



CROSSLINK TECHNOLOGY INC.

FORMULATED EPOXIES, URETHANES - CUSTOM CAST PARTS

ISO

9001

REGISTERED
QUALITY SYSTEM

SINCE 1981

TECHNICAL BULLETIN: CLR 1396 / CLH 6930

PRODUCT DESCRIPTION:

A HIGH PERFORMANCE, ROOM TEMPERATURE CURING, 100% SOLIDS, EPOXY ADHESIVE. THIS PRODUCT BONDS TO A WIDE VARIETY OF SUBSTRATES AND WAS SPECIFICALLY DEVELOPED TO SEAL POROUS METAL SUBSTRATES.

SALES SPECIFICATION	CLR 1396	CLH 6930
COLOUR	BLACK	AMBER
VISCOSITY (NOTE 1, NOTE 4)	150000 - 250000 CPS	100 - 300 CPS
SPECIFIC GRAVITY	1.60 ± 0.03 gm/cm ³	0.94 ± 0.02 gm/cm ³
SHELF LIFE	12 MONTHS	12 MONTHS

HANDLING:

MIX RATIO BY WEIGHT (A:B) (NOTE 2)	100:15 (by vol. 100:25.0)
MIXED VISCOSITY (NOTE 4)	16000 cps @ 22 °C
POT LIFE OF 200 gm. mass (NOTE 4)	40.00 Min. @ 22 °C
GEL TIME OF 200 gm. mass (NOTE 4)	60.00 Min. @ 22 °C

GEL TIME~15 Min @ 60°C

CURE SCHEDULE (NOTE 3):

RECOMMENDED CURE SCHEDULE	24 Hrs. @ 22 °C
ALTERNATE CURE SCHEDULE	4 Hrs. @ 60 °C

CURED PROPERTIES: (NOT INTENDED FOR PREPARATION OF SPECIFICATIONS)

COLOUR	BLACK
DENSITY (gm/cm ³)	1.50
SHORE HARDNESS	88D
TENSILE STRENGTH (psi) (ASTM D 638)	6000
TENSILE ELONGATION (%) (ASTM D 638)	2.5
TENSILE MODULUS (psi)	350000
HDT(°C) (ASTM D 648)	106
GUIDE TO OPERATING TEMPERATURE(°C)(NOTE 6)	130
LINEAR SHRINKAGE (in/in) (ASTM D 2566)	0.0030
MOISTURE ABSORPTION (% 24 Hours RT)	0.100
COEFFICIENT OF THERMAL EXPANSION (in/in/°C)	40x10 ⁻⁶

NOTES

Note1 If a filled resin, settling may occur during transportation or storage. Fillers must be remixed before use.

Note2 Mix ratio must be within $\pm 2\%$ of the stated amount and thorough mixing is required to avoid degraded final properties.

Note3 Other cure schedules may give satisfactory results, however, these should be determined by the customer for their given circumstances.

Note4 All measurements taken at 22°C unless otherwise specified.

Note5 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.

Note6 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.

Note7 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

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