



CROSSLINK TECHNOLOGY INC.

FORMULATED EPOXIES, URETHANES - CUSTOM CAST PARTS



TECHNICAL BULLETIN: CLR 1299 / CLH 6330

PRODUCT DESCRIPTION:

AN ALUMINUM FILLED, LOW VISCOSITY, ROOM TEMPERATURE GELLING, CASTING SYSTEM. THE PRODUCT HAS EXCELLENT SURFACE REPRODUCTION, AND HIGH STRENGTH. THIS SYSTEM IS RECOMMENDED FOR USE WITH ALUMINUM SHOT FOR LARGE MASS CASTING.

SALES SPECIFICATION	CLR 1299	CLH 6330
COLOUR	GREY	AMBER
VISCOSITY (NOTE 1, NOTE 4)	12000 - 20000 CPS @ 50 °C	200 - 500 CPS @ 22 °C
SPECIFIC GRAVITY	1.73 ± 0.03 gm/cm ³	1.00 ± 0.02 gm/cm ³
SHELF LIFE	12 MONTHS	12 MONTHS

HANDLING:

MIX RATIO BY WEIGHT (A:B) (NOTE 2)	100:10
MIXED VISCOSITY (NOTE 4)	12000 cps @ 22 °C
POT LIFE OF 200 gm. mass (NOTE 4)	2.50 Hrs. @ 22 °C

CURED PROPERTIES: (NOT INTENDED FOR PREPARATION OF SPECIFICATIONS)

COLOUR	GREY
DENSITY (gm/cm ³)	1.60
SHORE HARDNESS	87D
TENSILE STRENGTH (psi) (ASTM D 638)	6000
TENSILE ELONGATION (%) (ASTM D 638)	2.2
COMPRESSIVE STRENGTH (psi)	14300
FLEXURAL STRENGTH (psi)	13500
LINEAR SHRINKAGE (in/in) (ASTM D 2566)	0.0030
THERMAL CONDUCTIVITY W/(m•K)	0.85
TG (°C) ASTM E1545	88.00
CTE BELOW TG (x10 ⁻⁶ in/in°C) ASTM E831	38.32
CTE ABOVE TG (x10 ⁻⁶ in/in°C) ASTM E831	120.60

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

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 ITS 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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