



# 4281A RESIN 9250B, 9265B & 9297B HARDENERS

EPOXY RESIN SYSTEMS FOR INFUSION AND  
INJECTION  
TECHNICAL DATA BULLETIN

## SYSTEM BENEFITS:

CPD 4281A Resin with CPD 9250B, 9265B, or 9297B Hardener is a low viscosity epoxy laminating resin system designed for the infusion and RTM processes. The low viscosity and reactionary chemistry assures maximum wet-out of glass, carbon and Kevlar® fibers.

- Infusion
- Variable gel time
- Low viscosity

## HANDLING PROPERTIES

	CPD 9250B	CPD 9265B	CPD 9297B	Test Method
Resin Density at 25°C, lbs/gal	9.7	9.7	9.7	ASTM D1475
Hardener Density at 25°C, lbs/gal	7.9	7.9	7.9	ASTM D1475
Resin Viscosity at 25°C, cP	900	900	900	ASTM D2196
Hardener Viscosity at 25°C, cP	30	30	30	ASTM D2196
Mix Ratio by Weight	100A : 27B	100A : 27B	100A : 27B	Calculated
Mix Ratio by Volume	3A : 1B	3A : 1B	3A : 1B	Calculated
Initial Mixed Viscosity 25°C, cP	280	280	280	ASTM D2196
Gel Time at 25°C, 150g mass, min.	280	105	225	ASTM D2471

## PHYSICAL PROPERTIES

	CPD 9250B	CPD 9265B	CPD 9297B	Test Method
Color	Red-Brown	Amber	Amber	Visual
Izod Impact, Notched, ft-lb/in	1.12	1.15	1.13	ASTM D256
Tensile Strength, psi	10,200	11,100	10,300	ASTM D638
Tensile Modulus, psi	437,000	456,000	441,000	ASTM D638
Tensile Elongation, %	9.8	8.8	9.7	ASTM D638
Compressive Strength, psi	12,600	13,900	12,600	ASTM D695
Flexural Strength, psi	17,300	18,700	17,500	ASTM D790
Flexural Modulus, psi	388,000	409,000	394,000	ASTM D790
HDT, Room Temp Cure, °F	132	135	132	ASTM D648
HDT, Post Cure, °F	196	201	196	ASTM D648
Cured Density, g/cm <sup>3</sup> (lbs/in <sup>3</sup> )	1.15 (0.042)	1.15 (0.042)	1.15 (0.042)	ASTM D792
Volumetric Yield, in <sup>3</sup> /lb	24.0	24.0	24.0	ASTM D792
Volumetric Shrinkage, %	3.82	3.90	3.84	ASTM D792/2196
Hardness, Shore D	87	87	87	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:

CPD 9250B, 9265B & 9297B	48 Hours at 77°F (25°C)	7 Days at 77°F (25°C)	4 Hours at 120°F (49°C)	8 Hours at 180°F (49°C)
Room Temperature Cure	Supported	Unsupported		
Post Cure 1	Supported			Unsupported
Post Cure 2			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.

Polytek Development Corp. makes no warranty expressed or implied, including warranties of merchantability or fitness for a particular use. Under no circumstances will Polytek Development Corp. be liable for incidental, consequential or other damages, alleged negligence, breach of warranty, strict liability, tort or any other legal theory arising out of the use or handling of this product.

Revised April 2019



