



## Freeman 927 Epoxy Hi-Temp Laminating Resin

### Description

Freeman 927 is a low viscosity aluminum-filled hi-temp laminating system that offers excellent wet out and good working time for tooling applications requiring service temperature up to 300°F. Heated post cure is required.

### Physical Properties

Color	Gray
Mix Ratio (by weight)	100:13
Mix Ratio (by volume)	100:18
Viscosity, Mixed (cps)	3,600
Gel Time (minutes @ 77°F)	60
Demold Time (hours)	24
Hardness (Shore D)	90
Specific Gravity (g/cc)	1.31
Tensile strength, (psi)	26,000
Flexural Strength, (psi)	33,000
Compression Strength (psi)	52,800
CTE (in/in/°F)	$1.27 \times 10^{-5}$
Heat Distortion Temperature	300°F

\*Properties obtained from a 10 oz glass cloth laminate.

### Post Cure Schedule:

- (24) Hours @ 75°F
- (2) Hours @ 150°F
- (2) Hours @ 200°F
- (2) Hours @ 250°F
- (2) Hours @ 300°F

Tool should be supported through full post cure. If unable, allow tool to cure for (48) hours at 75°F, then post cure for (2) hours at 150°F before removing from mold.

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

Freeman Manufacturing & Supply Company | Avon, OH 44011 | (800) 321-8511 | [www.freemansupply.com](http://www.freemansupply.com)