TECHNICAL BULLETIN: CLI 4175 / CLH 6104

PRODUCT DESCRIPTION:
A room temperature cure, two component, urethane gel coat system. This high performance material has outstanding tear strength and abrasion resistance. The material can be used for tools, foundry patterns, and core boxes. It contains no MOCA or MDA.

SALES SPECIFICATIONS:

- **CLH 6104**
  - COLOR: RED
  - VISCOSITY (NOTE 1, NOTE 4): 8,000 - 12,000 cps
  - SPECIFIC GRAVITY: 1.50 ± 0.03 gm/cm³
  - SHELF LIFE: 12 MONTHS

- **CLI 4175**
  - COLOR: CLEAR
  - VISCOSITY (NOTE 1, NOTE 4): 8,000 - 12,000 cps
  - SPECIFIC GRAVITY: 1.11 ± 0.02 gm/cm³
  - SHELF LIFE: 12 MONTHS

HANDLING:
- **MIX RATIO BY WEIGHT (A:B) (NOTE 2)**: 100:100.0
- **MIXED VISCOSITY (NOTE 4)**: 17,500 cps @ 22 °C
- **POT LIFE OF 200 gm. mass (NOTE 4)**: 20 Min. @ 22 °C

CURE SCHEDULE (NOTE 3):
- **RECOMMENDED CURE SCHEDULE**: 5 Days. @ 22 °C
- **ALTERNATE CURE SCHEDULE**: 16 Hrs. @ 80 °C

CURED PROPERTIES: (NOT INTENDED FOR PREPARATION OF SPECIFICATIONS)

<table>
<thead>
<tr>
<th>Property</th>
<th>CLI 4175</th>
<th>CLH 6104</th>
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<tbody>
<tr>
<td>COLOUR</td>
<td>RED</td>
<td>RED</td>
</tr>
<tr>
<td>DENSITY (gm/cm³)</td>
<td>1.30</td>
<td>1.30</td>
</tr>
<tr>
<td>SHORE HARDNESS</td>
<td>62D</td>
<td>62D</td>
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<tr>
<td>LINEAR SHRINKAGE (in/in) (ASTM D 2566)</td>
<td>0.0020</td>
<td>0.0020</td>
</tr>
<tr>
<td>TENSILE STRENGTH (psi) (ASTM D 638)</td>
<td>2,600</td>
<td>2,600</td>
</tr>
<tr>
<td>TENSILE ELONGATION (%) (ASTM D 638)</td>
<td>125.0</td>
<td>125.0</td>
</tr>
<tr>
<td>FLEXURAL STRENGTH (psi)</td>
<td>2,000</td>
<td>2,000</td>
</tr>
</tbody>
</table>
Our strength is in our formulations

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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 MERCHANTABLE 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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