

MAKOBOND CASTING RESIN 410

PRODUCT DESCRIPTION

Makobond CR 410 is a high aluminum filled casting resin that produces high quality parts. The high aluminum content provides good thermal conductivity with no hard settling. Finished parts are easily machinable while producing high quality parts.

PRODUCT HIGHLIGHTS

- HIGH ALUMINUM CONTENT
- NO HARD SETTLE
- GOOD THERMAL CONDUCTIVITY

PRODUCT CHARACTERISTICS

	CR 410A	CR 410B
Viscosity @ 25°C	200,000 cps.	50 cps
Specific Gravity	1.79	1.05
Color	Gray	Amber

HANDLING PROPERTIES

Casting Resin 410	
Mix Ratio By Weight, Resin, Hardener	100:8.5
Mix Ratio By Volume, Resin, Hardener	6.9:1
Mixed Viscosity @ 25°C	80,000 cps.
Pot Life @ 25°C	55-65 minutes

PHYSICAL PROPERTIES

	Results	ASTM Method
Cured Hardness (Shore D)	85-89D	D2240
Flexural Strength (psi)	6,500 psi	D790
Compressive Strength (psi)	15,968 psi	D695
Tensile Strength (psi)	9,725 psi	D638
Shrinkage, in/in (Vol.: 0.344 gal)	0.0005	D2566

HANDLING AND CURING

Measure out the proper weights of CR 410 and mix until uniform and no streaks are present throughout. Be sure to scrape the sides and bottom on mixing container to avoid any unmixed material. CR 410 will cure at room temperature and castings can be demolded in 18-24 hours dependent on shop temperature.

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PACKAGING WEIGHTS

	Quart Kit	Gallon Kit	Pail Kit	Drum Kit
CR-410A	3.5 lbs	12 lbs	48 lbs	525 lbs
CR-410B	0.3 lbs	1 lbs	4 lbs	45 lbs
CR-410 Kit	3.8 lbs	13 lbs	52 lbs	570 lba

STORAGE AND SAFETY

Measure out the proper weights of CR 410 and mix until uniform and no streaks are present throughout. Be sure to scrape the sides and bottom on mixing container to avoid any unmixed material. CR 410 will cure at room temperature and castings can be demolded in 18-24 hours dependent on shop temperature. Warning: All thermosetting matrix systems undergo exothermic reaction during vulcanization and/or curing, generating heat. If not properly managed, exothermic reactions may release possibly flammable or toxic gases into the surrounding. Users should exercise extreme caution when blending large volumes of ingredients (ie greater than 1 lb), and/or curing thick sections of components (typically greater than 0.200 inches). Users should monitor heat profiles of any curing or blended materials carefully and attentively during cure. Please contact a Mako team member with any concerns prior to use and/or to coordinate the proper management of safety and temperature monitoring process to avoid exothermic phenomena.