



Freeman 9604 Epoxy Infusion System

Description

Freeman 9604 is a two-component, low viscosity epoxy system developed for use in the production of advanced composites using vacuum-assisted resin transfer process (VARTM), resin transfer molding (RTM), or other infusion processes.

Physical Properties

Color	Amber
Mix Ratio (by weight)	100:28
Viscosity, Mixed (cps)	300
Gel Time (minutes @ 77°F)	130
Demold Time (hours)	24
Hardness (Shore D)	84
Specific Gravity (in ³ /lb.)	1.10
Volumetric Yield (cu. in./ lb.)	25.1
HDT, Room Temperature Cure (°F)	130
HDT, Post Cure (°F)	190
Tensile strength (psi)	10,300
Compressive Strength (psi)	13,800
Flexural Strength (psi)	17,500
Izod Impact, Notched (ft-lb/in)	1.09
Elongation (%)	7.2
Shrink (in/in)	0.002"

System 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.

Cure Increments	24 Hours at 77°F (25°C)	7 Days at 77°F (25°C)	4 Hours at 120°F (49°C)	4 Hours at 150°F (66°C)	2 Hours at 180°F (82°C)
Room Temp.	Supported	Unsupported			
Post Cure	Supported			Supported	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