

PREMIUM RESIN TECH.

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HIGH TEMPERATURE BLACK SURFACE COAT

RDR-1902 / RDH-9302, RDH-9106

Resin / Hardener(s)

MIXING RATIO: 100:16

RDR-1902 is a high gloss, chemical resistant, high heat surface coat. **RDR-1902** system is the recommended surface coat for use with high temperature laminating.

TYPICAL PHYSICAL PROPERTIES

Used w/:	RDH-9302	RDH-9106
Color	Black	Black
Pot Life @ 72° F (200g mass)	14 minutes	60 minutes
Viscosity	gel	gel
Ratio by Weight	100 pbw to 15 pbw	100 pbw to 15 pbw
Flexural Strength @ 72° F	15,000 psi	16,000 psi
Tensile Strength	9,500 psi	10,000 psi
Compressive Strength	15,000 psi	16,000 psi
Heat Distortion	350°F	350°F
Hardness, Shore "D" @ 72° F	90	90
Shelf Life Resin / Hardener	1 year	1 year
Machinability	poor	poor
Cure Schedule	24 hours	24 hours

Recommended Post Cure: If tool is used at high temperature.

Upon Completion, the tool should be allowed to cure at ambient temperature for 24 hrs. Post cure cycle should be 50 degrees per hour (Tool Temperature, not air Temperature). Not more than 5 degrees per min.

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