 25°C	2 hrs
Pot Life, @ 25 °C	75-90 min
Functional Cure	Approximately 16 hrs
Full Cure	72 hrs

Properties of Cured Material

Specific Gravity	1.6
Hardness Shore D @ 25°C	85-90
Shear Adhesion Steel to Steel (ASTM D1002, 24 Hour Cure)	>2500 psi

Mixing and Application Instructions

When using Vibra-Tite 951 two-component epoxy, it is recommended that full units be mixed. Containers are filled to specific levels to match the prescribed mix ratio. For best results add the hardener to resin in the original resin container. If mixing less than full units, the resin side must be mixed before dispensing as settling may occur. For best results when using less than full container quantities, mixing by weight is highly recommended. Mix material with a spatula or tongue depressor with slow motions to prevent entrapment of air while scraping the sides of the container to ensure a homogeneous mixture.

Application of material should be done at ambient temperatures of 55-90 °F. At colder temperatures, preheating of surfaces is required and the material should be maintained at elevated temperature until material is cured. Surfaces should be dry and free of dirt, oil, grease or other contamination. For best bonding results, either grit blast or abrade the surfaces with sand paper.

General Information

Storage

Product should be stored in cool, dry conditions. Vibra-Tite 951, when un-mixed, has a shelf life of at least 12 months when stored at 25°C. Storage in cool, clean areas is recommended. Usable shelf life may vary depending on method of applications and storage conditions.

Note

The data are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is recommended that the product be tested in the application for which it is to be used.