

PREMIUM RESIN TECH.

3605 – 32nd Street., Port Huron, MI 48060
(586) 530-3633 RandDResin.com

HIGH TEMPERATURE LAMINATING SYSTEM

(ALUMINUM)

RDR-2250 / RDH-9234

Resin / Hardener

MIXING RATIO: 100 : 15 PBW

This high temperature laminating system cures at room temperature with post cure. It is extremely tough, has good dimensional stability with good heat distortion for tools requiring elevated temperatures.

TYPICAL PHYSICAL PROPERTIES

Pot Life @ 72°F (200g mass)	165 minutes
Ratio by Weight	100 pbw to 15pbw
Ratio by Volume	5.5 to 1
Flexural Strength @ 72°F	38,400
Flexural Strength @ 350°F	5,600
Heat Distortion	320°F
Hardness, Shore "D" @ 72°F	85
Hardness, Shore "D" @ 300°F	78
Density:	
Resin	12.5
Hardener	8.35
Mixed	10.4
Specific Gravity:	
Resin	1.50
Hardener	1.00
Mixed	1.25
Shelf Life Resin / Hardener	1 year

Upon Completion, the tool should be allowed to cure at ambient temperature for 24 hrs. At that point, apply an oven cure, cycle should be 50 degrees per hour (*tool temperature, not air temperature*). Not more than 5 degrees per min.

1-Hour 100F, 1-Hour 150F, 1-Hour 200F, 1-Hour 250F, 2-Hour 300F, Back down the same

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