

RenCast™ 3266/Ren[®] 3266 FLEXIBLE CASTING SYSTEM

DESCRIPTION: RenCast 3266(Resin)/Ren 3266(Hardener) is a variable hardness, unfilled two-component epoxy casting system which cures at room temperature. The degree of hardness can be altered by varying the proportion of hardener to resin. RenCast 3266 can be cast in thicknesses up to one inch, and is ideally suited for applications requiring flexibility.

ADVANTAGES:

- Variable hardness
- Low viscosity

MIXING INSTRUCTIONS:

		<u>Resin/Hardener</u>		
Reaction Ratio	(weight)	55/45	50/50	45/55
	(volume)	100/100	100/120	100/150

Mixing: Stir each component thoroughly before use. Weigh each component accurately ($\pm 5\%$) into clean containers. Thoroughly mix resin and hardener together (minimum 3 minutes) scraping container sidewalls, bottom and mixing stick several times to assure a uniform mix.

TYPICAL MIXED PROPERTIES:

Property	ASTM Test Method	Test Values ⁽¹⁾		
		(55/45)	(50/50)	(45/55)
Gel time, 14 fl.oz.	D-2471	32 min.	35 min.	39 min.
Color, mixed	Visual	Amber	Amber	Amber
Viscosity, mixed	D-2393	2,500 cP	2,500 cP	2,500 cP

⁽¹⁾Tested @ 77°F (25°C)

TYPICAL CURED PROPERTIES:

Property	ASTM Test Method	Test Values ⁽¹⁾		
		(55/45)	(50/50)	(45/55)
Specific Gravity	D-792	1.12	1.10	1.10
Cubic inch per lb.	D-792	25.0	25.2	25.2
Hardness (Shore D)	D-2240	75	60	40
Ultimate Compressive Strength (psi)	D-695	14,000	2,600	Rubbery
Ultimate Flexural Strength (psi)	D-790	2,200	120	Rubbery
Flexural Modulus	D-790	0.08 x 10 ⁶	-	Rubbery
Ultimate Tensile Strength (psi)	D-638	2,000	520	Rubbery
Deflection Temperature (264 psi) (°F)	D-648	<77	<77	<77
Shrinkage (in/in) cast Mold #1	D-2566	0.002	0.002	0.002

⁽¹⁾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.

CURING INSTRUCTIONS: Although room temperature epoxies will normally set up to a rigid, demoldable state within 24 hours at room temperature (75°F ± 5°F), these systems reach their full cure after seven days at room temperature. A full cure can be accelerated by applying heat after the part has set rigid. We recommend a postcure of 150°F for a minimum of six hours. (Add to this adequate time to bring the part to the postcure temperature.) After cure, the part should be cooled at a slow rate so as not to shock the part thermally.

Uniform heat distribution is also required during postcure; concentrated heat, such as that directed from a lamp, can cause warp. An elevated temperature cure will slightly increase the shrinkage compared to a room temperature cure.

STORAGE/HANDLING INFORMATION:

RenCast 3266 and Ren 3266

Store at 60-100°F in a dry place. After use 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 3266

This product may crystallize upon storage. If crystallized, vent container and heat to 125-145°F until crystals dissolve. Stir well after product has liquefied.

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

PACKAGING: This product is available in the following package size(s):

- Small kit of 15# total weight,
- or pails of resin at 44# each, and pails of hardener at 40#.

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 3266

WARNING! Causes skin and eye irritation. May cause allergic skin reaction.

Avoid contact with eyes, skin, or clothing. Avoid prolonged or repeated contact with skin. Wash thoroughly after handling.

Ren 3266

DANGER! COMBUSTIBLE. CORROSIVE. Causes eye burns and skin irritation.

Keep away from heat and flame. Do not get in eyes. Avoid contact with skin and clothing. Avoid breathing vapor or mist. Keep container closed. Use with adequate ventilation. 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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Vantico A&T US, Inc.
RenShape Solutions
4917 Dawn Avenue
East Lansing, MI 48823 USA

Tel 517 351 5900
800 375 1363
www.renshape.com

Customer Service Hotline: 800 367 8793
Technical Inquiries: 800 759 7165
Product Literature: 800 955 5509