



“Our strength is in our formulations”

TECHNICAL BULLETIN:

CLR 1299/XHD 1303

DESCRIPTION: A LOW VISCOSITY, ALUMINUM FILLED, ROOM TEMPERATURE GELLING CASTING SYSTEM. THE PRODUCT HAS EXCELLENT SURFACE REPRODUCTION AND HIGH STRENGTH. THIS SYSTEM IS RECOMMENDED FOR USE WITH ALUMINUM SHOT FOR LARGE MASS CASTING. IT MAY BE CAST UP TO 2.0” 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>16 HRS @ RT</u>
CLR 1299	XHD 1303	100:15	15,000	3.0 HRS.	16 HRS @ RT

CURE SCHEDULE: (NOTE 3)

OPERATING TEMPERATURE:

1) Standard Cure:

2 – 4 DAYS @ R.T.

2) Optimum Cure:

16 HRS @ R.T. + 4 HRS @ 60 °C + 2 HRS @ 100 °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>PSI</u>	<u>FLEXURAL</u> <u>PSI</u>	<u>ELONGATION</u> <u>%</u>
0.001*	85	7000*	13,500	9,000*	3.5

PACKAGING
Prewriteghed Units

SPECIFIC GRAVITY
gm/cm³ **lb/in³**

23.5 Kg Total	-->	1.6	0.058
4.7 Kg Total	-->	14,687 cm ³	893 in ³
		2,937 cm ³	179 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

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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