



## Freeman 821 Aluminum-Filled Epoxy Casting Resin

### Description

Freeman 821 is an economical aluminum-filled epoxy casting resin that is excellent for making wear resistant core boxes, patterns, and tooling fixtures. Once cured features excellent machining and polishing characteristics. Low shrinkage, long gel time, and lower exotherm enables this material to be poured up to 4" thick.

### Physical Properties

Color	Grey
Mix Ratio (by weight)	7:1
Viscosity, Mixed (cps)	6,000
Gel Time (minutes @ 77°F)	85
Demold Time (hours)	24
Hardness (Shore D)	83
Specific Gravity (in <sup>3</sup> /lb.)	1.83
Volumetric Yield (cu. in./ lb.)	15.2
Deflection Temperature (°F)	128
Tensile strength (psi)	4,000
Compressive Strength (psi)	10,150
Flexural Strength (psi)	8,300
C.T.E. (in/in/°F)	$2.7 \times 10^{-5}$
Shrinkage (in/in)	<0.005

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