



PX 5213

PMMA QUALITY - MERCURY FREE

The mercury free PX 5213 allows the rapid manufacturing of transparent parts with wall thickness up to 100 mm. It is used for decorative applications as well as technical parts.

- High optical surface quality
- Good workability
- High reproducibility
- UV stable and high transparent
- Easy pigmentation
- Low odour and solvent-free
- Up to 100 mm casting thickness

PX 5213

POLYURETHANE VACUUM CASTING SYSTEM FOR TRANSPARENT PIECES IN RAPID MANUFACTURING

Areas of application

- Transparent parts
- Imitation of jewelry articles and crystals
- Decorative parts
- Trophies

Product benefits

- Wall thickness up to 100 mm
- High transparent
- UV stable
- Polishable
- High reproducibility
- Good workability

Moulds for PX 5213

Silicone ESSIL 291 with dry catalyst ESSIL 291 is particularly suitable for PX 5213 moulds and gives the best surface quality.

Finishing of PX 5213

After full curing use same polishing tools and process than for PMMA.

Physical Data (approx. values)

Colour	Transparent
Density (g/cm ³)	1,06
Shore hardness	D 86
Tensile strength (MPa)	68
Elongation at break (%)	6
Impact resistance (CHARPY - kJ/m ²)	42
Glass Transition Temperature (°C)	100
Heat distortion temperature (°C)	85
Maximum of casting thickness (mm)	100

Processing Data

Mixing ratio in parts by weight	100 : 62
Mixed Viscosity, 25° C (mPa*s)	500
Pot life (min)	20
Demoulding time, 70° C - 100 mm (min)	45
Demoulding time, 70° C - < 5 mm (h)	3

Please see the current technical data sheet for further information.

Codification*	Sika material number	Axson material number
PX 5210-PX 5213; 3(1+0,62)	523957	09291
PX 5210; Iso; 5kg	526574	08345
PX 5213; Polyol; 3,10 kg	526573	09474

* available at the production sites SikaAxson France, SOA and SikaAxson Germany, Stuttgart

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