

Advanced Materials**RenCast[®] 3253 / Ren[®] 3253 System**

SURFACE CAST OR CASTING SYSTEMS

DESCRIPTION :

RenCast[®] 3253 (Resin) / Ren[®] 3253 (Hardener) is a black, iron-filled epoxy casting system designed for castings up to 3/4 inch thick. It provides excellent wear resistance in applications subject to high wear or surface abrasion.

APPLICATIONS :

- Dies
- Punches
- Core boxes
- Hammer forms

MIX RATIO :

	Resin / Hardener	
Reaction Ration	(weight)	100/5
	(volume)	100/16

Mixing: Stir each component thoroughly before use. Weigh each component accurately (\pm 5%) into clean containers. Thoroughly mix resin and hardener together (minimum 3 minutes) scraping container sidewalls, bottom and mixing stick several times to assure a uniform mix.

TYPICAL MIXED PROPERTIES :

Property	ASTM Test Method	Test Values ⁽¹⁾
Gel Time (4 fl. Oz.)	D-2471	100 min.
(14 fl. Oz.)		34 min.
Viscosity	D-2393	7500 cP

⁽¹⁾ Tested @ 77 °F (25 °C)

TYPICAL CURED PROPERTIES :

Property	ASTM Test Method	Test Values⁽¹⁾
Specific Gravity	D-792	2.99
Hardness (Shore D)	D-2240	90
Ultimate Compressive Strength (psi)	D-695	15,200
Ultimate Flexural Strength (psi)	D-790	8,500
Ultimate Tensile Strength (psi)	D-638	7,100
Deflection Temperature (264 psi) (°F)	D-648	120
Shrinkage (in/in) Mold #1	ERF 12-74	0.002
Coefficient of linear thermal expansion (in/in/°F)	D-696	3.23 x 10 ⁻⁵
Water absorption		
2 hrs. Water boil		0.354 %
24 hrs. @ R.T.		0.069 %
7 days @ R.T.		0.191 % in/lb
Volumetric weight	D-792	9.3 cu-in/lb

⁽¹⁾ Cure Schedule – 7 days @ 77 °F (25 °C), tested @ 77 °F

NOTE : Typical Properties – These physical properties are reported as typical test values obtained by our test laboratory. If assistance is needed establishing product specifications, please consult with our Quality Control Department.

STORAGE:

RenCast[®] 3253 (Resin) / Ren[®] 3253 (Hardener) should be stored in a dry place, in the sealed original container, at temperatures between +2°C and +40°C (+35.6°F and 104°F). Under these storage conditions, the shelf life is 2 years. The product should not be exposed to direct sunlight.

PRECAUTIONARY STATEMENT:

Huntsman Advanced Materials Americas LLC maintains up-to-date Material Safety Data Sheets (MSDS) on all of its products. These sheets contain pertinent information that you may need to protect your employees and customers against any known health or safety hazards associated with our products. Users should review the latest MSDS to determine possible health hazards and appropriate precautions to implement prior to using this material.

First Aid!

Refer to MSDS as mentioned above.

KEEP OUT OF REACH OF CHILDREN

FOR PROFESSIONAL AND INDUSTRIAL USE ONLY

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