

RP 3269-1 R/H

MASS CASTING SYSTEM

Ren[®] RP 3269-1 resin and hardener casting is a gray, aluminum-filled epoxy system formulated for castings up to 2 inches thick in nonconducting molds. It can be cast up to 4 inches thick against metal. RP 3269-1 R/H cures at room temperature, possesses a long pot life, and provides extremely accurate detail reproduction.

MIX RATIO

	By Weight:	By Volume:
Resin to Hardener	100 to 12	100 to 23

TYPICAL HANDLING PROPERTIES*

	<u>ASTM Method</u>	<u>Resin</u>	<u>Hardener</u>	<u>Mixed</u>
Color	Visual	Gray	Amber	Gray
Specific Gravity	D-1963	1.73	0.95	
Viscosity, cP	D-2393	12,000	225	4,600
Gel Time, 14 fl. oz, minutes	D-2471			150

NOTE: These physical properties are reported as typical test values obtained by our test laboratory. If assistance is needed in establishing product specifications, please consult with our Product Management Department.

RECOMMENDED CURE SCHEDULE

1. 77°F (25°C) at 7 days

TYPICAL CURED PROPERTIES*

	<u>ASTM Method</u>	<u>Cure Value</u>
Density, lb./ft ³ (g/cm ³)	D-792	106 (1.70)
Cubic Inch per Pound	D-792	16.3
Hardness, Shore D	D-2240	87
Ultimate Flexural Strength, psi	D-790	11,600
Flexural Modulus, psi	D-790	900,000
Ultimate Tensile Strength, psi	D-638	7,300
Tg by DMA, E", °F(°C)	D-4065	146 (63)
Ultimate Compressive Strength, psi	D-695	12,500
Coefficient of Thermal Expansion	D-3386	
		-22 to 86°F, in/in/°F
		-30 to 30°C, in/in/°C
Linear Shrinkage, in/in	D-2566	38.0 x 10 ⁻⁶
		68.4 x 10 ⁻⁶
		0.003

* Tested @ 77°F (25°C) unless otherwise noted.

** Molds are half round steel, 10 inches long, 2.250 inches deep

SAFETY: Do not use or handle this product until the Material Safety Data Sheet has been read and understood.

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