

## Biresin® U1419 with Biresin® U1419L Elastomeric casting resin for foundry pattern making

### Areas of Application

- Casting of abrasion and impact resistant mouldings and tools, e. g. smaller core boxes
- Casting of tough-elastic coatings

### Product Benefits

- Insensitive to moisture
- Good abrasion resistance
- Good impact resistance and tensile strength
- Good flowability
- Short demoulding time
- Good temperature resistance
- Dyeable with **Biresin® Colour Paste**
- **Biresin® U1419L** for increased potlife

### Description

- Basis Two component PUR system
- Component A **Biresin® U1419**, isocyanate prepolymer, colourless-transparent, unfilled
- Component B **Biresin® U1419**, amine, brownish-transparent, unfilled
- Component B **Biresin® U1419 L**, amine, reddish-transparent, unfilled

Component Properties	Viscosity (mPa.s)	Density (g/ml)
<b>Biresin® U1419 (A)</b>	~4,200	1.01
<b>Biresin® U1419 (B)</b>	~200	1.02
<b>Biresin® U1419L (B)</b>	~500	1.20

### Processing Data

Mixing ratio A : B in parts by weight	Component A	<b>Biresin® U1419</b>	100	100	100	100
	Component B	<b>Biresin® U1419</b>	16	12	8.5	5.4
		<b>Biresin® U1419 L</b>	0	4	8.5	12.6
Mixed viscosity, 25°C	mPa.s	~ 2,800				
Potlife, 500g / RT	min	7	10	15	25	
Demoulding time, RT	h	1 - 3	3 - 5	5 - 10	12 - 16	
Curing time, RT	d	3 - 5		5 - 7		

### Physical Data (approx. values)

Mixing ratio A : B in parts by weight	Component A	100	100	100	100
	Component B mixture	16	16	17	18
Colour	coloured-transparent*				
Density	ISO 1183 g/cm³	1.1			
Shore hardness	ISO 868 -	A98/D54	D 52	D 47	D 47
Tear resistance	ISO 34 N/mm	68	65	71	73
Tear strength	ISO 527 MPa	25	27	22	19
Elongation at break	ISO 527 %	375	480	630	690

\* dependent on raw materials the colour can differ without changing the mechanical properties

## Packaging

Working packages	<b>Biresin® U1419 AB Pack</b>	6 x 1 kg net resin + 6 x 0.16 kg net hardener in a box
Individual components	<b>Biresin® U1419 (A)</b> <b>Biresin® U1419 (B)</b> <b>Biresin® U1419L (B)</b>	200 kg; 10 kg; 1 kg net 16 kg; 1.6 kg net 5 kg; 0.9 kg net

## Processing

- The material, processing and mould temperature must be from 18 to 25°C.
- It is possible to add Biresin® Farbpaste to the B component before processing if required.
- Pay attention to dry conditions and dry mould surfaces while processing.
- The resin and hardener components are to be mixed thoroughly and poured immediately into previously released moulds (e.g. with Sika® Liquid Wax-815 resp. Sika® Pasty Wax-818; for more information see product data sheet).
- Porous surfaces (wood, gypsum) have to be well sealed before processing.

## Storage

- Minimum shelf life is 12 month under room conditions (18 - 25°C), when stored in original un-opened containers.
- After prolonged storage at low temperature, crystallisation of components may occur. This is easily removed by warming up for a sufficient time to a maximum of 70°C. Allow to cool to room temperature before use.
- Containers must be closed tightly immediately after use to prevent moisture ingress. The residual material needs to be used up as soon as possible.

## Health and Safety Information

For information and advice on the safe handling, storage and disposal of chemical products, users shall refer to the most recent Safety Data Sheet (SDS) containing physical, ecological, toxicological and other safety related data.

## Disposal considerations

Product Recommendations: Must be disposed of in a special waste disposal unit in accordance with the corresponding regulations.

Packaging Recommendations: Completely emptied packagings can be given for recycling. Packaging that cannot be cleaned should be disposed of as product waste.

## Value Bases

All technical data stated in this Product Data Sheet are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

## Legal Notice

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