Our strength is in our formulations

TECHNICAL BULLETIN: CLR 1299 / XHD 1326

PRODUCT DESCRIPTION:
AN ALUMINUM FILLED, HIGH OPERATING TEMPERATURE, CASTING SYSTEM. DUE TO ITS LOW EXOTHERM AND LONG POT LIFE, THE PRODUCT IS SUITABLE FOR LARGE CASTINGS. MATERIAL MUST BE POST CURED AS SPECIFIED, AND CASTING MUST BE SUPPORTED DURING POST CURE.

SALES SPECIFICATIONS: CLR 1299 XHD 1326
COLOR GREY AMBER
VISCOSITY (NOTE 1, NOTE 4) 12,000 - 20,000 cps @ 50 °C 1,200 - 1,800 cps
SPECIFIC GRAVITY 1.73 ± 0.03 gm/cm³ 0.96 ± 0.02 gm/cm³
SHELF LIFE 12 MONTHS 12 MONTHS

HANDLING:
MIX RATIO BY WEIGHT (A:B) (NOTE 2) 100:14.0
MIXED VISCOSITY (NOTE 4) 30,000 cps @ 22 ºC
POT LIFE OF 200 gm. mass (NOTE 4) 1 Hrs. @ 22 ºC

CURE SCHEDULE (NOTE 3):
RECOMMENDED CURE SCHEDULE: 16 Hrs. @ 22 ºC + 2 Hrs. @ 125 ºC
ALTERNATE CURE SCHEDULE: 2 Hrs. @ 80 ºC
OPTIONAL POSTCURE 2 Hrs. @ 150 ºC

CURED PROPERTIES: (NOT INTENDED FOR PREPARATION OF SPECIFICATIONS)
COLOUR GREY
DENSITY (gm/cm³) 1.60
SHORE HARDNESS 86D
LINEAR SHRINKAGE (in/in) (ASTM D 2566) 0.0040
TENSILE STRENGTH (psi) (ASTM D 638) 7,000
TENSILE ELONGATION (%) (ASTM D 638) 3.5
FLEXURAL STRENGTH (psi) 10,000
COMPRESSIVE STRENGTH (psi) 15,000

6380 Viscount Road, Mississauga, Ontario, Canada L4V 1H3
Phone: 1-800-563-3769, (905) 673-0510, Fax: (905) 673-0519
Web site: www.crosslinktech.com, E-mail: info@crosslinktech.com
ELECTRICAL PROPERTIES:

NOTES
Note 1 If a filled resin, setting may occur during transportation or storage. Fillers must be remixed before use.

Note 2 Mix ratio must be within ± 2% of the stated amount and thorough mixing is required to avoid degraded final properties.

Note 3 Other cure schedules may give satisfactory results, however, these should be determined by the customer for their given circumstances.

Note 4 All measurements taken at 22°C unless otherwise specified.

Note 5 These products may trigger allergic responses in some individuals. Prevent contact with skin, wash with plenty of soap and water immediately if contact occurs. Do not breathe vapours, provide good ventilation and exercise good housekeeping at work area. Read the Material Safety Data Sheet and observe.

Note 6 The “Guide to Operating Temperature” is based on our experience with materials of similar chemistry and/or thermal index. The ultimate suitability of this product for a given operating temperature is application dependent and may change according to the demands placed upon it in operation.

Note 7 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.

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 ASSESSMENTS TO DETERMINE IT’S 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 MERCHANTABILITY OR FIT FOR ANY PARTICULAR PURPOSE; OR THAT THE USE OF SUCH OTHER INFORMATION OR PRODUCT WILL NOT INFRINGE ANY PATENT.

Issue No: 3
April 28, 2011