



Product Data

## RenCast™ 3265/Ren® 3265 POLYURETHANE CASTING SYSTEM

**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 <sup>(1)</sup>
Gel time (14 fl.oz.)	D-2471	3 min.
Color Resin Hardener Mixed	Visual	Brown Pea green Brown
Viscosity, Mixed	D-2393	5,000 cP

<sup>(1)</sup>Tested @ 77°F (25°C)

## TYPICAL CURED PROPERTIES:

Property	ASTM Test Method	Test Values <sup>(1)</sup>
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	D-790	3,000
Flexural Modulus	D-790	0.40 x 10 <sup>6</sup>
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 <sup>-5</sup>
Shrinkage (in/in) Cast Mold #1	D-2566	0.005

<sup>(1)</sup>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.

## STORAGE/HANDLING INFORMATION:

### **RenCast 3265/Ren 3265**

Store at 70-90°F. 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 65°F (18°C) when mixing.

### **RenCast 3265**

Stir well before use. This material will separate. If crust has formed, product is no longer usable. Refer to MSDS for proper disposal.

### **Ren 3265**

Stir well before use. This material will separate.

**SHELF LIFE:** Provided materials are stored under the recommended storage conditions in their original containers, they will remain in useable condition for six months from date of shipping.

**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.

**SAFETY/HANDLING PRECAUTIONS:** Do not use or handle this product until the Material Safety Data Sheet has been read and understood.

**RenCast 3265**

**WARNING!** Harmful if inhaled. Causes skin and eye irritations. Causes allergic skin and respiratory reactions.

Avoid contact with eyes, skin, or clothing.  
Avoid breathing vapor or mist.  
Avoid prolonged or repeated contact with skin.  
Keep container closed. Use with adequate ventilation.  
Wash thoroughly after handling.

**Ren 3265**

**WARNING!** Causes skin and eye irritations.

Avoid contact with eyes, skin, and clothing.  
Wash thoroughly after handling.

Nuisance dust may be generated when sanding or sawing cured material.

**FIRST AID:** In case of contact with:

**Skin:** Immediately wash with soap and water. Remove contaminated clothing and launder before reuse. Destroy contaminated shoes.

**Eyes:** Immediately flush with water for at least 15 minutes. Call a physician.

**Ingestion:** If conscious, give plenty of water to drink. Do not induce vomiting. Call a physician.

**Inhalation:** Remove to fresh air. Administer oxygen or artificial respiration if necessary. Call a physician.

**Other:** Referral to physician is recommended if there is any question about the seriousness of any injury.

**PRECAUTIONARY NOTE:** Thermosetting systems generate heat when curing. The amount of heat and the period of time in which heat is released vary significantly between systems. Additionally, ambient or compound temperature, amount of material mixed, and construction and shape of the mold or container can also be factors in the temperature profile of a mixed system. In some cases, the thermosetting reaction can be vigorous, generating heat sufficient to cause decomposition of the system with subsequent liberation of large volumes of acrid smoke.

A good rule of thumb is never mix more material than can be applied during the stated pot life or gel time. Also take care when using materials in applications other than stated on the Product Data Sheet, i.e., a laminating resin for casting.

Please feel welcome to call our Product Information Department or your local Ren representative for instructions before you start your job.

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