



Freeman 9605 Epoxy Infusion System

Description

Freeman 9605 is a low viscosity epoxy system featuring an exceptionally long room temperature gel time. Developed for use in the production of advanced composites using vacuum-assisted resin transfer process (VARTM), resin transfer molding (RTM), or other infusion processes. This system requires a post cure for use at elevated temperatures.

Physical Properties

Color	Clear Amber
Mix Ratio (by weight)	100:35
Viscosity, Mixed (cps)	500-700
Gel Time (minutes @ 77°F)	500
Demold Time (hours)	24
Hardness (Shore D)	89
Specific Gravity (in ³ /lb.)	1.09
Volumetric Yield (cu. in./ lb.)	25.4
HDT, Post Cure (°F)	310
Tensile strength (psi)	9,700
Compressive Strength (psi)	15,700
Flexural Strength (psi)	19,000
Izod Impact, Notched (ft-lb/in)	0.90
Elongation (%)	5.6

POST CURE OPTIONS:

Post cure is recommended to obtain maximum physical and thermal properties of the system. The recommended post cure temperature ramp rate between stages is up 5°F per minute for heating, and down 1-2°F per minute for cooling. Heating and cooling ramp rates can vary based on size and thickness of the part. For larger or thicker parts use a more conservative ramp.

System Post Cure:

	24 Hr. @ 77°F (25°C)	2 Hr. @ 150°F (66°C)	2 Hr. @ 200°F (93°C)	2 Hr. @ 250°F (121°C)	2 Hr. @ 300°F (149°C)	2 Hr. @ 350°F (177°C)
Cure Increments	Supported	Supported	Unsupported	Unsupported	Unsupported	Unsupported

The user shall determine the suitability of this product for their application and assumes all risks and liabilities associated with the use of this product. The exclusive remedy for all proven claims is replacement of our materials only and in no event shall Freeman Mfg. & Supply Co. be liable for special, incidental, or consequential claims.

READ SAFETY DATA SHEETS AND PRODUCT LABELS BEFORE USING PRODUCT