

Advanced Materials**RenLam[®] 4005R Resin
Ren[®] 1500H Hardener****HEAT-RESISTANT EPOXY LAMINATING SYSTEM**

- High Temperature Performance
- Unfilled
- Good Work Life

DESCRIPTION :

RenLam[®] 4005R resin/Ren[®] 1500H hardener epoxy laminating system is an unfilled, two-component material designed to perform at temperatures up to 300°F (149°C). Intermittent use is possible in the 300°F (149°C) to 350°F (177°C) range. Laminated tools built with RenLam[®] 4005R resin/Ren[®] 1500H hardener epoxy system can be constructed with regular hand lay-up techniques or vacuum bagged, if the tool is small enough to allow the operator to complete bagging and squeezing operations before the material starts to gel. The system gels at room temperature but must be postcured to achieve maximum strength. RenLam[®] 4005R resin/Ren[®] 1500H hardener epoxy laminating system is well suited for use in building vacuum-form, RTM, RIM and compression molds as well as other high-temperature tooling. The epoxy system can be utilized with large quantities of bulk fill, such as Ren[®] RP 39 aluminum grain for casting.

TYPICAL MIXED PROPERTIES*

Property	4005R/1500H	Test Method
Color	Amber	Visual
Viscosity, mixed, cP at 77°F (25°C)	1,900	ASTM-D-2393
Gel time, 4 fl. oz. at 77°F (25°C)	50-60	ASTM-D-2471

* Tested at 77°F (25°C)

MIX RATIO :

RenLam[®] 4005R resin:Ren[®] 1500H hardener
100:14 by weight
100:15 by volume

Stir each component thoroughly before use. Weight each component accurately (+5%) into clean containers. Thoroughly mix resin and hardener together (minimum of three minutes), scraping container sidewalls, bottom and mixing stick several times to assure a uniform mix.

TYPICAL CURED PROPERTIES :

	<u>Cure Value</u>	<u>Test-Method</u>
Specific Gravity (cast)	1.19	ASTM D-792
Cubic Inch per Pound	23.3	ASTM D-792
Hardness, Shore D	90	ASTM-D-2240
Ultimate Flexural Strength, at 77°F (25°C), psi (MPa)	35,000 (241)	ASTM-D-790
Flexural Modulus, at 77°F (25°C), psi (MPa)	1.6x10 ⁶ (11,034)	
Ultimate Tensile Strength, at 77°F (25°C), psi (MPa)	26,000 (179)	ASTM D-638
Tg by DMA, E", °F (°C)	338 (166)	ASTM D-4065
Ultimate Compressive Strength, at 77°F (25°C), psi (MPa)	28,000 (193)	ASTM D-695
Deflection Temperature (264 psi), °F (°C)	289 (143)	ASTM D-648
Coefficient of Thermal Expansion, in./in./°F	8.5 x 10 ⁻⁶	ASTM D-3386

Cure Schedule – Contact laminate, 10 oz. glass cloth, 90° rotation, postcured 24 hrs. at 77°F (25°C), + 2 hrs. at 150°F (66°C) + 2 hrs. 200°F (93°C) + 2 hrs. at 250°F (121°C) + 2 hrs. at 300°F (149°C), tested at 77°F (25°C).

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 :

With proper backup completed, allow to gel at room temperature followed by a postcure of two hours at 150°F (66°C) plus two hours at 200°F (93°C), plus two hours at 250°F (121°C), plus two hours at 300°F (149°C).

STORAGE/ SHELF LIFE :

Epoxy resins and hardeners should be stored in a dry place in their original, sealed containers at temperatures from 60-100°F (16-38°C). Material temperatures should be above 65°F (18°C) when mixing. After use, tightly reseal containers. Under these conditions, epoxy resins and hardeners will remain useable for 12 months from date of shipping from Huntsman.

CAUTION :

Huntsman Advanced Materials Americas Inc. maintains up-to-date Material Safety Data Sheets (MSDS) on all of its products. These sheets contain pertinent information that you may need to protect your employees and customers against any known health or safety hazards associated with our products. Users should review the latest MSDS to determine possible health hazards and appropriate precautions to implement prior to using this material. Copies of the latest MSDS may be requested by calling our customer service group at 800-367-8793 or emailing your request to adhesives_group@huntsman.com.

FIRST AID !

Eyes and skin : Flush eyes with water for 15 minutes. Contact a physician if irritation persists. Wash skin thoroughly with soap and water. Remove and wash contaminated clothing before reuse.

Inhalation : Remove subject to fresh air.

Swallowing : Dilute by giving water to drink and contact a physician promptly. Never give anything to drink to an unconscious person.

KEEP OUT OF REACH OF CHILDREN**FOR PROFESSIONAL AND INDUSTRIAL USE ONLY**

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