

Room Cures

Typical Property Data

CURED FORM/ FILLER/ COLOR	TEMPERATURE CLASS	PRODUCT NUMBER	MIXING RATIO A/B	VISCOSITY ¹ @25°C (77°F) (Centipoise)	CURE SCHEDULES ² (Temp/Time)	GEL TIME ³ (Minutes)	HARDNESS ⁴
Flexible Unfilled Black	B	226	Wt 2:5 Vol (%) 23.6:75.4	A = 190 B = 750 Mixed = 650	23°C (73°F) 72 hrs. 67°C (152°F) 6 hrs.	15 min at 60°C (140°F)	75 Shore A
Rigid Unfilled Clear Amber	B	5	Wt 2:1 Vol (%) 63.5:36.5	A = 12,500 B = 100 Mixed = 3,000	23°C (73°F) 24-48 hrs. 60°C (140°F) 1 hr. 95°C (203°F) 1/2 hr.	18 min at 60°C (140°F)	15 Barcol
Semiflexible Unfilled Clear Amber Reddish Brown	B	8 208	Wt 1:1 Vol (%) 46:54	A = 12,500 B = 4,000 Mixed = 7,000	23°C (73°F) 24-48 hrs. 60°C (140°F) 2 hrs. 95°C (203°F) 1 hr.	30 min at 60°C (140°F)	68 Shore D.
Semiflexible Filled Cream	B	5237	Wt 3:4 Vol (%) 47:53	A = 12,500 B = 30,000 Mixed = 20,000	23°C (73°F) 24-48 hrs. 60°C (140°F) 2 hrs. 95°C (203°F) 1 hr.	15 min at 60°C (140°F)	80 Shore D.
Semiflexible Filled Reddish Brown	B	9	Wt 1:1 Vol (%) 47:53	A = 90,000 B = 20,000 Mixed = 28,000	23°C (73°F) 24-48 hrs. 60°C (140°F) 2 hrs. 95°C (203°F) 1 hr.	28 min at 60°C (140°F)	70 Shore D
Semiflexible Filled (paste) Reddish Brown	B	10 210	Wt 1:1 Vol (%) 48:52	A = paste B = paste Mixed = paste	23°C (73°F) 24-48 hrs. 60°C (140°F) 2 hrs. 95°C (203°F) 1 hr.	30 min at 60°C (140°F)	70 Shore D
Primer		5136					

Oven Cures

Typical Property Data – Unfilled Resins

Rigid Unfilled Brown	F	250	Wt 1:1 Vol (%) 50:50	A = 13,000 B = 130 Mixed = 1,800	75°C (167°F) 15-20 hrs. 95°C (203°F) 6-8 hrs. 120°C (248°F) 2-3 hrs.	17	25 Barcol
Rigid Unfilled Clear Amber	B	3	Wt 2:3 Vol (%) 37:63	A = 12,500 B = 400 Mixed = 1,600	77°C (167°F) 12-16 hrs. 95°C (203°F) 6-8 hrs. 120°C (248°F) 1-2 hrs.	21	80 Shore D
Semiflexible Unfilled Clear Amber	F	280	Wt 2:3 Vol (%) 37:63	A = 12,500 B = 2,500 Mixed = 4,000	75°C (167°F) 24 hrs. 95°C (203°F) 6-8 hrs. 120°C (248°F) 3-4 hrs.	20	73 Shore D
Semiflexible Unfilled Reddish-Brown	B	235	Wt 1:2 Vol (%) 31:69	A = 13,000 B = 1,000 Mixed = 1,800	75°C (167°F) 15-20 hrs. 95°C (203°F) 6-8 hrs. 120°C (248°F) 2-3 hrs.	18	55 Shore D

Filled Resins

CURED FORM/ FILLER/ COLOR	TEMPERATURE CLASS	PRODUCT NUMBER	MIXING RATIO A/B	VISCOSITY ¹ @25°C (77°F) (Centipoise)	CURE SCHEDULES ² (Temp/Time)	GEL TIME ³ 121°C (250°F) (Minutes)	HARDNESS ⁴
Rigid Filled Brown	F	251	Wt 1:1 Vol (%) 50:50	A = 175,000 B = 10,000 Mixed = 19,000	75°C (167°F) 15-20 hrs. 95°C (203°F) 6-8 hrs. 120°C (248°F) 2-3 hrs	20	40 Barcol
Semiflexible Filled Cream	F	MR283F075	Wt 5:1 Vol (%) 36.3:10	A = 40,000 B = 150 Mixed = 6,800	75°C (167°) 36-48 hrs. 95°C (203°F) 8-10 hrs. 120°C (248°F) 3-4 hrs.	30	80 Shore D
Semiflexible Filled Off-White	B	255	Wt 2:3 Vol (%) 39:61	A = 12,000 B = 40,000 Mixed = 25,000	82°C (180°F) 16-20 hrs. 121°C (250°F) 3-4 hrs.	21	72 Shore D
Semiflexible Filled Cream Black	F	281 5166	Wt 2:3 Vol (%) 37:63	A = 320,000 B = 38,000 Mixed = 75,000	75°C (167°F) 24 hrs. 95°C (203°F) 6-8 hrs. 120°C (248°F) 2-3 hrs.	21	73 Shore D
Semiflexible Filled Reddish-Brown Cream	B	241 243	Wt 1:2 Vol (%) 31:69	A = 175,000 B = 9,000 Mixed = 15,000	75°C (167°F) 15-20 hrs. 95°C (203°F) 6-8 hrs. 120°C (248°F) 2-3 hrs.	22	65 Shore D
Rigid Filled Thixotropic Reddish-Brown	F	252	Wt 1:1 Vol (%) 50:50	A = Thixotropic B = Thixotropic Mixed = Thixotropic	75°C (167°F) 15-20 hrs. 95°C (203°F) 6-8 hrs. 120°C (248°F) 2-3 hrs.	21	45 Barcol
Semiflexible Filled Thixotropic Cream	F	282	Wt 2:3 Vol (%) 37:63	A = Thixotropic B = Thixotropic Mixed = Thixotropic	75°C (167°F) 24 hrs. 95°C (203°F) 6-8 hrs. 120°C (248°F) 2-3 hrs.	23	73 Shore D
Semiflexible Filled Thixotropic Reddish-Brown	B	253	Wt 1:2 Vol (%) 30:70	A = Thixotropic B = Thixotropic Mixed = Thixotropic	95°C (203°F) 12-16 hrs. 120°C (248°F) 2-3 hrs.	25 min. @ 120°C (248°F)	65 Shore D

Test methods

¹ Brookfield Viscometer

² The cure times do not take into consideration the time necessary for the part and resin to reach the cure temperature. The user must determine this time and add it to the cure time at temperature.

³ 3M Test Method, using Sunshine Gel Timer

⁴ Shore A = Immediate per ASTM D 2240
Shore D = Immediate per ASTM D2240
Barcol = Immediate per Barcol Hardness Tester