



CROSSLINK TECHNOLOGY INC.

FORMULATED EPOXIES, URETHANES - CUSTOM CAST PARTS

ISO

9001

REGISTERED
QUALITY SYSTEM

SINCE 1981

TECHNICAL BULLETIN: CLR 1331 / CLH 5185

PRODUCT DESCRIPTION:

A HEAT CURE, LOW STRESS, TOUGH, EPOXY CASTING COMPOUND. THE CURED MATERIAL EXHIBITS EXCELLENT THERMAL STABILITY AND THERMAL CYCLING CHARACTERISTICS.

SALES SPECIFICATION	CLR 1331	CLH 5185
COLOUR	GREY	AMBER
VISCOSITY (NOTE 1, NOTE 4)	20000 - 35000 CPS @ 70 °C	300 - 1000 CPS @ 22 °C
SPECIFIC GRAVITY	1.85 ± 0.03 gm/cm ³	1.10 ± 0.02 gm/cm ³
SHELF LIFE	12 MONTHS	12 MONTHS

HANDLING:

MIX RATIO BY WEIGHT (A:B) (NOTE 2)	100:30
MIXED VISCOSITY (NOTE 4)	2000 cps @ 60 °C
POT LIFE OF 200 gm. mass (NOTE 4)	5.00 Hrs. @ 60 °C
GEL TIME OF 200 gm. mass (NOTE 4)	30.00 Min. @ 125 °C

CURE SCHEDULE (NOTE 3):

RECOMMENDED CURE SCHEDULE	4 Hrs. @ 125 °C
OPTIONAL POST CURE	150 @ 150 °C

CURED PROPERTIES: (NOT INTENDED FOR PREPARATION OF SPECIFICATIONS)

COLOUR	GREY
DENSITY (gm/cm ³)	1.63
SHORE HARDNESS	92D
HDT(°C) (ASTM D 648)	90
GUIDE TO OPERATING TEMPERATURE(°C)(NOTE 6)	155

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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