

Hex Epoxy 306XR

Chemical Characteristics (neat resin)

Chemical Characteristic	Value	Tolerance	Method
Appearance	Part A : light tan opaque Part B : pale yellow to clear liquid		
Storage conditions	Store dry at +5°C to +35°C (40-95 F) Condition material to +18°C to 24°C (65-75F) before using		
Cure Temperature Range	> 10°C (50F)		
Mixing ratio (by weight)	100 parts A to 28.9 parts B Mixing the entire unit is recommended.		
Viscosity	Part A : 44, 000 cps at 25°C (77 F) Part B : 18 cps at 25°C (77 F)	± 6000 cps ± 5 cps	lab meas.
Density	1,14 g/cm ³	±5%	D792
Shelf life	2 years in original, unopened container		lab meas.
Pot Life	3 hours at 21°C (70 F)	±1 hr	lab meas.
Cure Time	5 days at 21°C (70 F)	±4 hrs	lab meas.
Gel Time	5 hours at 21°C (70 F)	±1 1/2 hrs	lab meas.
Tack free	16 hours at 21°C (70 F)	±4 hrs	lab meas.
Glass Transition Temperature (Tg)	7 days at 23°C (73 F), Tg = 48°C (117 F) 5 days at 23°C + 48 hrs at 60°C (140 F) Tg = 80°C (151 F)		DSC

Mechanical Properties

Mechanical Property	Value	Tolerance	ASTM Test Method
Tensile Strength	65 MPa (9.4 ksi)	±5 %	D638
Tensile Modulus	3560 MPa (516 ksi)	±5 %	D638
Elongation at Failure	3.5 %	--	D638
Flexural Strength	103 MPa (14.9 ksi)	±10 %	D790
Flexural Modulus	2920 MPa (423 ksi)	±10 %	D790

