



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



“Our strength is in our formulations”

TECHNICAL BULLETIN:

CLR 1635 / CLH 6027

DESCRIPTION:

A GENERAL PURPOSE, ROOM TEMPERATURE CURE, WHITE EPOXY SURFACE COAT.

HANDLING:

<u>RESIN Part A</u>	<u>HARDENER Part B</u>	<u>MIX RATIO By Weight</u>	<u>VISCOSITY cps</u>	<u>POT LIFE 200 gm Mass</u>	<u>DEMOULD</u>
CLR 1635	CLH 6027	100 : 15	LIGHT PASTE	15 Minutes	16 Hrs @ RT

CURE SCHEDULE:

SURFACE OPERATING TEMP.

24 Hrs @ RT (25 ^o C)	-----
12 Hrs @ RT + 12 Hrs @ 60 ^o C (For optimum results)	-----

CURED PROPERTIES:

<u>SHRINKAGE in/in</u>	<u>HARDNESS Shore D</u>	<u>TENSILE psi.</u>	<u>COMPRESSIVE psi</u>	<u>FLEXULAR psi</u>	<u>ELONGATION %</u>
-----	86	6,500	15,000	10,000	3.0

PACKAGING

Pre-weighed Units

20 Kg Total
 4 Kg Total

SPECIFIC GRAVITY

<u>gm/cm³</u>	<u>lb/in³</u>
1.4	0.051
17,857 cm ³	1,090 in ³
3,571 cm ³	218 in ³

MIXING:

- Stir each component individually prior to mixing together.
- Mix together in the recommended ratio and stir for 4 – 5 minutes scraping the sides of the container.

CURING:

- During post cure, if the tool is to be removed from the model, a support may be necessary depending on the design of the tool.
- For optimum dimensional reproduction, a staged post cure is recommended.

Continued....

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 22⁰C.
- 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 THEIR OWN ASSESSMENT TO DETERMINE ITS SUITABILITY FOR THEIR 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 MERCANTABLE 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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