

## DESCRIPTION

Used by casting in silicon moulds for making prototype parts and flexible mock-ups.

## PROPERTIES

- Fast demoulding
- High reproduction accuracy
- « Moulded rubber » aspect
- Abrasion resistance
- Max. peak temperature: 100 °C (see ageing results page 2)

PHYSICAL PROPERTIES				
Composition		PART A ISOCYANATE	PART B POLYOL	MIXED
Mix ratio by weight		100	45	
Aspect		liquid	liquid	liquid
Colour		colourless	amber	amber
Viscosity at 25°C (mPa.s)	BROOKFIELD LVT	3,000	200	1,500
Specific gravity at 25°C (g/cm <sup>3</sup> )	ISO 1675 : 1985	1.05	0.98	-
Specific gravity of cured product at 23°C	ISO 2781 : 1996	-	-	1.02
Pot life at 25°C on 100 g (min)	Gel Timer TECAM			8 - 12

## VACUUM CASTING PROCESSING BY MACHINE

**Important :** When storing the product at a temperature under 15 °C the part B can crystallise. It is recommended to store the product at 50 °C maximum until complete decrystallisation then return to room temperature.

- Both parts must be processed at a temperature above +18 °C.
- When pre-heating part A at 40 °C a 1,000 mPa.s mix viscosity is obtained.
- Separately degas the parts.
- Mix 45 seconds approx.
- Cast in a pre-heated mould at 65 °C - 70 °C.
- Allow to cure 60 to 90 minutes at 70 °C before demoulding

## HANDLING PRECAUTIONS

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

- Ensure good ventilation
- Wear gloves, safety glasses and waterproof clothes.

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

## MECHANICAL PROPERTIES AT 23°C AFTER HARDENING(1)

			Initial values	After ageing 15 days at +100°C (2)
Hardness	ISO 868 : 2003	Shore A1	63	60
Tensile strength	ISO 37 : 1994	MPa	4.5	2
Elongation at break	ISO 37 : 1994	%	800	1,000
Tear strength <i>Unnotched angular specimens</i>	ISO 34 : 2004	kN/m	25	20

## THERMAL AND SPECIFIC PROPERTIES (1)

Working temperature	-	°C	-40 / +80
Demoulding time at 70°C		min.	60 - 90
Complete hardening time at 70°C		hr	6

(1) Average values obtained on standard specimens, cast in moulds at 65 - 70 °C / Hardening 6 hr at 70 °C.

(2) Ageing in an oven with air renewal

## STORAGE CONDITIONS

Shelf life is 12 months in a dry place and in original unopened containers at a temperature between 25 and 30 °C. Any open can must be tightly closed under dry nitrogen blanket.

## PACKAGING

<b>ISOCYANATE (Part A)</b> 6 x 1.00 kg	<b>POLYOL (Part B)</b> 6 x 0.45 kg
---	---------------------------------------

## GUARANTEE

The information contained in this technical data sheet result from research and tests conducted in our Laboratories 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 guarantee the conformity of their products with their specifications but cannot guarantee 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 responsibility of AXSON is strictly limited to reimbursement or replacement of products which do not comply with the published specifications