

MAKOBOND LAMINATE RESIN 308

PRODUCT DESCRIPTION

Makobond LR 308 is a low viscosity, unfilled laminate resin designed to service a variety of production parts and its components. The low viscosity is ideal for a fast wet out of fabrics for production parts. LR 308 is an easy-to-use product that produces parts with a long service life.

PRODUCT HIGHLIGHTS

- EASY HANDLING
- VERSATILE SYSTEM
- LONG LASTING PARTS

PRODUCT CHARACTERISTICS

	LR 308A	LR 308B
Viscosity @ 25°C	10,000 cps	30 cps.
Specific Gravity	1.15	0.96
Color	Amber	Amber

PHYSICAL PROPERTIES

	Results	ASTM Method
Cured Hardness (Shore D)	88-90D	D2240
Flexural Strength (psi)	46,492 psi	D790
Flexural Modulus (psi)	2,162,138 psi	D790
Compressive Strength (psi)	14,496 psi.	D695
Tensile Strength (psi)	35,229 psi	D638
Tensile Modulus (psi)	2,308,426 psi	D638
Glass Transition Temperature, T _g , (DMA)	260°F	D4065

HANDLING PROPERTIES

Laminate Resin 308	
Mix Ratio By Weight, Resin, Hardener	100:24
Mix Ratio By Volume, Resin, Hardener	3.5:1
Mixed Viscosity @ 25°C	1,000 cps.
Pot Life @ 25°C	85-105 minutes

HANDLING AND CURING

Measure out the proper weights of LR 308 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. Allow laminate to cure completely before delamination. A quick heat cure will expedite processing for LR 308. About 4 hours at 180°F is sufficient for a full cure of LR 308. If no oven is available, LR 308 will cure completely at room temperature.

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PACKAGING WEIGHTS

	Quart Kit	Gallon Kit	Pail Kit	Drum Kit
LR-308A	2 lbs	8 lbs	40 lbs	500 lbs
LR-308B	0.5 lbs	1.9 lbs	9.6 lbs	120 lbs
LR-308 Kit	2.5 lbs	9.9 lbs	49.6 lbs	620 lbs

STORAGE AND SAFETY

Makobond LR 308 has a shelf life of 12 months from date of shipment when unopened and stored at ambient temperatures, (18-27°C). Nitrogen purging opened containers is recommended before re-sealing. LR 308B may darken over time, but this will have no effect on any finished product. Users need to exercise proper care while working with material; gloves, eyewear, and proper ventilation are recommended. 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.