



# High quality epoxy tooling board

## EP678

Trelleborg EP678 is a medium temperature, low density syntactic epoxy tooling board designed for the manufacture of accurate and stable master models and molds.

### Applications:

EP678 can be used for the following:

- Master models.
- Lay-up tools for low and medium temperature curing epoxy prepregs.



### Features & Benefits:

EP678 is a high quality tooling board offering a lower cost solution.

- **Excellent dimensional stability**  
Maintains shape at elevated temperatures.
- **Low coefficient of thermal expansion**  
Consistent, predictable performance.
- **Inert surface**  
Chemically compatible with tooling prepregs.
- **Direct to part manufacturing**  
Suitable for use up to 135° C.

TECHNICAL PROPERTIES		
PROPERTY	TYPICAL DATA	TEST METHOD
Color	Blue	
Density	770 kg/m <sup>3</sup>	
Shore Hardness	75 D	
Uniaxial Compressive Stress	48 MPa	BS EN ISO 604
HDT	135 °C	BS 2782
Glass Transition Temperature	126 °C	BS EN ISO 11359-2
Coefficient of Thermal Expansion	42 x 10 <sup>-6</sup> / °C	BS EN ISO 11359-2
Flexural Strength	25 MPa	BS EN ISO 178
Flexural Modulus	2,343 MPa	BS EN ISO 178

## Product Sizes

EP678 is available in a standard board size of 24" x 60" at the following thickness: 2", 3", 4" and 6".

	Length	Width	Thickness
Type 1	24" / 610mm	60" / 1,524mm	2" / 50.8mm
Type 2	24" / 610mm	60" / 1,524mm	3" / 76.2mm
Type 3	24" / 610mm	60" / 1,524mm	4" / 101.6mm
Type 4	24" / 610mm	60" / 1,524mm	6" / 152.4mm

## Storage

The board should be stored in a dry warehouse.

## Health & Safety

Eye protection and a face mask should be worn when working with Trelleborg EP678. Please refer to the Trelleborg MSDS.

## Cutting Guidelines

EP678 can be sawn using carbide or diamond coated saw blades or cutting wheels.

## Bonding Guidelines

Large patterns can be constructed from boards using the appropriately selected epoxy adhesive system. Trelleborg adhesive system 551A/B is recommended. The adhesive system must offer adequate pot life and be capable of meeting the mechanical and thermal properties of the tooling board.

To ensure good bonding:

- The adhesive should be applied to both surfaces (dust free) using a notched spatula.
- The surfaces should be brought together and a uniform clamping pressure applied by either mechanical or vacuum means.
- Any surplus adhesive that extrudes from bond lines after curing can be machined off.
- Bonded joints should be left to cure for 24 hours at ambient temperature for best results.

The recommended adhesive has matched characteristics to the EP678 material.

## Machining Advisory

In order to avoid board distortion it is recommended that stock removal should be taken equally from opposing faces. Where this is not possible, then the board should be supported by and bonded to additional layers.

To minimize distortion when machining large flat boards, it is advisable to rough cut one face, invert the board and machine the rear face, re-invert and complete the machining. The board can be finished by the use of successively finer grades of wet and dry abrasive paper.

## Machining Guidelines

The machining information provided is for guidance purposes only. It is advised that individual users should determine the appropriate speeds, feed, cutters and depths for their own specific application.

TYPICAL PROPERTIES	
Roughing Speed	5,000 rpm
Roughing Feed	9 m/min
Cutter Type	40 mm Ball Nose Cutter
Step Down	10 mm
Step Over	15 mm
Finishing Speed	7,500 rpm
Finishing Feed	9 m/min

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## Contact Us

Trelleborg's Applied Technologies division is an industry expert in delivering innovative and reliable solutions that maximize performance for our customers. Our vast range of specialized, customizable materials ensure peace of mind at every stage of your project. With reliable and efficient project management and manufacturing we endeavor to take performance to new levels by achieving your goals safely, on time and within scope.



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