



**PACE TECHNOLOGIES**  
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# Compression Mounting



## Phenolic, Epoxy, Acrylic and Diallyl Phthalate Resins

Compression mounting resins are a quick and easy way to mount a metallographic specimen. Both pressure and temperature are required for compression mounting with mounting times typically requiring several minutes at the appropriate resin mounting temperature. There are two types of compression mounting compounds: thermosets and thermoplastics. Thermosets are the most common and are non-reversible resins (i.e. cannot be remelted). Thermoplastics on the other hand can be remelted. The phenolics, diallyl phthalates, and the conductive mounting resins are thermosets, whereas the TRANSACRYLIC™ acrylic powder is a thermoplastic.



Resin	Phenolic	Acrylic	Epoxy	Diallyl Phthalate
Form	Granular	Powder	Granular	Granular
Specific gravity (gm/cm <sup>3</sup> )	1.4	0.95	1.75-2.05	1.7-1.9
Colors	Black, Red, Green	Clear	Black	Blue
Shrinkage (compression) (in/in)	0.006		0.001-0.003	0.001-0.003
Coefficient of Linear Thermal Expansion (in/in/°C 10 <sup>-6</sup> )	50		28	19
Chemical resistance	Glycol, petrochemicals, solvents, some acids and bases	Alcohol, dilute acids & alkalis, and oxidizers	Solvents, acids, alkalis	Solvents, acids, alkalis
Molding temperature	165°-185°C (330°-360°F)	200°C (425°F)	180°-200°C (350°-425°F)	180°-200°C (350°-350°F)
Molding pressure	17-28 MPa (2500-4000 psi)	24-41 MPa (3500-6000 psi)	17-28 MPa (2500-4000 psi)	17-28 MPa (2500-4000 psi)
Hardness		Rockwell M63	Barcol 72	
Curing time (1/2" mount at temperature and pressure)	5 minutes	10 minutes	5 minutes	5 minutes



METAPRESS



FINOPRESS



DIGIPRESS

### Phenolic Compression Mounting Resin Powder

Description	Quantity	Part Number
Phenolic powder - Black (wood flour)	5 lbs (2.3 kg)	CM-2001B-5
	25 lbs (11.4 kg)	CM-2001B-25
Phenolic powder - Red (wood flour)	5 lbs (2.3 kg)	CM-2001R-5
	25 lbs (11.4 kg)	CM-2001R-25
Phenolic powder - Green (wood flour)	5 lbs (2.3 kg)	CM-2001G-5
	25 lbs (11.4 kg)	CM-2001G-25

### Acrylic Compression Mounting Resin Powder

Description	Quantity	Part Number
Acrylic Resin powder (transparent)	5 lbs (2.3 kg)	AR-2101A-5
Acrylic Resin powder (transparent)	25 lbs (11.4 kg)	AR-2101A-25

### EPOCOMP™ Epoxy (Glass Reinforced) Compression Mounting Resin Powder

Description	Quantity	Part Number
EPOCOMP™ Epoxy Compression Resin Powder	5 lbs (2.3 kg)	EP-2201A-5
EPOCOMP™ Epoxy Compression Resin Powder	25 lbs (11.4 kg)	EP-2201A-25
EPOCOMP™ FINE Epoxy Compression Resin Powder	5 lbs (2.3 kg)	EPF-2201A-5

### Diallyl Phthalate Compression Mounting Resin Powder

Description	Quantity	Part Number
Diallyl Phthalate Compression Mounting Powder (short-glass filled)	5 lbs (2.3 kg)	DY-2301A-5
Diallyl Phthalate Compression Mounting Powder (short-glass filled)	25 lbs (11.4 kg)	DY-2301A-25

### CONDUCTO-CU™ Conductive (copper) Compression Mounting Powder

Description	Quantity	Part Number
Conductive Compression Mounting Powder (copper filled)	1 lb	CONDUCTO-CU-1
Conductive Compression Mounting Powder (copper filled)	5 lb	CONDUCTO-CU-5

### CONDUCTOMOUNT™ Conductive (graphite) Compression Mounting Powder

Description	Quantity	Part Number
Conductive Compression Mounting Powder (graphite filled)	1 lb	CONDUCTO-1
Conductive Compression Mounting Powder (graphite filled)	5 lb	CONDUCTO-5

### Miscellaneous Mounting Accessories

Description	Quantity	Part Number
2.6 oz scoop	2.6 oz	MS-1000-01
Mold release	8 oz (0.24l)	MR-1000-08
	16 oz (0.47l)	MR-1000-16