

# RP 3281 R/H

## TWO COMPONENT “LOW DENSITY” EPOXY FILLER

Ren<sup>®</sup> RP 3281 resin and hardener is a room-temperature curing, low-density, two-component syntactic epoxy filler system. The resin and hardener are colored to ensure a homogeneous mix. A mechanical mixer (such as a Hobart or Kol mixer) is required for mixing. Although RP 3281 R/H is a general tooling system, it has been of particular benefit in foundry applications, in negative-mold and core-mask construction, and for internal core structures for production patterns and core boxes.

### MIX RATIO

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

### TYPICAL HANDLING PROPERTIES\*

	<u>ASTM Method</u>	<u>Resin</u>	<u>Hardener</u>	<u>Mixed</u>
Color	Visual	Blue	Tan	Light blue
Specific Gravity	D-1963	0.60–0.70	0.42–0.52	
Gel Time, 14 fl. oz, hours	D-2471			2.5–3

**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 <sup>3</sup> (g/cm <sup>3</sup> )	D-792	34 (0.55)
Cubic Inch per Pound	D-792	50.4
Hardness, Shore D	D-2240	50
Ultimate Flexural Strength, psi	D-790	1,500
Ultimate Tensile Strength, psi	D-638	1,086
Tg by DMA, E", °F(°C)	D-4065	158 (70)
Deflection Temperature, °F(°C)	D-648	118 (48)
Ultimate Compressive Strength, psi	D-695	2,690
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	16.2 x 10 <sup>-6</sup> 29.2 x 10 <sup>-6</sup> 0.0002

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

\*\* Molds are half round steel, 10 inches long, 4.250 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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