

PREMIUM RESIN TECH.

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HIGH TEMPERATURE CLEAR LAMINATING (CLEAR AND RIGID)

RDR-3250 / RDH-9234

Resin / Hardener

MIXING RATIO: 100 : 25 PBW

RDR-3250 is an unfilled clear epoxy room temperature curing laminating system used in high temperature and room temperature applications. This system is tough, strong, has good heat distortion, chemical resistance and excellent adhesive qualities. As with most high temperature systems, it will achieve a demoldable state overnight @ ambient temperature. In some instances, tools may be used without post cure. However, for most uses at elevated temperature, post cure is recommended.

TYPICAL PHYSICAL PROPERTIES

Pot Life @ 72°F (200g mass)	2 hrs.
Ratio by Weight	100 pbw to 25 pbw
Ratio by Volume	3.4 to 1
Cure Time:	24 Hrs.
Flexural Strength @ 72°F	38,500
Flexural Modulus	1.85 x 10 ⁶
Compressive Strength	55,000
Heat Distortion	325°F
Hardness, Shore "D" @ 72°F	85
Hardness, Shore "D" @ 300°F	78
Density:	
Resin	9.6
Hardener	7.8
Mixed	9.25
Specific Gravity:	
Resin	1.16
Hardener	.94
Mixed	1.11
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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