



Product Data

Ren[®]
Professional Tooling Line

RenCast[™] 8269/Ren[®] 8269 Slow/Ren[®] 8269 Medium
ROOM-TEMPERATURE PERFORMANCE ALUMINUM-FILLED CASTING RESIN

DESCRIPTION: RenCast 8269(Resin) and Ren 8269 Slow–Medium(Hardener) casting system offers two hardener choices to suit both thick and thin section casting jobs. All combinations offer excellent detail pick-up and excellent cured strength to aid in the construction of high-quality, stable cast tools.

RenCast 8269 casting systems can be used with RenGel 8024 surface coat and with RenLam 8100 or RenLam 8110 laminating systems for tool construction.

MIX RATIO

	By Weight:	By Volume:
Resin to Slow Hardener	100 to 18	100 to 28
Resin to Medium Hardener	100 to 10	100 to 15

TYPICAL HANDLING PROPERTIES*

	<u>ASTM Method</u>	<u>Mixed, Slow</u>	<u>Mixed, Medium</u>
Color	Visual	Gray	Gray
Viscosity, cP	D-2393	22,000	4,300
Gel Time, 600g, minutes	D-2471	180	90
Demold Time, hours		24–48	24

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.

TYPICAL CURED PROPERTIES*

	<u>ASTM Method</u>	<u>Slow System</u>	<u>Medium System</u>
Density, lb./ft ³ (g/cm ³)	D-792	101 (1.61)	104 (1.67)
Cubic Inch per Pound		17.2	16.6
Hardness, Shore D	D-2240	85	88
Ultimate Flexural Strength, psi	D-790	6,800	10,900
Flexural Modulus, psi	D-790	600,000	1,000,000
Ultimate Tensile Strength, psi	D-638	5,500	9,200
Tensile Modulus, psi	D-638	600,000	1,100,000
% Elongation	D-638	2.1	2.2
Tg by DMA, E", °F(°C)	D-4065	171 (73)	210 (99)
Deflection Temperature, °F(°C)	D-648	148 (64)	184 (84)
		142 (61)	167 (75)
Ultimate Compressive Strength, psi	D-695	15,600	20,000
Compressive Modulus, psi	D-695	60,000	900,000
Izod Impact, notched, ft-lb./in	D-256	0.61	0.72
Coefficient of Thermal Expansion	D-3386		
		22 x 10 ⁻⁶	28 x 10 ⁻⁶
		40 x 10 ⁻⁶	50 x 10 ⁻⁶

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

**RECOMMENDED CURE
SCHEDULE**

1. 77°F (25°C) at 7 days

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

RenCast 8269

WARNING! Can cause skin irritation, eye irritation, and allergic skin reaction. Avoid contact with eyes, skin, and clothing. Wash thoroughly after handling.

Ren 8269 Medium

DANGER! COMBUSTIBLE. CORROSIVE. Causes skin and eye burns. May cause allergic skin reaction. Keep away from heat and flame. Do not get in eyes, on skin, or on clothing. Avoid breathing vapor or mist. Keep container closed. Use with adequate ventilation. Wash thoroughly after handling.

Ren 8269 Slow

WARNING! Causes eye irritation. May cause allergic skin reaction. Avoid contact with eyes and prolonged or repeated contact with skin. Wash thoroughly after handling. Nuisance dust may be generated when sanding or sawing cured material.

FIRST AID: In case of contact with:

Skin: Immediately wash with soap and water. Remove contaminated clothing and launder before reuse. Destroy contaminated shoes.

Eyes: Immediately flush with water for at least 15 minutes. Call a physician.

Ingestion: If conscious, give plenty of water to drink. Do not induce vomiting. Call a physician.

Inhalation: Remove to fresh air. Administer oxygen or artificial respiration if necessary. Call a physician.

Other: Referral to physician is recommended if there is any question about the seriousness of any injury.

PRECAUTIONARY NOTE: Thermosetting systems generate heat when curing. The amount of heat and the period of time in which heat is released vary significantly between systems. Additionally, ambient or compound temperature, amount of material mixed, and construction and shape of the mold or container can also be factors in the temperature profile of a mixed system.

In some cases, the thermosetting reaction can be vigorous, generating heat sufficient to cause decomposition of the system with subsequent liberation of large volumes of acrid smoke.

A good rule of thumb is never mix more material than can be applied during the stated pot life or gel time. Also take care when using materials in applications other than stated on the Product Data Sheet, i.e., a laminating resin for casting.

Please feel welcome to call our Product Information Department or your local Ren representative for instructions before you start your job.

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