

RP 1225 R/H

FINISH SPLINING MATERIAL

Ren[®] RP 1225 resin and hardener is an easy-to-work, sag-resistant, white epoxy paste especially designed for finish splining. It can also be used for surface repair of master models and room-temperature tools plus many other tooling applications. It has a fast set time and offers good bonding characteristics between successive coats. It works especially well over Ren RP 1220 R/H base spline.

MIX RATIO

	By Weight:	By Volume:
Resin to Hardener	100 to 18	100 to 25

TYPICAL HANDLING PROPERTIES*

	<u>ASTM Method</u>	<u>Resin</u>	<u>Hardener</u>	<u>Mixed</u>
Color	Visual	White	Light Amber	White
Specific Gravity	D-1963	1.40–1.47	1.10–1.20	
Sag Resistance	D-2730-68			Pass 1/4" Fail 1/2"
Gel Time, 4 fl. oz, minutes	D-2471			15

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	90 (1.44)
Cubic Inch per Pound	D-792	19.2
Hardness, Shore D	D-2240	88
Ultimate Flexural Strength, psi	D-790	7,800
Flexural Modulus, psi	D-790	700,000
Ultimate Tensile Strength, psi	D-638	4,500
Tg by DMA, E", °F(°C)	D-4065	176 (80)
Deflection Temperature, °F(°C)	D-648	140 (60)
Ultimate Compressive Strength, psi	D-695	14,300
Compressive Modulus, psi	D-695	6,600,000
Coefficient of Thermal Expansion	D-3386	
		3,000 x 10 ⁻⁶
		5,400 x 10 ⁻⁶
Linear Shrinkage, in/in**	D-2566	0.002

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

** Molds are half round steel, 10 inches long, 0.875 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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