



Freeman 935 High Temperature Epoxy Surface Coat

Description

Freeman 935 High Temperature Epoxy Surface Coat features three variable gel times depending on which hardener is used. This product is ideal for thermo-forming, prototype injection molding, and other general high-temperature tooling.

Physical Properties

	935-15	935-30	935-90
Color (when mixed)	Gray	Gray	Gray
Mix Ratio (R:H, by wt.)	100:11	100:11	100:11
Viscosity (cps, mixed)	27,500	29,500	25,350
Gel Time (min. @ 72°F.)	28	43	90
Demold Time (hrs.)	24	24	24
Hardness (Shore D) (ASTM 2240)	88	90	88
Specific Gravity, Mixed (ASTM D-792)	1.559	1.599	1.591
Volumetric Yield (cu. in./ lb.)	17.76	17.31	17.40
Compressive Strength (psi)	26,500	26,500	26,500
Tensile Strength (psi) (ASTM D-638)	4,000	4,000	4,000
Flexural Strength (psi)	7,950	7,950	7,950
Deflection Temperature (°F)	300	300	300
Tg (°F)	350	350	350

Post Curing Instructions: After curing at room temperature for 24-48 hours, it is recommended to post cure two hours at 150°F (66°C), plus two hours at 200°F (93°C), plus two hours at 250°F (121°C), plus two hours at 300°F (149°C). Temperature limitations of the mold or model dictate whether it can be used as the supporting structure during the post cure cycle. If the tool must be pulled from the model for the post cure, a supporting frame must be provided. Uniform heat distribution is also required during post cure cycle; concentrated heat, such as that directed from a lamp, can cause warping. An elevated temperature cure will slightly increase the shrinkage compared to a room temperature cure.

Ordering Information

Item Number	Description	Size	Net Wt. Lbs.
055942	Freeman 935 Hi-Temp Surface Coat Resin Only	Quart	2
055943	Freeman 935-30 Hi-Temp Surface Coat Hardener Only	½-Pint	0.22
055939	Freeman 935 Hi-Temp Surface Coat Resin Only	6-Quart	12
055940	Freeman 935-30 Hi-Temp Surface Coat Hardener Only	6-½Pint	1.32
055937	Freeman 935 Hi-Temp Surface Coat Resin Only	5-Gallon	45
055944	Freeman 935-15 Hi-Temp Surface Coat Hardener Only	Gallon	4.94
055938	Freeman 935-30 Hi-Temp Surface Coat Hardener Only	Gallon	4.94
055947	Freeman 935-90 Hi-Temp Surface Coat Hardener Only	Gallon	4.94

Designated mix ratios must be adhered to for desired results. The user shall determine the suitability of this product for their application and assumes all risks and liabilities associated with the use of this product. The exclusive remedy for all proven claims is replacement of our materials only and in no event shall Freeman Mfg. & Supply Co. be liable for special, incidental, or consequential claims.

READ SAFETY DATA SHEETS AND PRODUCT LABELS BEFORE USING PRODUCT