

## Description

TC80 Tool Cast is an aluminium filled epoxy casting resin designed specifically for the production of high quality cast epoxy tools such as vacuum forming tools.

## Key Features

- Aluminium filled
- Excellent Mechanical Properties
- Excellent Thermal Stability
- Medium Viscosity Resin
- Ideal for Vacform and other Tools

## Typical Uses

- Vacuum forming male tools
- Platen press tool
- Any cast mould tool

## How To Use

Before mixing, ensure that both the Tool Cast epoxy resin and its hardener are both at room temperature (between 15° and 25°C). Thoroughly mix the Tool Cast epoxy resin to distribute the aluminium filler throughout the resin.

Pattern or mould surfaces should be clean and dry and treated with an appropriate mould release agent. Porous surfaces such as foam or wood (including MDF) should be thoroughly sealed using either a coat of epoxy or a suitable filler/primer paint (such as two pack polyurethane) and finished to the required standard.

Any deep sections in the moulding should be 'blocked out' using a tapered wooden block to reduce the quantity of resin that will be required and reduce any shrinkage. We recommend blocking out any areas where the casting resin would be deeper than 75mm. Always ensure that any such wooden core/block is at least 35mm from the mould surface. Wooden blocks/cores should be removed after the resin has cured, before the mould is used.

## Mix Ratio

### Mix Ratio 100:6 by Weight

Tool Cast Epoxy Casting Resin should be mixed with its Hardener at a ratio of 100 parts of resin to 6 parts of hardener, by weight.

The correct ratio of resin to hardener must be maintained to ensure a proper cure. Failure to do so will result in a poor or only partial cure of the resin, greatly reduced mechanical properties and possibly other adverse effects. Under no circumstances add 'extra hardener' in an attempt to speed up the cure time; epoxies do not work in this way.

## Mixing Instructions

Only weigh out and mix as much resin as you can use within the pot life.

Weigh or measure the exact correct ratio of resin and hardener into a straight sided container. Using a suitable mixing stick begin to mix the resin and hardener together to combine them completely.

Mix thoroughly to ensure that the hardener is well distributed throughout the resin and again ensure that any aluminium filler is evenly distributed throughout the resin before pouring.

Care should be taken to avoid aerating the resin whilst mixing. Use a steady mixing action, moving material from the bottom and edges of the container into the middle.

Once finished mixing in one container, it is good practice to transfer the mixed resin into a second container and undertake further mixing of the resin using a new mixing stick. Doing so will eliminate the risk of accidentally using unmixed resin from the bottom or sides of the container.

To help remove any trapped air, pour the resin into the mould slowly in a thin stream. Pour into a single part of the mould and allow it to flow to the rest of the cavity from there.

On areas of fine surface detail, we suggest painting an amount of the mixed resin directly onto the detailed areas ensuring that the resin is in intimate contact with the mould with no trapped air before pouring the bulk of the resin around it.

## Pot-Life / Working Time / Cure Time

Transfer the resin from the mixing pot onto the part as soon as possible to extend the working time and avoid the risk of uncontrollable rapid cure in the mixing pot.

As with all epoxies, the pot-life/working time will vary significantly depending on the ambient temperature, the starting temperature of the resin and hardener and the amount of resin mixed.

Stage at 25°C	Pot Life	Gelation	Demould Time
Time	2-3hrs	6hrs	12-24 hrs

Tool Cast Epoxy Casting Resin can be used in ambient temperatures between 15°C (59°F) and 30°C (86°F). For best results, an ambient temperature of at least 20°C (68°F) is recommended. Ensure that both resin and hardener containers are within this temperature range before use.

Curing times will depend on the size and shape of the casting and also the ambient working temperature and so will vary between 12 and 24hrs to reach a full cure.

## Full Cure / Post-Cure

As with most epoxy systems, where parts cure in normal ambient temperatures, full cure is not reached for several days. Although parts will be handleable after the listed demould time (at 25°C), full mechanical properties will take at least 14 days to develop (at 25°C). Where possible, avoid exposing the cured resin to full service rigours for at least this time.

To ensure that the cast material achieves its maximum operating temperature a ramped elevated temperature post-cure is recommended. Allow the casting to cure fully at room temperature before post curing as follows:

- 40°C for 1 hour
- 60°C for 1 hour
- 80°C for 1 hour
- 100°C for 1 hour

To prevent any distortion during the post cure cycle, the unit should be fully supported during the process. When post-curing is complete, let the unit cool down slowly to room temperature, preferably in the oven. Sudden change in temperature can cause distortion or warping.

## Mechanical Properties

The table below shows the typical uncured properties:

Property	Unit	Resin	Hardener	Combined
Material	-	Metal Filled Epoxy Resin	Formulated Amine	Epoxy
Appearance	-	Grey Liquid	Amber Liquid	Grey Liquid
Viscosity @25°C	mPa.s	32000-42000	30-50	10000-15000
Density @25°C	g/cm <sup>3</sup>	1.70-1.80	0.99 - 1.04	1.62-1.72

Cured Resin Properties:

Property	Standard	Unit	Value
Hardness 25°C	ISO 868	Shore D	85-95
Linear Shrinkage	500 x 50 x 3mm	%	< 0.05
Tensile strength	ISO 527	MPa	20 -25
Tensile Modulus	ISO 527	MPa	2000 - 2500
Elongation at break	ISO 527	%	1.0 - 1.5
Flexural strength	ISO 178	MPa	38.0 - 42.0
Flexural Modulus	ISO 178	MPa	5000 - 5500
Maximum Service Temperature	In House	°C	80

## Transport and Storage

Resin and hardener should be kept in tightly seal containers during transport and storage. Both the resin and hardener should be stored in ambient conditions of between 10°C (50°F) and 25°C (77°F).

When stored correctly, the resin and hardener will have a shelf-life of 12 months. Although it may be possible to use the resin after a longer period, a deterioration in the performance of the resin will occur, especially in relation to cure profile.

Pay particular attention to ensuring that containers are kept tightly sealed. Epoxy hardeners especially will deteriorate quickly when exposed to air.

## RoHS Compliance Statement

Easy Composites Ltd is committed to minimising the environmental impact of our operations and to complying with all applicable environmental regulations and standards.

We hereby confirm that TC80 complies with the requirements of:

**Directive 2011/65/EU of the European Parliament and of the Council (RoHS 2),**

**Directive (EU) 2015/863, amending Annex II to Directive 2011/65/EU (RoHS 3).**

These directives restrict the use of certain hazardous substances in electrical and electronic equipment.

## Disclaimer

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 Easy Composites Ltd gives no warranty; express or implied, and all products are sold upon condition that purchasers will make their own tests to determine the quality and suitability of the product for their particular application and circumstances.

Easy Composites Ltd shall be in no way responsible for the proper use and service of the product, nor for the safeguarding of personnel or property, all of which is the duty of the user. Any information or suggestions are without warranty of any kind and purchasers are solely responsible for any loss arising from the use of such information or suggestions. No information or suggestions given by us shall be deemed to be a recommendation to use any product in conflict with any existing patent rights. Before using any of our products, users should familiarise themselves with the relevant technical and safety datasheets provided by Easy Composites Ltd.

TC80 is a trademark of Easy Composites Ltd.

## Leaders in materials, equipment and training for advanced composites

**Easy Composites Ltd**  
Unit 39, Park Hall Business Village  
Stoke-on-Trent, ST3 5XA  
United Kingdom

**Easy Composites Ltd**  
Beneluxbaan 16  
Rijen, 5121 DC  
Netherlands

**W:** [www.easycomposites.com](http://www.easycomposites.com)  
**E:** [sales@easycomposites.com](mailto:sales@easycomposites.com)  
**T:** +44 (0) 1782 454499

Version 2.2  
Revised 22/01/2026

Page 2 of 2