




PROTOTYPING SYSTEMS

POLYURETHANES & MOLD MAKING SILICONES

EASY PROCESSING ▪ DURABLE ▪ EXCEPTIONAL PROPERTIES

PROTOTYPING POLYURETHANE SYSTEMS

Product	Brand	Flexural Modulus (psi)	Pot Life (min/g)	Tg (°F)	Shore Hardness	Cured Color	Description & Applications
PX 1000 NA		200,000	17/200	167	78 D	off-white	Casting system for simulating thermoplastic-like parts, mock ups, and prototypes
TCC-8020/8021		237,500	17/150	140	75 D	white	System for simulating RIM parts, polypropylene parts with thermoplastic characteristics, fastcast, and rapid prototyping
PX 523/PX 5210		321,000	17/156	237	85 D	clear	UV-resistant system for crystal clear, glass/polycarbonate-like, mock up, and prototype parts for high temp applications
PX 223 HT		334,000	6/90	248	80 D	black	System for parts out of HIPS with superior heat and impact resistance




PROCESSING RECOMMENDATIONS

Based on using a preheated silicone mold (≈158°F/70°C)

Not Recommended	Could lead to surface imperfections, bubble entrapment & void space, resulting in loss of optical brilliance
Satisfactory	Brilliant against bottom mold surface, but potential for voids/imperfections in geometrically challenging designs, especially walls & top surface of the casted part
Recommended	Brilliant aspect for all surfaces of the casted part with very low potential for the loss of optical brilliance and/or the entrapment of air
Best	Stunning surfaces and highest obtainable level of optical brilliance with part free of entrapped air

Product	Open Casting	Open Casting/ Pressure Pot	Vacuum Degas/ Open Casting	Vacuum Degas/ Pressure Pot	Vacuum Chamber/Oven
PX 1000 NA	Satisfactory	Recommended	Satisfactory	Recommended	Best
TCC-8020/8021	Satisfactory	Recommended	Satisfactory	Recommended	Best
PX 523	Not Recommended	Not Recommended	Not Recommended	Recommended	Best
PX 223 HT	Satisfactory	Recommended	Satisfactory	Recommended	Best

MOLD MAKING SILICONES

Product	Brand	Shore Hardness	Tear Resistance (ppi)	Cured Color	Mixed Viscosity	Description & Applications
ESSIL 125 NA		30 A	100	white or blue	20,000	Condensation (tin) cure silicone for resin casting, fastcast urethanes, and epoxies. Offered with 2 hardener options
AX-SIL 4240		38 A	120	translucent	40,000	Addition (platinum) cure silicone ideal for reproducing intricate details. Maintains close tolerances for mold-making from 3D printers
ESSIL 245-255		53 A	75	gray	25,000	Addition (platinum) cure silicone with high strength and excellent release for pattern/model shop mold making and tooling applications

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