



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



“Our strength is in our formulations”

TECHNICAL BULLETIN: CLR 1299 / CLH 6330

DESCRIPTION: ALUMINUM FILLED, LOW VISCOSITY, ROOM TEMPERATURE, GELLING CASTING SYSTEM. EXCELLENT SURFACE REPRODUCTION. HIGH STRENGTH. OFTEN USED WITH ALUMINUM SHOT FOR LARGE MASS. MAY BE CAST UP TO 2.0 INCHES DEPTH.

HANDLING:

<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>200gms</u>	<u>DEMOULD</u>
CLR 1299	CLH 6330	100:10	20,000	1.0 HR	12HRS @ R.T.

CURE SCHEDULE:

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

OPERATING TEMPERATURE:

40 °C
 100 °C

CURED PROPERTIES:

<u>SHRINKAGE</u> <u>in/in</u>	<u>HARDNESS</u> <u>Shore D</u>	<u>TENSILE</u> <u>psi</u>	<u>COMPRESSIVE</u> <u>YIELD psi</u>	<u>FLEXURAL</u> <u>psi</u>	<u>ELONGATION</u> <u>%</u>
.003	87	6,000	14,300	13,500	2.2

PACKAGING
Prewieghed Units

<u>SPECIFIC GRAVITY</u>	
<u>gm/cm³</u>	<u>lb/in³</u>
1.6	0.058

25 Kg Total	-->	15,625 cm ³	953 in ³
5 Kg Total	-->	3,125 cm ³	191 in ³

MIXING:

- Stir each component individually prior to mixing together.
- Mix together in 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 needed depending on the design of the tool.

- For optimum dimensional reproduction, a staged post cure is recommended.

**Typical properties shown are in Laminate Form

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 22^oC.
- 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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