

PREMIUM RESIN TECH.

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

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

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.