



## Crit Cast Dice Resin Product Specifications

### Hardening properties:

**Proportion SG:** 1.15 0.96

**Viscosity 25°C:** 500-1000 CPS 800 MAX CPS

### Conditions of Use:

**Mix Ratio:** A: B = 100:50 (Volume ratio)

### Hardening conditions:

25°C / 77°F = 2.5 hours initial curing time

25°C / 77°F = 4-6 hours full dry time

25°C / 77°F = 24 hours full hardening time

**Pot life:** 25°C / 77°F 35 min

**For optimal cure time Crit Cast Dice Resin should be cured with a small amount of heat applied during the curing process. 7°C / 44.6°F rise in temp will halve the above times. 7°C / 44.6°F lower temp. will double above times.**

For example:

Mix Ratio	Initial cure time	Full Dry Time	Full Hardening Time
18°C / 64.4°F	5 hours	8-12 hours	48 hours
25°C / 77°F	2.5 hours	4-6 hours	24 hours
32°C / 89°F	1.25 hours	2-3 hours	12 hours

### Working environment:

Please keep the plastic container clean. A, B components are strictly according to the volume ratio, accurately measured, and stir it evenly along the inner wall of the container clockwise until it is mixed for 3-5 minutes.

When the temperature is lower than 15°C/59°F or the humidity is more than 85%, please preheat part A to 30°C/86°F. This can be done by running the bottle under a hot tap.

After use, seal the lid, to avoid moisture absorption.

### Hardened property:

**Hardness:** <90 shore D

**Withstand voltage:** 22 KV/mm

**Bending strength:** 23 Kg/mm<sup>2</sup>

**Volume resistance:** 1x10<sup>15</sup> Ohm<sup>3</sup>

**Surface resistance:** 5X10<sup>15</sup> Ohm<sup>2</sup>

**Thermal conductivity:** 0.61 W/M.K

**Lure power loss:** 0.42 KHZ

**Heat distortion temperature:** 85C

**Water absorption:** <0.15%

**Compressive strength:** 13.4Kg/mm<sup>2</sup>

*The above performance data is typical data measured in a laboratory environment with a temperature of 25°C and a humidity of 40%. It is for customer reference only.*