

## Biresin® U1320 NT

### Elastomeric Casting system for foundry pattern making, Shore D 62 and D 66

#### Areas of Application

- Casting of high tear and impact resistant parts and tools, e. g. core boxes and match plates
- Casting of tough-hard coatings

#### Product Benefits

- Both components without toxic classification
- Simple hand casting without postcuring
- Very high abrasion resistance
- Insensitive to moisture
- Short demoulding time **without brittleness phase**
- Long potlife with **Biresin® U1320 L Neu (B)**
- Translucent with **Biresin® U1320 C Neu (B)**
- Higher hardness with **Biresin® U1320 H (B)**
- Very good impact resistance and tensile strength

#### Description

- Basis Two component PUR system
- Component A **Biresin® U1320 NT**, isocyanate prepolymer, yellowish-transparent
- Component B **Biresin® U1320 L Neu**, amine, beige
- Component B **Biresin® U1320 C Neu**, amine, amber-translucent
- Component B **Biresin® U1320 H**, amine, beige

Processing Data	Component A		Component B		
	Biresin®	U1320 NT	U1320 L Neu	U1320 C Neu	U1320 H
Individual components	Biresin®	U1320 NT	U1320 L Neu	U1320 C Neu	U1320 H
Viscosity, 25°C	mPa.s	~ 14.000	~ 270	~ 270	~ 300
Density	g/ml	1,10	1,15	1,15	1,15
Mixing ratio A : B	in pbw	100	40	40	30
		<b>Mischung</b>			
Mixed viscosity, RT	mPa.s	~ 8.000		~ 8.500	
Potlife, 500 g, RT	min	16		13	
Recommended casting thickness	mm	6 - 8			
Demoulding time, RT	h	> 16			
Machinable (e. g. installing of nozzles)	h	> 24 (dependent on casting thickness)			
Curing time, RT	d	3 - 5			

#### Physical Data (approx. values)

Biresin® U1320 NT (A)	with component B	Biresin®	U1320 L Neu	U1320 C Neu	U1320 H
Colour			beige*	amber-translucent*	beige*
Density	ISO 1183	g/cm³	1,15		
Shore hardness	ISO 868	-	D 62		D 66
Tensile strength	ISO 527	MPa	50		32
Elongation at break	ISO 527	%	330		270
Abrasion resistance	ISO 4649	mm³	70		100

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

## Packaging

Individual components	<b>Biresin® U1320 NT (A)</b>	10 kg; 5 kg net
	<b>Biresin® U1320 L Neu (B)</b>	8 kg; 2 kg net
	<b>Biresin® U1320 C Neu (B)</b>	2 kg net
	<b>Biresin® U1320 H (B)</b>	1.5 kg net

## Processing

- The material temperature must be 18 - 25°C.
- The B component must be mixed thoroughly before use.
- It is possible to add Biresin® Farbpaste to the B component before processing if required.
- A visible cloudiness or a solid white consistency of the A component means that crystallization has either just begun or is in an advanced state. This crystallization can be removed by simply heating for a short time at maximum 70°C and then cooling to room temperature again before use.
- 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.
- Crystallization of the components may occur due to improper storage conditions. Please refer to the recommended actions to be taken under the processing section.
- 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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