



# ALCHEMIX EP 4060C

*Two Part Epoxy Coupling Coat System  
For use with GELCOAT EP 4060 and ALCHEMIX EP 4350  
Laminating Paste*

ALCHEMIX EP 4060C is a two component, unfilled, thixotropic epoxy resin system for use with GELCOAT EP 4060 and ALCHEMIX EP 4350 laminating paste. ALCHEMIX EP 4060C is specifically formulated for high temperature applications.

### Special Features

- High heat distortion temperature
- Easy application on vertical surfaces

### Mix Ratio

**EP 4060C : H4060C**  
By Weight 100 : 25

### Product Data

Property	Units	EP 4060C	H4060C	Mix
<b>Material</b>	-	Epoxy resin	Formulated amine	Epoxy
<b>Appearance</b>	-	Brown thixotropic paste	Amber liquid	Brown thixotropic paste
<b>Viscosity (25 °C)</b>	mPa.s	80,000 – 140,000	10 – 20	15,000 – 25,000
<b>Density (25 °C)</b>	g/cm <sup>3</sup>	1.10 – 1.20	0.95 – 1.00	1.05 – 1.15
<b>Pot Life (200g, 25 °C)</b>	Minutes	-	-	60 – 80
<b>Demould Time (200g, 25 °C)</b>	Hours	-	-	24 may be longer in cold conditions



**Cured Properties**

Properties	Standard	Units	Result (Full Cure)
Hardness	BS 2782: Part 3: Method 365B	Shore D	85 – 90
Flexural Strength	BS 2782: Part 3: Method 335A	MPa	10 – 15
Flexural Modulus	BS 2782: Part 3: Method 335A	MPa	1900 – 2200
Heat Distortion Temperature (HDT)	TMA	°C	150 – 160 (After full post cure, see below)

**Method of Use**

***Mixing and Application***

ALCHEMIX EP 4060C should be mixed with HARDENER H4060C according to the indicated mixing ratio. Both components should be thoroughly mixed, care should be taken to avoid air entrapment and make certain that material at bottom and sides of container is thoroughly stirred into centre. When the gelcoat has reached a tack free stat, the mixed material should be evenly applied onto the gelcoat by brush. See the technical datasheet for GELCOAT EP 4060 for further details

***Cure and Post Cure***

To achieve full high temperature properties, a step wise post cure treatment is recommended. Allow the product to cure at room temperature for at least 24 hours, then heat to 40°C for 1 hour, followed by 60°C for 1 hour, followed by 80°C for 1 hour, followed by 100°C for 1 hour, followed by 120°C for 1 hour, followed by 140°C for 1 hour, followed by 160°C for 1 hour. Then allow the product to slowly return to room temperature. The product can be used without post cure or with partial post cure, but will not achieve full high temperature properties.

***Laminating***

After ALCHEMIX EP 4060C coupling coat has been applied, ALCHEMIX EP 4350 laminating paste should be applied. See the technical data sheet for ALCHEMIX EP 4350 for full details on the use of this product.

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## **Storage**

ALCHEMIX EP 4060C and HARDENER H4060C should be stored in original, unopened containers between 15 and 25°C. KEEP THE PACKING TIGHTLY SEALED WHEN NOT IN USE.

If stored under the above conditions, ALCHEMIX EP 4060C / H4060C will have a shelf life of 12 months, from the date of production.

## **Packaging**

ALCHEMIX EP 4060C is supplied in 1kg, 5kg and 10kg containers.  
HARDENER H4060C is supplied in 250g, 1.25kg and 2.5kg containers.

(Please contact Alchemie Ltd for bulk supply)

## **Further Information**

This data is not to be used for specifications. Values listed are for typical properties and should not be considered minimum or maximum.

Our technical advice, whether verbal, or in writing is given in good faith, but without warranty – this also applies where proprietary rights of third parties are involved. It does not release you from the obligation to test the products supplied by us as to their suitability for the intended process and use.

Before using any of our products, users should familiarise themselves with the relevant Technical and MSDS provided by Alchemie Ltd.

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## **Alchemie Limited**

Alchemie Ltd develop, formulate and distribute Epoxy Resins, Polyurethane Resins, Silicones, Model Boards and Sheet Wax for use in the following applications:

- Electrical encapsulation
- Rapid Prototyping
- Prototypes
- Casting
- Gel Coating
- Laminating
- Model Making
- Master Models
- Flexible and rigid mould making

We offer fast service, technical support, development expertise, innovative products, diverse knowledge and experience.

We are a well-established company, with a high level of investment and experience. We implement BS EN ISO 9001.

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