

APPLICATIONS

Suitable for the production of flexible prototype parts, temperature-stressed parts in the engine compartment, bellows, antivibration parts, gaskets and sealing seams, sealing lips and other flexible components when higher temperature resistance and self-extinguishing characteristics are required.

ÜBERSICHT

- very good temperature resistance up to 120 °C
- self extinguishing
- good mechanical properties
- mercury free, RoHS-compliant

PHYSICAL PROPERTIES				
Composition	-	PX 755 ISOCYANATE	PX 755 POLYOL	MIXING
Mix ratio by weight	-	10	100	-
Color	-	dark amber	black	black
Aspect	-	liquid	liquid	liquid
Viscosity at 25 °C (mPa·s)	BROOKFIELD LVT	125	2 750	2 400
Specific density at 25 °C (g/cm ³)	ISO 1675 : 1988	1,31	1,22	-
Density at 23 °C (after curing) (g/cm ³)	ISO 2781 : 1988	-	-	1,30
Pot life at 25 °C for 110 g (min)	Gel Timer TECAM	-	-	30 **

PROCESSING (Vacuum casting machine)

- heat silicon mold to +40 up to +70 °C and resin parts to +18 °C to + 25 °C **.
- The Isocyanate has to be shaken well before use. The Polyol has to be stirred up very well before use and has to be processed immediately after (as it contains a high percentage of functional filler)
- Before casting, ensure that molds are free from humidity.
 - Fill the Isocyanate into the upper cup (IMPORTANT: don't forget the cup's rest*).
 - Fill the Polyol into the lower mixing cup.
- Degas both parts separately if necessary.
- In compliance with the mix ratio*, mix both parts for ca. 60 s and then cast in the preheated mold.
- For curing, let silicone mold in the oven at 70 °C for 2-4 h.
- Open the mold, but let the part inside. Cool down to room temperature and then demold.

* **IMPORTANT:** Unprecise weighing leads to improper curing and soft and sticky parts. We recommend to fill some isocyanate into the cup and put it back into the bottle. Then put the cup (including the cup's rest) back on the scale and fill in the needed amount of Isocyanate.

** **BE CAREFUL:** Pot life depends on mixing amount and temperature of the resin parts. A deviation of e.g. + 10 °C results in a halving to third reduction of pot life.

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.

MECHANICAL PROPERTIES AT 23 °C (1)

Hardness	ISO 868 : 2003	Shore A1 / A15	55 / 54
Tensile strength	ISO 37 : 2004	MPa	2,1
Elongation at break		%	267
Tear strength	ISO 34 : 1994	kN/m	10

THERMAL AND SPECIFIC PROPERTIES (1)

Use temperature range	-	°C	-40 to +120 °C
Demolding time - at 23 °C for 200 g - at 70 °C in silicone mold, for 3-5 mm thickness	-	h	12 - 24 2-4
Fire Behaviour	UL 94 : 1979	6 mm 2 mm	V0 V2

(1) Average values, determined at standard specimen after 24 h curing at 23 °C and 16 h at 80 °C.

STORAGE

Shelf life of polyol is 6 months; shelf life of isocyanate is 12 months in a dry place and in their original unopened containers at a temperature between +15 and +25 °C. Any open can must be tightly closed under dry nitrogen gas.

PACKAGING

PX 755 ISOCYANATE 1x 0,5 kg	PX 755 POLYOL 1x 5 kg
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GUARANTEE

The 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, under their own conditions before commencing with the proposed application. AXSON refuse any guarantee about the compatibility of a product with any particular application. AXSON disclaim 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.