



2102A RESIN 9244B, 9245B & 9246B HARDENERS

HIGH TEMPERATURE BLACK EPOXY SURFACE COAT

TECHNICAL DATA BULLETIN

SYSTEM BENEFITS:

CPD 2102A Resin with 9244B, 9245B and 9246B Hardeners are thixotropic, aluminum filled surface coat systems designed for use at elevated temperatures. The systems gels at room temperature, but requires a post cure to achieve maximum properties. The systems are excellent for wet lay-up/vacuum bagged parts, autoclaved parts, and compression molded parts.

- Surface coat
- High temp
- Aluminum filled

HANDLING PROPERTIES

| | CPD 9244B | CPD 9245B | CPD 9246B | Test Method |
|-----------------------------------|-------------|-------------|-------------|-------------|
| Resin Density at 25°C, lbs/gal | 10.4 | 10.4 | 10.4 | ASTM D1475 |
| Hardener Density at 25°C, lbs/gal | 8.4 | 8.5 | 8.4 | ASTM D1475 |
| Resin Viscosity at 25°C, cP | Thixotropic | Thixotropic | Thixotropic | ASTM D2196 |
| Hardener Viscosity at 25°C, cP | 100 | 975 | 450 | ASTM D2196 |
| Mix Ratio by Weight | 100A : 10B | 100A : 14B | 100A : 12B | Calculated |
| Mix Ratio by Volume | 8A : 1B | 6A : 1B | 6.7A : 1B | Calculated |
| Initial Mixed Viscosity 25°C, cP | Thixotropic | Thixotropic | Thixotropic | ASTM D2196 |
| Gel Time at 25°C, 150g mass, min. | 120 | 60 | 420 | ASTM D2471 |
| Sag Test 1/16 inch | Pass | Pass | Pass | Visual |
| Sag Test 1/8 inch | Fail | Fail | Fail | Visual |

PHYSICAL PROPERTIES

| | CPD 9244B | CPD 9245B | CPD 9246B | Test Method |
|---|-----------------------|-----------------------|-----------------------|-------------|
| Color | Black | Black | Black | Visual |
| Izod Impact, Notched, ft-lb/in | 1.03 | 1.09 | 1.11 | ASTM D256 |
| Tensile Strength, psi | 5,600 | 4,400 | 5,800 | ASTM D638 |
| Tensile Modulus, psi | 280,000 | 290,000 | 300,000 | ASTM D638 |
| HDT, Post Cure, °F | 300 | 282 | 320 | ASTM D648 |
| Service Temperature, °F | 325 | 300 | 350 | ASTM D648 |
| CTE, in/in/ °F | 3.60×10^{-5} | 3.60×10^{-5} | 3.60×10^{-5} | ASTM D696 |
| Compressive Strength, psi | 24,000 | 25,000 | 23,000 | ASTM D695 |
| Flexural Strength, psi | 8,700 | 8,500 | 8,900 | ASTM D790 |
| Flexural Modulus, psi | 305,000 | 310,000 | 310,000 | ASTM D790 |
| Cured Density, g/cm ³ (lbs/in ³) | 1.22 (0.044) | 1.22 (0.044) | 1.22 (0.044) | ASTM D792 |
| Volumetric Yield, in ³ /lb | 22.7 | 22.7 | 22.7 | ASTM D792 |
| Hardness, Shore D | 88 | 89 | 88 | ASTM D2240 |
| Linear Shrinkage, in/in | <0.002 | <0.002 | <0.002 | ASTM D2566 |



SYSTEM POST CURE OPTIONS:

Select one of the following cure schedules depending on the available time, the physical properties of the mold and the desired physical properties of the final part. Post cure the part to obtain maximum physical and thermal properties of the system. The recommended post cure temperature ramp rate between stages is up 5°F per minute for heating and down 1-2°F per minute for cooling. Heating and cooling ramp rates can vary based on size and thickness of the part. For larger thicker parts use a more conservative ramp. If you need to deviate from the recommended post cure schedule, please contact our technical service department.

CURE INCREMENTS:

| CPD 9244B, 9245B & 9246B | 24 Hours at 77°F (25°C) | 2 Hours at 150°F (66°C) | 2 Hours at 200°F (93°C) | 2 Hours at 250°F (121°C) | 2 Hours at 300°F (149°C) | 2 Hours at 350°F (177°C) | 4 Hours at 350°F (177°C) |
|--------------------------|-------------------------|-------------------------|-------------------------|--------------------------|--------------------------|--------------------------|--------------------------|
| Post Cure Option 1 | Supported | Supported | Supported | Supported | Supported | Supported | Supported |
| Post Cure Option 2 | Supported | Supported | | | | | Unsupported |

MIXING AND SURFACE PREP:

Always use the recommended mix ratio for the system. Do not deviate in an attempt to speed up or slow down gel time. Mix together thoroughly, scraping sides and bottom of mixing container, until no streaks or striations are visible, then use immediately. Use only clean dry tools for mixing and applying. Do not mix or apply below 60°F. All surfaces must be clean, dry, and free of any surface contamination. Molds and patterns should be treated with release or parting agents.

STORAGE AND CRYSTALLIZATION:

Store between 60-90°F in a dry place. After use, tightly reseal all containers and store products on a raised surface during cold weather and avoid storing near outside walls or doors. If available, Purge with dry nitrogen to preserve color and minimize moisture contamination. Do not allow to freeze during winter storage. Do not use material with any signs of crystallization such as solid chunks, grainy texture or white color. Crystallization can be reversed by heating the material to 125-140°F, and stirring occasionally, until all crystals dissolve.

SAFETY HANDLING:

Wear protective gloves, clothing, and eye/face protection. Use only outdoors or in a well-ventilated area. Avoid contact to the skin and eyes. Avoid breathing dust, fumes, gas mist, vapors and spray. Wash hands thoroughly after handling. Take off contaminated clothing and wash before reuse. These products may cause skin and respiratory allergic reactions. Consult product Safety Data Sheets for complete precautions for use of this product.

Polytek Development Corp. has experience only in the compounding of resins and hardeners and not in the actual manufacture of tools or parts. Each piece is different. The user should run tests to assure the suitability of the system for use in a particular application. The test data and results set forth herein are based on laboratory work and do not necessarily indicate the results that the buyer or user will attain.

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