

Devcon® Tooling Resins Specifications

Product	Mix Ratio Resin to Hrd'nr (by wt.)	Mix Ratio Resin to Hrd'nr (by vol.)	Gel Time (min)	Mixed Viscosity Brookfield (cps.)	Coverage Per Lb. (in. ² @ 1/4")	Vol. Wt. Ratio (in. ³ /lb.)	Hardness (Shore D)	Compressive Strength (psi)	Ultimate Flexural Strength (psi)	Ultimate Tensile Strength (psi)	Coefficient Of Thermal Expansion (in./in./°F)	Operating Temp. (Max) (°F)	Shrinkage (in/in) (Cast)
Plastic Aluminum (Liquid)	9/1	5/1	75	15-25,000	70	17.5	85 D	9,820	3,540	2,700	50 x 10 ⁻⁶	250	0.0009
Plastic Steel (Liquid)	9/1	3/1	45	15-25,000	52	13.1	85 D	10,200	7,480	4,900	38 x 10 ⁻⁶	250	0.0006
Flexane 80 Liquid	77/23	–	30	10,000	106	26.5	87 A	–	–	2,100	–	180	0.0018
Flexane 80 Putty	72/28	–	20	Putty	94	23.5	87 A	–	–	1,700	–	180	0.0014
Flexane 94	69/31	–	10	6,000	106	26.5	97 A	–	–	2,800	–	180	0.0014
ASTM test							D2240		D790	D638	D696		D2566

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