



Rhino™ R-908SC-HT

High Temperature Epoxy Face Coat

Data Sheet



ISO 9001:2000
FM62236

Resin – Part # R-908SC-HT
Hardener – Part # 3102, 3136-R-1, 3137

DESCRIPTION:

Rhino R-908SC-HT (black) high temperature face coat is a Bis-F Novolac, high functionality epoxy resin. Designed for ambient cures and high temperature applications, 908SC brushes on easily to intricate mold and pattern shapes without sagging or draining. Rhino 908SC-HT's surface is impact resistant and may be sanded or polished. Rhino R-908SC-HT is solvent-free, 100% solids, and DOT non-regulated.

SUGGESTED USES:

Epoxy face coatings on intricate patterns and molds. Ambient cures with H-3102 and 3136-R1 hardeners. High temperature applications (275°F – 350°F) with H-3137 hardener.

PROPERTIES OF RHINO R-908SC-HT EPOXY RESIN:

Viscosity	Thixotropic
Weight/Gal	12.0 – 12.2lbs per gallon
Color	Black

MIXING:

Use and store between 65° – 80°F. Surfaces must be free of contaminants such as dirt, oil, grease, or water. Wax or “release” mold surfaces before epoxy application. Mix Rhino 908SC with any listed hardener at 100:12 by weight. Recommend mixing smaller batches H-3102 due to its brief pot-life.

CURING:

Allow applied 908SC to cure past the tacky stage (see thin film set time), then immediately apply backup laminates. Once laminate schedule is completed, cure the structure at ambient temperature (65° – 80°F) overnight. Then post-cure at 130°F for 4 hours followed by a ramping schedule that increases temperature in 50°F increments for 1 hour to the intended service temperature or the limits of the backup laminate's HDT.

PHYSICAL PROPERTIES OF RHINO R-908SC-HT WITH RHINO HARDENERS:

Rhino R-908SC-HT (black)	w/ Rhino 3102	w/ Rhino 3136-R1	w/ Rhino 3137
Mix Ratio, PHR, (WT)	100:12	100:20	100:12
Gel Time, Minutes, 77°F	15	30	40
Thin Film Set Time, Hrs, 77°F	2	2.5	4
Cure Temperatures, °F	77/130/180/225	77/130/180/225/285	77/130/180/225/275/325
HDT F, Ambient Cure	175	195	-
HDT F, Post-cure	225	280	350

HOW SUPPLIED:

FOB Rhino Linings San Diego, CA or authorized distributors. R-908SC: 10lb Gallons, 50lb Pails and 500lb special order drums. H-3102, 3136-R1, and 3137: 2lb Quarts, 8lb Gallons and 40lb Pails.

SAFETY PRECAUTIONS:

Health Considerations: Consult the Rhino Linings® Material Safety Data Sheets.

This chemical system requires the use of proper safety equipment and procedures. Please follow the Rhino Linings® product MSDS and Safety Manual for detailed information and handling guidelines.

For Your Protection:

The information and recommendations in this publication are, to the best of our knowledge, reliable. Suggestions made concerning the products and their uses, applications, storage and handling are only the opinion of Rhino Linings

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SAFETY PRECAUTIONS of Rhino™ R-908SC-HT (continued):

Corporation. Users should conduct their own tests to determine the suitability of these products for their own particular purposes and of the storage and handling methods herein suggested. The toxicity and risk characteristics of products made by Rhino Linings Corporation will necessarily differ from the toxicity and risk characteristics developed when such products are used with other materials during a manufacturing process. The resulting risk characteristics should be determined and made known to ultimate end-users and processors. Because of numerous factors affecting results, **Rhino Linings Corporation makes no warranty of any kind, express or implied**, other than that the material conforms to its applicable current Standard Specifications. Rhino Linings Corporation hereby disclaims any and all other warranties, including but not limited to those of merchantability or fitness for a particular purpose. No statements made herein may be construed as a representation or warranty. The liability of Rhino Linings Corporation for any claims arising from or sounding in breach of warranty, negligence, strict liability, or otherwise shall be limited to the purchase price of the material.

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