



3727A RESIN 3955B HARDENER

EPOXY RESIN SYSTEM FOR FILAMENT WINDING
TECHNICAL DATA BULLETIN

SYSTEM BENEFITS:

CPD 3727A Resin with CPD 3955B Hardener is an amine-cured epoxy resin system designed for use in filament winding processes. It is ideally suited to the manufacture of high-performance composite parts for structural applications. CPD 3955B Hardener is a low-viscosity polyamine curing agent.

- Filament Winding
- High-Performance FRP Parts

HANDLING PROPERTIES

	CPD 3955B	Test Method
Resin Density at 25°C, lbs/gal	9.7	ASTM D1475
Hardener Density at 25°C, lbs/gal	7.8	ASTM D1475
Resin Viscosity at 25°C, cP	8,800	ASTM D2196
Hardener Viscosity at 25°C, cP	20	ASTM D2196
Mix Ratio by Weight	100A : 27B	Calculated
Mix Ratio by Volume	3A : 1B	Calculated
Initial Mixed Viscosity 25°C, cP	1,300	ASTM D2196
Gel Time at 25°C, 150g mass, min.	160	ASTM D2471

PHYSICAL PROPERTIES

	CPD 3955B	Test Method
Color	Clear	Visual
Izod Impact, Notched, ft-lb/in	1.25	ASTM D256
Tensile Strength, psi	11,900	ASTM D638
Tensile Modulus, psi	427,000	ASTM D638
Tensile Elongation, %	3.9	ASTM D638
Heat Deflection Temperature, °F	315	ASTM D648
Compressive Strength, psi	15,400	ASTM D695
Flexural Strength, psi	18,900	ASTM D790
Flexural Modulus, psi	448,000	ASTM D790
Density, Cured, g/cm ³ (lbs/in ³)	1.14 (0.041)	ASTM D792
Volumetric Yield, in ³ /lb	24.3	ASTM D792
Volumetric Shrinkage, %	3.4	ASTM D792/D1475
Hardness, Shore D	88	ASTM D2240



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:

	24 Hours at 77°F (25°C)	2 Hours at 120°F (49°C)	1 Hour at 140°F (60°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)
CPD 3955B								
Post Cure 1	Supported			Supported	Supported	Supported	Supported	Supported
Post Cure 2		Supported		Unsupported	Unsupported	Unsupported	Unsupported	Supported
Post Cure 3			Supported	Unsupported	Unsupported	Unsupported	Unsupported	Supported

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 Corporation 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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