



**CROSSLINK TECHNOLOGY INC.**  
FORMULATED EPOXIES, URETHANES • CUSTOM CAST ELECTRICAL PARTS



**“Our strength is in our formulations”**

**TECHNICAL BULLETIN:**

**CLR 1396 / CLH 6930**

**PRODUCT DESCRIPTION:** THIS HIGH PERFORMANCE SEALANT WAS SPECIFICALLY DEVELOPED FOR APPLICATION TO BUTT WELD JOINTS ON AUTOMOTIVE WHEELS, TO INSURE AGAINST THE LEAKAGE OF AIR THROUGH POROUS CURFACES AND PIN HOLES. THIS TWO COMPONENT, 100% SOLIDS, ROOM TEMPERATURE CURE ADHESIVE BONDS TO A WIDE VARIETY OF SURFACES. THE PRODUCT CAN BE APPLIED EASELY IN MASS PRODUCTION ENVIRONMENTS.

**SALES SPECIFICATION:**

**CLR 1396**

**CLH 6930**

COLOUR	BLACK	AMBER
VISCOSITY (NOTE 1)	25,000-50,000 cps	100-300 cps
SPECIFIC GRAVITY	1.6-1.7 gm/cm <sup>3</sup>	1.0 gm/cm <sup>3</sup>
SHELF LIFE	6 MONTHS	6 MONTHS

**HANDLING:** (NOTES 1, 2 & 5)

1. MIX RATIO BY WEIGHT (A:B)(NOTE 2)	100:15(100:25 BY VOL.)
2. VISCOSITY (NOTE 4)	12,000 – 20,000 cps
3. POT LIFE OF 200 gm MASS (NOTE 4)	40 MINUTES
4. GEL TIME (NOTE 4)	60 MINUTES

**CURE SCHEDULE (NOTE 3):**

24 HOURS @ R.T. OR 4 HOURS @ 60 °C

**CURED PROPERTIES:** (NOT INTENDED FOR PREPARATION OF SPECIFICATIONS)

COLOUR	BLACK
DENSITY	1.5 gm/cm <sup>3</sup>
SHORE HARDNESS	85D
LINEAR SHRINKAGE	0.003 in/in
TENSILE STRENGTH	7,000 psi
ELONGATION	5.0%
GUIDE TO OPERATING TEMPERATURE	125 °C
THERMAL EXPANSION COEFFICIENT (in/in/ °C X 10 <sup>6</sup> )	40
MOISTURE ABSORPTION (24 hr IMMERSION)	0.1%

**NOTES:**

- 1) If a filled resin, settling may occur during transportation or storage. Fillers must be remixed before use.
- 2) The mix ratio must be within  $\pm 2\%$  of the stated value and thorough mixing is required to avoid degraded properties.
- 3) Other cure schedules may yield satisfactory results however; these should be determined by the customer for his given application.
- 4) Unless otherwise specified, all measurements are taken at 22<sup>o</sup>C.
- 5) These products may trigger allergic reactions in some individuals. Prevent contact with skin; wash with plenty of soap and water if contact occurs and **Read the Material Safety Data Sheet** before using the materials. **Do Not Breathe Vapours** provide good ventilation and exercise good housekeeping at the work area.
- 6) If indicated, the values under “**Electrical Characteristics**” may be based on supplier data for products with similar compositions. They are provided only as a guide and the recipient must test each material to determine its suitability for the intended application.
- 7) If stated, the “**Guide to Operating Temperature**” is based on our experience with materials of similar chemistry and/or thermal index. The ultimate suitability of a product for a particular operating temperature is application dependent and **may change according to the demands placed upon it in service.**

**IMPORTANT**

**THE INFORMATION IN THIS BULLETIN IS BASED ON DATA OBTAINED BY OUR OWN RESEARCH AND IS CONSIDERED ACCURATE. ALL INFORMATION SUPPLIED BY CROSSLINK TECHNOLOGY INC., IS FURNISHED UPON THE EXPRESS CONDITION THAT THE PERSON RECEIVING THE PRODUCT SHALL MAKE HIS OWN ASSESSMENTS TO DETERMINE IT'S SUITABILITY FOR HIS PARTICULAR PURPOSE. NO WARRANTY IS EXPRESSED OR IMPLIED REGARDING SUCH INFORMATION, OR THE RESULTS TO BE OBTAINED FROM THE USE THEREOF; THAT ANY PRODUCT SHALL BE MERCHANTIBLE OR FIT FOR ANY PARTICULAR PURPOSE; OR THAT THE USE OF SUCH OTHER INFORMATION OR PRODUCT WILL NOT INFRINGE ANY PATENT.**

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