

LECO Mounting Presses and Cold-Mounting Systems Specification Sheet

Ordering Information for Cold-Mounting Acrylics, Epoxies, and Polyesters

LECOSET™ 100 (Acrylic)

Mix 1 part liquid with 2 parts powder; 10 to 12 minutes air curing for an opaque mount (use LECOMAT™ Pressure Vessel for transparent mount).

Kits (All kits include measuring scoop)

Small (makes >39 mounts)	812-129-HAZ	1 pt. (473 ml) liquid/2.2 lb. (1000 g) powder
Medium (makes >79 mounts)	812-130-HAZ	1 qt. (0.95 l) liquid/4.4 lb. (2000 g) powder
Extra Large (makes >238 mounts)	812-132-HAZ	3 qt. (2.85 l) liquid/13.2 lb. (6000 g) powder

Basic Acrylic Kit

Mix 1 part liquid with 2 parts powder; 8 to 10 minutes air curing for an opaque pink mount.

Kit (Includes measuring scoop)

Small (makes >10 mounts)	811-201-HAZ	1 pt. (473 ml) liquid/1 lb. (454 g) powder
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LECOSET™ 7007

Mix liquid with powder; 10 to 12 minutes air curing for an opaque mount.

Kits

Small (makes >4 mounts)	813-001-HAZ	(100 g powder/80 ml liquid)
Medium (makes >40 mounts)	813-091-HAZ	(1000 g powder/500 ml liquid)
Large (makes >80 mounts)	813-106-HAZ	(2000 g powder/1000 ml liquid)

For a comprehensive listing of all products offered in this category, see LECO's Met Supplies Catalog, form no. 203-826

LC Epoxy (Long Cure)

Mix 14 g hardener with 100 g resin; 4 to 8 hours air curing/45 minutes working time for a transparent mount; 175°F (79°C) peak cure temperature.

Kits

Small (makes >27 mounts)	812-522-HAZ	4.7 oz. (133 g) hardener/2 lb. (907 g) resin
Large (makes >110 mounts)	812-523-HAZ	1 lb. 2 oz. (508 g) hardener/8 lb. (3629 g) resin

QC Epoxy (Quick Cure)

Mix 20 g hardener with 100 g resin; 30 to 60 minutes air curing/15 minutes working time for a transparent mount; 200°F (93°C) peak cure temperature.

Kits

Small (makes >27 mounts)	812-524-HAZ	6.4 oz. (182 g) hardener/2 lb. (907 g) resin
Large (makes >110 mounts)	812-525-HAZ	1 lb. 10 oz. (737 g) hardener/8 lb. (3629 g) resin

LECOSET™ 7000 (Polyester)

Mix 2 parts liquid #1 with 1 part liquid #2 and 2 parts powder; 5 to 7 minutes air curing for an opaque mount.

Kits

Small (makes >5 mounts)	813-004-HAZ	(120 g powder/80 ml liquid #1/40 ml liquid #2)
Medium (makes >31 mounts)	813-005-HAZ	(750 g powder/500 ml liquid #1/250 ml liquid #2)
Large (makes >63 mounts)	813-056-HAZ	(1500 g powder/1000 ml liquid #1/500 ml liquid #2)
Extra Large (makes >254 mounts)	813-089-HAZ	(6000 g powder/4000 ml liquid #1/2000 ml liquid #2)

Castolite (Polyester)

Mix 0.1 oz. (3 ml) hardener with 6 oz. (178 ml) resin; 4 to 6 hours air curing for a transparent mount; 190°F (88°C) peak cure temperature.

Kits

Small (makes >9 mounts)	811-186-HAZ	0.25 oz. (7.4 ml) hardener/1 lb. (454 g) resin
Medium (makes >19 mounts)	811-187-HAZ	0.40 oz. (11.8 ml) hardener/2 lb. (908 g) resin
Large (makes >85 mounts)	811-188-HAZ	2.0 oz. (60 ml) hardener/9 lb. (4083 g) resin

Accessories for Cold Mounts

810-485	Spring steel sample supports, 100/pkg	810-990-012	12 green plastic mold cups, 1 in. diameter
810-815-310	Plastic sample clips, 100/pkg	810-991-012	12 green plastic mold cups, 1.25 in. diameter
811-269-HAZ	Release agent (paste wax), 1 qt. (948 ml)	810-992-012	12 green plastic mold cups, 1.50 in. diameter
811-275	Graduated paper mixing cup, 5 oz. (148 ml), 100/pkg	813-018-012	12 white plastic mold cups, 25 mm diameter
811-279	Graduated paper mixing cup, 16 oz. (474 ml), 100/pkg	813-019-012	12 white plastic mold cups, 30 mm diameter
813-025	Mixing kit includes: 20 paper cups; 20 wooden spatulas; 1 spoon; 12 mold cups—1-in. diameter; 12 mold cups—1.25-in. diameter	813-020-012	12 white plastic mold cups, 40 mm diameter

813-006 LECOMAT™ Pressure Vessel Specifications

- Dimensions: 10 in. H x 14 in. W x 13 in. D (25.4 x 35.6 x 33 cm)
- Weight 7 lb. (3178 g)
- Will hold up to ten 1.5 in. mold cups



Mounting Presses Specifications

	PR-25	PR-32	PR4X
Available Mold Sizes	1.00, 1.25, 1.50 in.	1.25, 1.50, 2.0 in.*	1.25, 1.50 in., 30, 40, 50 mm
Power Requirements	115V, 60 Hz or 230V, 50 Hz; single phase	115V, 60 Hz or 230V, 50 Hz; single phase	115V, 60 Hz or 230V, 50 Hz
Maximum Current Draw	10.5 amps @ 115V	11 amps @ 115V	15 amps @ 115V; 10 amps @230V
Other Utilities Required	oil-less air at 85 psi, (5.86 bars) continuously flowing water & drain	oil-less air at 85 psi, (5.86 bars) continuously flowing water & drain	continuously flowing water & drain (no air required)
Dimensions	25 in. H x 17 in. W x 15 in. D (63.5 x 43 x 38 cm)	25 in. H x 17 in. W x 18 in. D (63.5 x 43 x 46 cm)	21.5 in. H x 8.5 in. W x 20 in. D (8.46 x 3.35 x 7.87 cm)

*PR-32 will produce two mounts simultaneously—recommended sizes for dual mounts are 1.25 in. and 1.50 in. only.

Ordering Information for Presses, Accessories, and Consumables

814-200 Series

115 volt PR-25 with **1.00, 1.25, 1.50** in. molds
Spare mold assemblies including heater/cooler

814-200-**100**, 814-200-**125**, 814-200-**150**
807-927-**100**, 807-927-**125**, 807-927-**150**

814-300 Series

230 volt PR-25 with **1.00, 1.25, 1.50** in. molds
Spare mold assemblies including heater/cooler

814-300-**100**, 814-300-**125**, 814-300-**150**
807-928-**100**, 807-928-**125**, 807-928-**150**

805-600 Series

115 volt PR-32 with **1.25, 1.50, 2.00** in. molds
Spare mold assemblies including heater/cooler

805-600-**125**, 805-600-**150**, 805-600-**200**
807-620-**125**, 807-620-**150**, 807-620-**200**

805-700 Series

230 volt PR-32 with **1.25, 1.50, 2.00** in. molds
Spare mold assemblies including heater/cooler

805-700-**125**, 805-700-**150**, 805-700-**200**
807-661-**125**, 807-661-**150**, 807-661-**200**

PR4X Series

PR4X Press (Master Unit, 115V)	PR40AD
PR4X Press (Master with 1 Auxiliary Unit, 115V)	PR41AD
PR4X Press (Master with 2 Auxiliary Units, 115V)	PR42AD
PR4X Press (Master with 3 Auxiliary Units, 115V)	PR43AD
PR4X Press (Master Unit, 230V)	PR40AI
PR4X Press (Master with 1 Auxiliary Unit, 230V)	PR41AI
PR4X Press (Master with 2 Auxiliary Units, 230V)	PR42AI
PR4X Press (Master with 3 Auxiliary Units, 230V)	PR43AI

Mold Assemblies, PR4X Series

NOTE: A mold assembly must be chosen for each unit, including the master unit and any auxiliary units.

1.25 in. Mold Assembly; provides dual-mount capability	809-550-125
1.50 in. Mold Assembly; provides dual-mount capability	809-550-150
50 mm Mold Assembly	808-980-50M

Consumables and Accessories

Silicone mold release, 6 oz. (170 g) spray	811-271-HAZ	Blue Glass-filled diallyl phthalate powder, 5 lb. (2.27 kg)	811-137
Wax mold release, 2 oz. (57 g) powder	811-272	Copper-filled diallyl phthalate powder, 5 lb. (2.27 kg)	811-139
Wax mold release, 16 oz. (454 g) spray	811-273-HAZ	Green Glass-filled epoxy powder, 5 lb. (2.27 kg)	811-141
Black mineral epoxy*, 5 lb. (2.27 kg)	811-645	Mineral-filled black epoxy powder, 5 lb. (2.27 kg)	811-145
Black bakelite powder, 5 lb. (2.27 kg)	811-111	Ultra-fine mineral-filled black epoxy powder 5 lb. (2.27 kg)	811-145-120
Black bakelite powder, 20 lb. (9.07 kg)	812-122	Electric engraver	804-120
Red bakelite powder, 5 lb. (2.27 kg)	811-118	Replacement carbide points for engraver	804-099
Transparent lucite powder, 5 lb. (2.27 kg)	811-133		
Blue Mineral-filled diallyl phthalate powder, 5 lb. (2.27 kg)	811-135		

*Use with PR4X mounting press

Specifications and part numbers may change.
Consult LECO for latest information.

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