

# PREMIUM RESIN TECH.

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## ROOM TEMPERATURE R.T.M. SYSTEM

### RDR-3121 / RDH-9386, RDH-9386-99

Resin / Hardener(s)

**MIXING RATIO: 100 : 33 PBW**

**RDR-3121** is an unfilled clear epoxy resin system with a long pot life. This resin is tough, strong, impact resistant resin with good heat distortion and chemical resistance. It has excellent wetting quality, flow and air release for R.T.M. and injection resin system.

### TYPICAL PHYSICAL PROPERTIES

	<u>RDH-9386</u>	<u>RDH-9386-99</u>
Pot Life @ 72°F (200g mass)	35 minutes	60 minutes
Ratio by Weight	100 pbw to 33 pbw	100 pbw to 33 pbw
Tensile Strength @ 25°C	12,500	12,500
Flexural Strength @ 25°C	40,900	40,900
Flexural Modulus @ 25°C	1.98	1.98
Heat Deflection	300°F	300°F
Hardness, Shore "D" @ 72°F	85	85
Density:		
Resin	9.7	9.7
Hardener	7.9	7.9
Mixed	9.1	9.1
Viscosity, mixed, cps	1500	1500
Shelf Life Resin / Hardener	1 year	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**

*The information herein is accurate to the best of our knowledge. Premium Resin Tech., assumes no liability whatsoever for the accuracy or completeness of the information contained herein. Final determination of suitability of any material is the sole responsibility of the user. All material may present unknown hazards and should be used with caution. Although certain hazards are described herein, we cannot guarantee that these are the only hazards which exist.*