



4282A RESIN 4302B HARDENER

FLAME RETARDANT EPOXY RESIN SYSTEM FOR HAND LAY-UP
TECHNICAL DATA BULLETIN

SYSTEM BENEFITS:

CPD 4282A Resin with CPD 4302B Hardener is an elevated temperature setting, medium service temperature, white, flame retardant epoxy compound that may be used in many diverse applications such as bonding, casting and laminating. It meets or exceeds the requirements of UL 94 V0 and FAR 25.853(a) of FAA standards.

- Laminating
- Elevated temp gel
- Flame retardant

HANDLING PROPERTIES

	CPD 4302B	Test Method
Resin Density at 25°C, lbs/gal	11.0	ASTM D1475
Hardener Density at 25°C, lbs/gal	10.0	ASTM D1475
Resin Viscosity at 25°C, cP	230,000	ASTM D2196
Hardener Viscosity at 25°C, cP	110	ASTM D2196
Mix Ratio by Weight	100A : 60B	Calculated
Mix Ratio by Volume	1.5A : 1B	Calculated
Initial Mixed Viscosity 25°C, cP	3,200	ASTM D2196
Gel Time at 85°C, 150g mass, min.	30	ASTM D2471

PHYSICAL PROPERTIES

	CPD 4302B	Test Method
Color	White	Visual
Izod Impact, Notched, ft-lb/in	1.07	ASTM D256
Tensile Strength, psi	3,600	ASTM D638
Tensile Modulus, psi	313,000	ASTM D638
Tensile Elongation, %	2.7	ASTM D638
HDT, Post Cure, °F	250	ASTM D648
Compressive Strength, psi	17,000	ASTM D695
Flexural Strength, psi	6,600	ASTM D790
Flexural Modulus, psi	672,000	ASTM D790
Hardness, Shore D	91	ASTM D2240
Linear Shrinkage, in/in	<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 4302B	2 Hours at 185°F (85°C)	8 Hours at 230°F (110°C)	4 Hours at 250°F (121°C)
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.

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