

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 ⁶
Flexural Modulus @ 350°F	4.10 x 10 ⁶
Heat Distortion	450°F
Specific Gravity, Resin	1.18
Co-Efficient of Linear Thermal Expansion	3.4 x 10 ⁶ /°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

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