



Epoxy and Polyurethane Tooling Compounds

Casting Compounds • Laminating Systems • Surface Coat Systems



Crosslink Technology Inc.
Epoxies, Urethanes • Custom Cast Parts

Epoxy and Polyurethane Tooling Compounds are formulated for improved heat transfer and are specifically suited to limited production quantities where the cost of permanent steel tooling can not be justified. Tooling can be manufactured utilizing aluminum or sealed wooden masters at considerably lower cost than having the complete tool made out of steel. Replacing worn tools is quick and easy.

Using Epoxy or Polyurethane Tooling Compounds is a fast and economical way to test and prove the accuracy of new part and tool designs before manufacturing steel production tooling. It is an excellent way to confirm the correct location for vent openings and pour holes etc. Many of these materials are also suitable for use as short run production tooling.

Benefits: High temperature operation capability / Low cost compared to steel or aluminum / Exceptional detail reproduction / Many products are machineable

Casting Compounds

System	Type	Pot Life	Hardness	Op. Temp.
CLR1260/XHD1303	Black for Tracing	3 Hours.	84D	60°C
CLR1296/XHD1303	Low Viscosity, General Purpose, Aluminum	3 Hours.	87D	80°C
CLR1299/XHD1303	General Purpose, Aluminum	3 Hours.	85D	100°C
CLR1299/CLH6330	General Purpose Aluminum	1 Hour.	87D	40-100°C
CLR1299/CLH6140	Mass Casting, Aluminum	2-3 Hours.	87D	60-100°C
CLR1296/CLH6040	High Temperature, Aluminum	45 Min.	87D	150°C

Laminating Systems

System	Type	Pot Life	Hardness	Op. Temp.
CLR1625/CLH6330	General Purpose Epoxy	20 Min.	85D	60°C
CLR1625/CLH6333	General Purpose Epoxy	10 Min.	85D	60°C
CLR1730/CLH6040	High Temp. Unfilled Epoxy	30 Min.	86D	150°C
CLR1292/CLH6040	High Temperature Epoxy (Al Filled)	30 Min.	86D	150°C
XRD1014/XHD1015	High Temperature Clear Epoxy	1 Hr.	85D	100°C

Surface Coat Systems

System	Type	Pot Life	Hardness	Op. Temp.
CLR1635/CLH6027	General Purpose White Epoxy	15 Min.	86D	70°C
CLR1632/CLH6027	General Purpose Blue Epoxy	15 Min.	86D	70°C
CLR1666/CLH6027	Abrasion Resistant Epoxy	20 Min.	87D	70°C
CLR1297/CLH6040	High Temperature Epoxy	40 Min.	87D	60°C
CLP7829/CLI4182	General Purpose Urethane	20 Min.	65/60D	100°C
CLI4175/CLH6104	General Purpose Urethane	20 Min.	65/60D	100°C



NEW! 3 Part Variable Hardness System

Abrasion Resistant System CLC AR-019 A/B
Standard Polyurethane System CLC 1V-019 A/B

	1	1	2	2	3	3	4	4	5	5	6	6	7	7						
MIX RATIO (By Weight)																				
COMPONENTS:	1	1	2	2	3	3	4	4	5	5	6	6	7	7						
1V or AR-019-A (Curative-1)	69.6	69.6	61.6	61.6	51.6	51.6	40.5	40.5	31.6	27.5	20.6	20.6	0	0						
1V or AR-019-B (Curative-2)	5.64	5.64	8.8	8.8	12.9	10.2	17.3	17.3	21.1	22.5	25.2	25.2	33.7	33.7						
1V or AR-019-C (Resin)	24.8	24.8	29.6	29.6	35.5	31.7	42.2	42.2	47.4	50	54.1	54.1	66.3	66.3						
Pot Life*: (Minutes)	18	18	14	14	10	12	8.5	8.5	7	6.5	6	6	4.5	4.5						
Gel Time:** (22°C)	30	30	25	25	16	20	11	11	7	6.5	6	6	5	5						
PHYSICAL PROPERTIES																				
Machine Mixed Samples:																				
Hardness (Shore)	30A	30A	40A	40A	43A	50A	50A	50A	60A	60A	60A	68A	80A	80A	84A	84A	90A	90A	91A	91A
100% Modulus (psi)	130	110	200	200	165	283	219	397	303	503	386	628	672	875	864					
200% Modulus (psi)	207	154	321	321	243	450	323	617	463	760	575	918	988	1200	1251					
300% Modulus (psi)	290	198	442	442	327	605	420	816	614	991	747	1178	1225	1450	1545					
UTS (psi)	350	333	527	527	486	800	1125	1300	981	1713	1242	2772	2860	4237	3239					
Ultimate Elongation (%)	350	534	367	367	506	460	970	582	520	531	551	657	732	679	664					
DIE 'C' Tear (pli.)	65	56	78	78	102	130	171	186	172	250	213	320	357	420	410					
Split tear (pli.)	10	14	13	13	16	18	39	30	33	40	36	84	100	140	131					
Compression Set (%)	45	21	45	45	35	51	35	52	34	61	34	64	44	76	52					
Taber Abrasion (mg)	413	24	539	539	32	283	68	456	50	492	57	308	56	251	108					
Bayshore Rebound (%)	55		63	63		61		64		57		54		52						

* Pot Life: Time to reach 100 poise (Brookfield Viscosity).

**Gel time: (200gm. mix @22°C)



Crosslink Technology Inc., established in 1981, operates two separate and distinct divisions serving customers with a variety of Epoxy and Polyurethane applications and custom cast electrical components. Both divisions are certified to ISO 9001 - 2000 quality standards.



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