

RP 6457 R/H

SHORE 65D LARGE PART

LOW FLEXURAL MODULUS PROTOTYPE SYSTEM FOR MACHINE DISPENSING

Ren® RP 6457 resin and hardener is formulated to rapidly produce prototype parts from low-cost tooling. It can be cast into molds made from silicone, polyurethane, or epoxy. Cured parts have the look and feel of thermoplastic polyolefins. The parts have high-impact resistance with good dimensional stability. This system provides additional working time to fill large molds. Parts can be demolded in 1 to 2 hours, depending on configuration. RP 6457 R/H is best suited for use with meter-mix dispensing equipment.

MIX RATIO

Resin to Hardener	By Weight: 53 to 100	By Volume: 50 to 100
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TYPICAL HANDLING PROPERTIES*

	<u>ASTM Method</u>	<u>Resin</u>	<u>Hardener</u>	<u>Mixed</u>
Color	Visual	Dark brown	Cream	Buff
Specific Gravity	D-1963	1.20	1.06	
Viscosity, cP	D-2393	170	750	
Gel Time, 150g, seconds	D-2471			90-120

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	71 (1.15)
Cubic Inch per Pound		24.1
Hardness, Shore D	D-2240	65
Flexural Strength, 5% strain, psi	D-790	2,800
Flexural Modulus, psi	D-790	78,000
Ultimate Tensile Strength, psi	D-638	2,700
Tensile Modulus, psi	D-638	111,000
% Elongation	D-638	8
Tear Strength, ppi	D-624	630
Tg per DMA, E", °F(°C)	D-4065	175 (80)
Deflection Temperature, °F(°C)	D-648	145 (63)
	66 psi	123 (51)
	264 psi	
Ultimate Compressive Strength, psi	D-695	9,500
Compressive Modulus, psi	D-695	78,000
Izod Impact, notched, ft-lb./in	D-256	0.8
Coefficient of Thermal Expansion	D-3386	
	-22 to 86°F, in/in/°F	77 x 10 ⁻⁶
	-30 to 30°C, in/in/°C	138 x 10 ⁻⁶

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

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

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