

### APPLICATIONS

Negatives, molds, masters and mock-ups using the unfilled product or filled with RZ 30150 mineral filler in order to avoid an exothermic reaction and to get easy machining.

Thermoforming masters using the product filled with RZ 209/6 aluminium powder in order to increase thermal conductivity.

### PROPERTIES

- Quick setting system
- Low viscosity
- Good temperature resistance after heat curing
- Easy-to-use mix ratio (1:1 by weight)
- Adjustable filler content

PHYSICAL PROPERTIES					
Composition		POLYOL	ISOCYANATE	UNFILLED MIXING	MIXING FILLED WITH RZ 30150
Mixing ratio by weight		100	100		300
Aspect		liquid	liquid	liquid	liquid
Color		off white	amber	beige	beige
Viscosity at 25°C (mPa.s)	BROOKFIELD LVT	170	59	90	1.700
Density of parts before mixing	ISO 1675 : 1985	1.00	1.10	-	-
Density of cured mixing at 23°C	ISO 2781 : 1996	-	-	1.08	1.61
Pot life at 25°C on 200g (min)	Gel Timer TECAM			2'30	3'30

MECHANICAL PROPERTIES AT 23°C (1)			
			UNFILLED MIXING
Hardness	ISO 868 : 2003	Shore D1	77
Flexural modulus of elasticity	ISO 178 : 2010	MPa	1289
Flexural strength	ISO 178 :2010	MPa	57
Charpy impact resistance <i>Unnotched test tubes</i>	ISO 179/1eU :1994	kJ/m <sup>2</sup>	15

(1) : Average values obtained on standardized specimens / Hardening 14 hours at 60°C.

THERMAL AND SPECIFIC PROPERTIES (1)			
			UNFILLED MIXING
Glass transition temperature	ISO 11359-2 : 1999	°C	112
Demolding time at 25°C			
- thickness : 10 mm	-	min	30
- thickness : 40 mm		min	-
FILLED MIXING			
Linear shrinkage on:			
- 200x70x5 mm sample	-	mm/m	0.25
- 1000x50x50 mm sample			2.6

## PROCESSING CONDITIONS

Before use the polyol must be mixed until both color and aspect become homogeneous. The polyol and the Isocyanate must be mixed at a temperature equal or above 18°C according to the mix ratio indicated on this technical data sheet.

For casting thicknesses above 5 mm it is recommended to add a filler as follows:

- up to 350 phr of RZ 30150 filler (mineral filler)
- up to 350 phr of RZ 209/6 filler (aluminium powder)

For thicknesses up to 40 mm maximum.

## HANDLING PRECAUTIONS

Normal health and safety precautions should be observed when handling these products:

- ensure good ventilation,
- wear gloves and safety glasses.

For further information, please consult the product safety data sheet.

## STORAGE CONDITIONS

Shelf life of both components is 12 months in a dry place and in their original unopened containers at a temperature between 15 to 25°C. Any open must be tightly closed under dry inert gas (dry air, nitrogen, etc.).

## PACKAGING

POLYOL	ISOCYANATE	KIT
6 x 0.9 Kg 1 x 4.5 Kg 1 x 18 Kg 1 x 180 Kg	6 x 0.9 Kg 1 x 4.5 Kg 1 x 18 Kg 1 x 180 Kg	6 x (0.9+0.9) Kg 1 x (4.5+4.5) Kg 1 x (18+18) Kg

## GUARANTEE

Information of our technical data sheet is based on our present knowledge and the result of tests conducted under precise conditions. It is the responsibility of the user to determine the suitability of AXSON products for his application under his own conditions. AXSON refuses any guarantee about the compatibility of a product with any particular application. AXSON disclaims all responsibility for damage from any incident which results from the use of these products. The guarantee conditions are regulated by our general sale conditions.