



“Our strength is in our formulations”

TECHNICAL BULLETIN:

XPD 1392 / CLI 4181

DESCRIPTION: A TRANSPARENT, LOW VISCOSITY, FLEXIBLE POLYURETHANE CASTING RESIN. THE PRODUCT CONTAINS NO MDA OR MOCA.

SALES SPECIFICATION:

XPD 1392

CLI 4181

COLOR	CLEAR	AMBER
VISCOSITY (NOTE 1)	300-600 cps @ 22°C	500-1000 cps @ 22°C
SPECIFIC GRAVITY	1.01-1.05 gm/cm ³ @ 22°C	1.20-1.24 gm/cm ³ @ 22°C
SHELF LIFE	12 MONTHS	12 MONTHS

HANDLING: (NOTES 1,2 & 5)

MIX RATIO BY WEIGHT (A:B) (NOTE 1)	100:70
VISCOSITY	500-700 cps @ 22°C
POT LIFE	25 - 35 minutes @ 22°C
GEL TIME	40 - 60 minutes @ 22°C

CURE SCHEDULE: (NOTE 3)

RECOMMENDED CURE SCHEDULE	6 HOURS @ 60°C
ALTERNATE CURE SCHEDULE	16 - 24 HOURS @ 22°C

CURED PROPERTIES: (not intended for preparation of specifications)

COLOUR	CLEAR
DENSITY / SPECIFIC GRAVITY	1.08 gm/cm ³ @ 22°C
SHORE HARDNESS	85A ± 3A
GUIDE TO OPERATING CLASS	105°C
LINEAR SHRINKAGE (ASTM D 2566)	0.004 in/in

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NOTES:

- 1) If a filled resin, settling may occur during transportation or storage. Fillers must be remixed before use.
- 2) The mix ratio must be within $\pm 2\%$ of the stated value and thorough mixing is required to avoid degraded properties.
- 3) Other cure schedules may yield satisfactory results however; these should be determined by the customer for his given application.
- 4) Unless otherwise specified, all measurements are taken at 22^oC.
- 5) These products may trigger allergic reactions in some individuals. Prevent contact with skin; wash with plenty of soap and water if contact occurs and **Read the Material Safety Data Sheet** before using the materials. **Do Not Breathe Vapours** provide good ventilation and exercise good housekeeping at the work area.
- 6) If indicated, the values under “**Electrical Characteristics**” may be based on supplier data for products with similar compositions. They are provided only as a guide and the recipient must test each material to determine its suitability for the intended application.
- 7) If stated, the “**Guide to Operating Temperature**” is based on our experience with materials of similar chemistry and/or thermal index. The ultimate suitability of a product for a particular operating temperature is application dependent and **may change according to the demands placed upon it in service.**

IMPORTANT

THE INFORMATION IN THIS BULLETIN IS BASED ON DATA OBTAINED BY OUR OWN RESEARCH AND IS CONSIDERED ACCURATE. ALL INFORMATION SUPPLIED BY CROSSLINK TECHNOLOGY INC., IS FURNISHED UPON THE EXPRESS CONDITION THAT THE PERSON RECEIVING THE PRODUCT SHALL MAKE THEIR OWN ASSESSMENT TO DETERMINE ITS SUITABILITY FOR THEIR PARTICULAR PURPOSE. NO WARRANTY IS EXPRESSED OR IMPLIED REGARDING SUCH INFORMATION, OR THE RESULTS TO BE OBTAINED FROM THE USE THEREOF; THAT ANY PRODUCT SHALL BE MERCANTABLE OR FIT FOR ANY PARTICULAR PURPOSE; OR THAT THE USE OF SUCH OTHER INFORMATION OR PRODUCT WILL NOT INFRINGE ANY PATENT.

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