

MAKOBOND CASTING RESIN 420

PRODUCT DESCRIPTION

Makobond CR 420 is an aluminum-filled casting resin that is meticulously engineered to produce top-tier parts with exceptional quality. The final products exhibit excellent machinability, ensuring consistent, high-quality results. Moreover, this system boasts superior toughness, rendering it particularly well-suited for applications demanding durability and impact resistance. Its outstanding bonding capabilities elevate its suitability for a broad spectrum of casting and molding applications, enhancing the overall performance of the finished parts. This resin's formulation has been optimized to provide excellent flow properties, ensuring intricate molds are filled accurately and efficiently. Additionally, its high thermal conductivity facilitates rapid curing, reducing production time and increasing efficiency.

PRODUCT HIGHLIGHTS

- HIGH ALUMINUM CONTENT
- NO HARD SETTLE
- EXCELLENT BONDING

PRODUCT CHARACTERISTICS

	CR 420A	CR 420B
Viscosity @ 25°C	200,000 cps.	90 cps
Specific Gravity	1.79	1.02
Color	Gray	Amber

HANDLING PROPERTIES

Casting Resin 420	
Mix Ratio By Weight, Resin, Hardener	100:7
Mixed Viscosity @ 25°C	65,000 cps
Pot Life @ 25°C	60-70 minutes

PHYSICAL PROPERTIES

	Results	ASTM Method
Cured Hardness (Shore D)	92D	D2240
Flexural Strength (psi)	16,200 psi	D790
Compressive Strength (psi)	15,702 psi	D695
Tensile Strength (psi)	8,503 psi	D638

HANDLING AND CURING

Measure out the proper weights of CR 420 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 420 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
CR-420A	4 lbs	12 lbs	50 lbs
CR-420B	0.3 lbs	0.84 lbs	3.5 lbs
CR-420 Kit	4.3 lbs	12.84 lbs	53.5 lbs

STORAGE AND SAFETY

Measure out the proper weights of CR 420 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 420 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.