



# Technical Data Sheet

## Freeman 955 Epoxy Hi-Temp Surface Coat

### Description

Freeman 955 is an aluminum-filled hi-temp epoxy surface coat that can be used for tooling applications up to 300°F. Applications include vacuum form tools, RTM and RIM molds, compression and injection molds.

Freeman 955 is also styrene resistant. Heated post cure is required.

### Physical Properties

Color	Gray
Mix Ratio (by weight)	100:10
Mix Ratio (by volume)	100:15
Viscosity, Resin (cps)	Thixotropic
Viscosity, Hardener (cps)	145
Viscosity, Mixed (cps)	Thixotropic Paste
Gel Time (minutes @ 77°F)	45
Demold Time (hours)	16
Hardness (Shore D)	90
Density, Resin (g/cc)	1.50
Density, Hardener (g/cc)	0.96
Density, System (g/cc)	1.47
Volumetric Yield (in <sup>3</sup> / lb)	18.9
Tensile strength, (psi)	5,800
Flexural Strength, (psi)	6,500
Compression Strength (psi)	28,000
Heat Distortion Temperature	300°F

Tool should be supported through full post cure. If unable, allow tool to cure for (48) hours at 75°F, then post cure for (2) hours at 150°F before removing from mold.

Cure Schedule:	24 Hours at 77°F (25°C)	2 Hours at 150°F (66°C)	2 Hours at 200°F (93°C)	2 Hours at 250°F (121°C)	2 Hours at 300°F (149°C)
	Supported	Supported	Supported	Supported	Supported

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