



# Technical Data Sheet

## Freeman 925 High-Temperature Epoxy Casting Resin

### Description

Freeman 925 is an aluminum-oxide filled high-temperature epoxy casting resin that features low shrinkage and high accuracy. Freeman 925 is commonly used in prototype injection molding, vacuum forming, and elevated temperature fixtures.

### Physical Properties

Color	Gray
Mix Ratio (R:H, by wt.)	100:8
Viscosity (cps, mixed)	11,000
Gel Time (min. @ 72°F)	37
Demold Time (hrs.)	24
Hardness (Shore D)(ASTM 2240)	90
Specific Gravity, Mixed	1.68
Volumetric Yield (cu. in./lb.)	16.48
Deflection Temperature (°F)(ASTM D-648)	225
Tg (°F)	290
Coefficient of Thermal Expansion	2.20 x 10 <sup>-5</sup> in./in./°F
Thermal Conductivity (ASTM C-177)	11.56
Tensile Strength (psi)(ASTM D-638)	10,200
Compressive Strength (psi)(ASTM D-695)	40,000
Flexural Strength (psi)(ASTM D-790)	18,000
Linear Shrinkage (in./in.)(ASTM D-2566)*	0.001

\*Actual shrinkage dependent upon mass

### Recommended Cure Schedule:

72°F @ 24 hours, plus 150°F @ 2 hours on mold if possible, plus 200°F @ 2 hours, plus 250°F @ 2 hours, plus 300°F @ 2 hours

Temperature limitations of the mold or model dictate whether it can be used as the supporting structure during the post-cure cycle. If the tool must be pulled from the model for post-cure, a supporting frame must be provided. Uniform heat distribution is also required during post-cure; concentrated heat, such as that directed from a lamp, can cause warping. An elevated temperature cure will slightly increase the shrinkage compared to a room temperature cure.

### Ordering Information

SKU	Description	UM	Net Wt. Lbs.
055951	Freeman 925 Epoxy Casting Resin Only Quart	EA	2
055953	Freeman 925 Epoxy Casting Hardener Only ½ Pint	EA	0.16
055950	Freeman 925 Epoxy Casting Resin Only 6-Quart	EA	12
055952	Freeman 925 Epoxy Casting Hardener Only 6-1/2 Pint	EA	0.96
055954	Freeman 925 Epoxy Casting Resin Only 5-Gallon	EA	45
055955	Freeman 925 Epoxy Casting Hardener Only Gallon	EA	3.60

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

