

PREMIUM RESIN TECH.

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HIGH TEMPERATURE CLEAR LAMINATING (CLEAR AND RIGID)

RDR-3250 / RDH-9106

Resin / Hardener

MIXING RATIO: 100 : 24 PBW

RDR-3250 is an unfilled clear epoxy room temperature curing laminating system used in high temperature and room temperature applications. This system is tough, strong, has good heat distortion, chemical resistance and excellent adhesive qualities. As with most high temperature systems, it will achieve a demoldable state overnight @ ambient temperature. In some instances, tools may be used without post cure. However, for most uses at elevated temperature, post cure is recommended.

TYPICAL PHYSICAL PROPERTIES

Pot Life @ 72°F (200g mass)	1.5 hrs.
Ratio by Weight	100 pbw to 24 pbw
Ratio by Volume	3.4 to 1
Cure Time:	24 Hrs.
Flexural Strength @ 72°F	38,500
Flexural Modulus	1.85 x 10 ⁶
Compressive Strength	55,000
Heat Distortion	300°F
Hardness, Shore "D" @ 72°F	85
Hardness, Shore "D" @ 300°F	78
Density:	
Resin	9.6
Hardener	7.8
Mixed	9.25
Specific Gravity:	
Resin	1.16
Hardener	.94
Mixed	1.11
Shelf Life Resin / Hardener	1 year

Upon Completion, the tool should be allowed to cure at ambient temperature for 24 hrs. At that point, apply an oven cure according to the manufacturers schedule for your application. Please call for post-cure schedule.

The information herein is accurate to the best of our knowledge. Premium Resin Tech., assumes no liability whatsoever for the accuracy or completeness of the information contained herein. Final determination of suitability of any material is the sole responsibility of the user. All material may present unknown hazards and should be used with caution. Although certain hazards are described herein, we cannot guarantee that these are the only hazards which exist.