



CROSSLINK TECHNOLOGY INC.

FORMULATED EPOXIES, URETHANES - CUSTOM CAST PARTS

ISO

9001

REGISTERED
QUALITY SYSTEM

SINCE 1981

TECHNICAL BULLETIN: XRD 1014 / XHD 1015

PRODUCT DESCRIPTION:

AN UNFILLED, HEAT RESISTANT, CLEAR LAMINATING SYSTEM. PRODUCTS LOW VISCOSITY GIVES THE SYSTEM EXCELLENT WET-OUT PROPERTIES TO FIBERGLASS AND OTHER REINFORCING FIBRES. THE MATERIAL EXHIBITS HIGH PHYSICAL STRENGTHS AND MODULUS WITH MODERATE POST CURE TEMPERATURES.

SALES SPECIFICATION	XRD 1014	XHD 1015
COLOUR	CLEAR	AMBER
VISCOSITY (NOTE 1, NOTE 4)	300 - 500 CPS @ 22 °C	200 - 500 CPS @ 22 °C
SPECIFIC GRAVITY	1.10 ± 0.03 gm/cm ³	1.10 ± 0.03 gm/cm ³
SHELF LIFE	12 MONTHS	12 MONTHS

HANDLING:

MIX RATIO BY WEIGHT (A:B) (NOTE 2)	100:28
MIXED VISCOSITY (NOTE 4)	400 cps @ 22 °C
POT LIFE OF 200 gm. mass (NOTE 4)	60.00 Min. @ 22 °C

THIN FILM GEL TIME~ 3-4 HRS. @ 22°C.

CURE SCHEDULE (NOTE 3):

RECOMMENDED CURE SCHEDULE	48 Hrs. @ 22 °C
ALTERNATE CURE SCHEDULE	6 Hrs. @ 80 °C

CURED PROPERTIES: (NOT INTENDED FOR PREPARATION OF SPECIFICATIONS)

COLOUR	AMBER
DENSITY (gm/cm ³)	1.10
SHORE HARDNESS	85D
TENSILE STRENGTH (psi) (ASTM D 638)	10000
TENSILE ELONGATION (%) (ASTM D 638)	5.5
HDT(°C) (ASTM D 648)	90
FLEXURAL STRENGTH (psi)	17500
FLEXURAL MODULUS (psi)	450000
THIN FILM WORKING TIME (HOURS)	2.0

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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6430 Vipond Drive, Mississauga, Ontario, Canada L5T 1W8 Phone: 1-800-563-3769, (905) 673-0510, Fax: (905) 673-0519 Web site: www.crosslinktech.com , E-mail: info@crosslinktech.com