



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



“Our strength is in our formulations”

TECHNICAL BULLETIN:

CLR 1299 / CLH 6140

DESCRIPTION: AN ALUMINUM FILLED, MACHINABLE, ROOM TEMPERATURE GELLING, CASTING SYSTEM. THE PRODUCT GIVES EXCELLENT SURFACE REPRODUCTION AND HIGH STRENGTH. THE LONG POT-LIFE AND LOW SHRINKAGE PERMIT CASTINGS UP TO 4 INCHES IN DEPTH.

HANDLING: (NOTES 1, 2 & 5)

<u>RESIN</u> <u>Part A</u>	<u>HARDENER</u> <u>Part B</u>	<u>MIX RATIO</u> <u>By Weight</u>	<u>VISCOSITY</u> <u>CPS</u>	<u>POT LIFE</u> <u>200 gm</u>	<u>DEMOULD</u> <u>_____</u>
CLR 1299	CLH 6140	100:15	30000 - 60000	2 - 3 HOURS	16 HOURS

CURE SCHEDULE:

6 HRS @ 60°C + 2 HRS @ 100°C
 24 -48 HRS @ R.T. OR 2 HRS @ 60°C

OPERATING TEMPERATURE:

100°C
 60°C

CURED PROPERTIES:

(not intended for preparation of specifications)

<u>SHRINKAGE</u> <u>In/In</u>	<u>HARDNESS</u> <u>Shore D</u>	<u>TENSILE</u> <u>PSI</u>	<u>COMPRESSIVE</u> <u>PSI</u>	<u>FLEXURAL</u> <u>PSI</u>	<u>ELONGATION</u> <u>%</u>
0.002	87	6,000	15,000	13,000	2.5

PACKAGING

Preweighed Units:

SPECIFIC
gm/cm³
1.6

GRAVITY
lb/in³
0.058

25 KG TOTAL

15,625 cm³

953 in³

5 KG TOTAL

3,125 cm³

191 in³

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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