

# PREMIUM RESIN TECH.

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## HIGH TEMPERATURE EPOXY SYSTEM

### RDR-3350 / RDH-9234

Resin / Hardener

**MIXING RATIO: 100 : 25 PBW**

**RDR-3350** high temperature laminating system cures at room temperature, but requires post cure to obtain optimal physical properties. **RDR-3350** is extremely tough, excellent handling, has good dimensional stability with excellent heat distortion. **RDR-3350** is especially suited for tools requiring elevated temperatures. To reach ultimate physical properties, post cure is necessary. Post cure varies depending on the temperature use of the tool. **RDR-3350** maximum temperature is 500 F.

#### TYPICAL PHYSICAL PROPERTIES

|  |                           |
|--|---------------------------|
| Color                                    | Clear / Black             |
| Pot Life @ 72°F (200g mass)              | 150 minutes               |
| Ratio by Weight                          | 100 pbw to 25 pbw         |
| Ratio by Volume                          | 4 to 1                    |
| Flexural Strength @ 72°F                 | 55,000                    |
| Flexural Strength @ 350°F                | 36,000                    |
| Flexural Modulus @ 72°F                  | 6.25 x 10 <sup>6</sup>    |
| Flexural Modulus @ 350°F                 | 4.10 x 10 <sup>6</sup>    |
| Heat Distortion                          | 450°F                     |
| Specific Gravity, Resin                  | 1.18                      |
| Co-Efficient of Linear Thermal Expansion | 3.4 x 10 <sup>6</sup> /°C |
| Hardness, Shore "D" @ 72°F               | 85 - 90                   |
| Hardness, Shore "D" @ 350°F              | 84 - 86                   |
| 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, 1-Hour 300F, 1-Hour 350F, 2-Hours 400F, Then 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.*