

MAKOBOND LAMINATE RESIN 325

PRODUCT DESCRIPTION

Makobond LR 325 is a white room temperature laminate resin designed to produce durable tools. The LR 325 system provides deep penetration of various fabrics and leaves no voids in tools. LR 325 has excellent chemical resistance making it ideal for most applications.

PRODUCT HIGHLIGHTS

- EASY MIXING
- VERSATILE SYSTEM
- DURABLE PARTS
- ROOM TEMP CURE

PRODUCT CHARACTERISTICS

	LR 325A	LR 325B
Viscosity @ 25°C	5,000 cps.	800 cps.
Specific Gravity	1.47	1.02
Color	White	Amber

HANDLING PROPERTIES

Laminate Resin 325	
Mix Ratio By Weight, Resin, Hardener	100:15
Mix Ratio By Volume, Resin, Hardener	4.6:1
Mixed Viscosity @ 25°C	4,000 cps.
Pot Life @ 25°C	25-35 minutes

PHYSICAL PROPERTIES

	Results	ASTM Method
Cured Hardness (Shore D)	86-90D	D2240
Flexural Strength (psi)	31,460 psi	D790
Compressive Strength (psi)	15,071 psi	D695
Tensile Strength (psi)	29,228 psi	D638
Glass Transition Temperature, Tg, (DMA)	210°F	D4065

HANDLING AND CURING

Measure out the proper weights of LR 325 and mix until uniform and no streaks are present throughout. Be sure to scrape the sides and bottom on mixing container to avoid unmixed material. Allow laminate to cure completely before delamination. LR 325 should be left at ambient temperature for 24 hours prior to any heat cure avoid shrinkage. After 24 hours, a slight cure for 2 hours at 150°F is sufficient for to obtain full properties of LR 325.

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PACKAGING WEIGHTS

	Quart Kit	Gallon Kit	Pail Kit	Drum Kit
LR-325A	2 lbs	9 lbs	45 lbs	500 lbs
LR-325B	0.3 lbs	1.35 lbs	6.75 lbs	75 lbs
LR-325 Kit	2.3 lbs	10.35 lbs	51.75 lbs	575 lbs

STORAGE AND SAFETY

Makobond LR 325 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 325B 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.