



BUILDING TRUST



# F23 ISOCYANATE F23-1 POLYOL

**FASTCAST POLYURETHANE RESIN**  
EASY TO SAND - VERY GOOD SURFACE ASPECT

## APPLICATIONS

Tools for small to medium series, thermoforming tools, checking fixtures, positioning fixtures, prototyping parts, decorative applications when plaster aspect is needed (e.g. furniture ornaments, statues, bas reliefs).

## PROPERTIES

- Very good surface aspect after machining (non-porous)
- Phtalate free
- Easy to carve, sand and polish
- Gloss recovering with polishing paste
- REACH and ROHS compliant

### PHYSICAL PROPERTIES

Composition		POLYOL	ISOCYANATE	MIXTURE
Mixing ratio by weight		100	20	
Aspect		Liquid	Liquid	Liquid
Color		White	Translucent yellow	White
Viscosity at 25°C (mPa.s)	BROOKFIELD LVT	2900	40	900
Density of liquid parts	ISO 1675	1.64	1.21	-
Density of cured mixing at 23°C	ISO 2781	-	-	1.58
Pot life at 25°C on 240g (min)	Gel Timer TECAM			4'25 - 5'25

### MECHANICAL PROPERTIES AT 23°C (1)

Hardness	ISO 868	Shore D1	80
Tensile strength	ISO 527	MPa	30
Flexural modulus	ISO 178	MPa	3200
Flexural strength	ISO 178	MPa	47
Compressive strength at yield	ISO 604	MPa	63

### THERMAL AND SPECIFIC PROPERTIES (1)

Glass transition temperature (Tg)	ISO 11359-2	°C	60
Glass transition temperature (Tg) after 3h at 80°C	ISO 11359-2	°C	107
Linear shrinkage on 1000x50x10 mm sample	Internal method	mm/m	2
Demolding time at 25°C : thickness of 10 mm	Internal method	min	30

(1): Average values obtained on standardized specimens / Hardening 7 days at 23°C

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# F23 ISOCYANATE

## F23-1 POLYOL

### FASTCAST POLYURETHANE RESIN

EASY TO SAND - VERY GOOD SURFACE ASPECT

## PROCESSING CONDITIONS

Before use Polyol must be stirred until both color and aspect become homogeneous. Polyol and Isocyanate must be mixed together at a temperature above 18°C according to the indicated mix ratio. The maximum advised casting thickness is around 50 mm. Prior to cast, please check that parts or molds are free of any traces of moisture to avoid bad surface aspect.

## HANDLING PRECAUTIONS

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

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

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

## STORAGE CONDITIONS

Shelf life of both parts is 6 months in a dry place and in their original unopened containers at a temperature between 15 to 25°C. Any open must be tightly closed under dry inert gas (dry air, nitrogen, etc.).

## PACKAGING

F23-1 POLYOL	F23 ISOCYANATE	KIT
1 x 5 Kg 6 x 1 Kg	1 x 1 Kg 6 x 0.2 Kg	1 x (5+1) Kg 6 x (1+0.2) Kg

## GUARANTEE

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 for his application under his own conditions. AXSON refuses any guarantee about the compatibility of a product with any particular application. AXSON disclaims 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.

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