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Advanced Materials

RenCast® 3265 / Ren® 3265 System

POLYURETHANE CASTING SYSTEMS

DESCRIPTION:

RenCast® 3265(Resin) / Ren® 3265(Hardener) is a unique, two-component casting system which can be mixed, poured and demolded within 15 to 30 minutes at room temperature.

APPLICATIONS:

- Duplicate masters
- Jigs
- Fixtures
- Patterns
- General purpose tooling aids

ADVANTAGES:

- Quick demold time
- Fast cure
- Easy mixing and handling
- Good surface detail reproduction
- Excellent physical properties

MIXING INSTRUCTIONS:

Reaction Ratio 100R to 100H by weight
 100R to 100H by volume

Mixing: The resin and hardener should be mixed thoroughly for approximately 30 seconds or until the mixture begins to warm. Mixing may be done by hand, with a paddle or with a power mixer. When mixing with power, generate only a small vortex and do not whip excess air into the mixture. Proper application of a parting agent, such as RP 803, is important for satisfactory release.

TYPICAL MIXED PROPERTIES:

Property	ASTM Test Method	Test Values ⁽¹⁾
Gel time, 4 fl. oz.	D-2471	3 min.
Color Resin	Visual	Brown
Hardener		Pea green
Mixed		Brown
Viscosity, Mixed	D-2393	5,000 cP

⁽¹⁾ Tested @ 77°F (25°C)



TYPICAL CURED PROPERTIES:

Property	ASTM Test Method	Test Values ⁽¹⁾
Specific Gravity	D-792	1.70
Cubic inch per lb.	D-792	16.2
Hardness (Shore D)	D-2240	78
Ultimate Compressive Strength (psi)	D-695	5,000
Ultimate Flexural Strength (psi)	D-790	3,000
Flexural Modulus	D-790	0.40 x 10 ⁶
Ultimate Tensile Strength (psi)	D-638	2,000
Deflection Temperature @ 264 psi	D-648	135°F (57°C)
Coefficient of thermal Expansion (in/in/°F)	D-3386	4.1 x 10 ⁻⁵
Shrinkage (in/in) cast Mold #1	D-2566	0.005

⁽¹⁾ Cure Schedule – 7 days @ 77°F (25°C), tested @ 77°F

NOTE: Typical Properties – These physical properties are reported as typical test values obtained by our test laboratory. If assistance is needed in establishing product specifications, please consult with our Quality Control Department.

HANDLING:**RenCast® 3265 / Ren® 3265 System**

This product is moisture-sensitive and packaged under a blanket of dry nitrogen. Maintain factory seal. After use, reblanket with dry nitrogen and tightly reseal.

Work in a well ventilated area and use clean, dry tools for mixing and applying. For two component system, combine the resin and hardener according to mix ratio. Mix together thoroughly and use immediately after mixing. Material temperature should not be below 18°C (65°F) when mixing.

RenCast® 3265 Resin

Stir well before use. This material will separate.

PACKAGING:

This product is available in the following package size(s):

- Cartons containing 6 small containers each of resin or hardener.
- Each carton contains 18# of material (resin or hardener).

Please call Customer Service (800-367-8793) for price and availability.

STORAGE:

RenCast® 3265(Resin) / Ren® 3265(Hardener) should be stored in a dry place, in the sealed original container, at temperatures between +2°C and +40°C (+35.6°F and 104°F). Under these storage conditions, the shelf life is 2 years. The product should not be exposed to direct sunlight.

PRECAUTIONARY STATEMENT:

Huntsman Advanced Materials Americas LLC maintains up-to-date Material Safety Data Sheets (MSDS) on all of its products. These sheets contain pertinent information that you may need to protect your employees and customers against any known health or safety hazards associated with our products. Users should review the latest MSDS to determine possible health hazards and appropriate precautions to implement prior to using this material.

First Aid!

Refer to MSDS as mentioned above.

KEEP OUT OF REACH OF CHILDREN

FOR PROFESSIONAL AND INDUSTRIAL USE ONLY

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