

### APPLICATIONS

Vacuum casting polyurethane resin. Casting for production of prototype parts having high thermal resistance.

### PROPERTIES

- Good thermal resistance
- Easy to paint
- Easy processing
- Good reproduction accuracy

### PHYSICAL PROPERTIES

	UP 6160ALS	UP 6160BL	MIXED
Composition	POLYOL	ISOCYANATE	
Mix ratio by weight	100	200	
Aspect	Liquid	Liquid	Liquid
Colour	Yellowish	Colorless	Yellowish
Density at 20°C (g/cm <sup>3</sup> )	0.96 – 1.01 -	1.20 – 1.23 -	- 1.20
Viscosity at 23°C (mPa.s)	300 - 400	200 - 300	200 - 300
Pot life at 20-25°C (min) 100g			6 - 8

### PROCESSING CONDITIONS (Vacuum casting machine)

- Weigh both 2 parts, put Part B (ISOCYANATE) into the upper cup.
- Pour Part B to Part A and mix for 1 minute minimum after degassing for 5 -10 minutes under vacuum.
- Degas for 1 – 2min after mixing.
- Cast under vacuum in silicone mould previously heated at 50 - 60°C.
- Demould after 60 minutes minimum at 70°C
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### MECHANICAL PROPERTIES at 23°C<sup>(1)</sup>

Hardness	Shore D	80 – 81
Flexural modulus of elasticity	MPa	2100 - 2200
Flexural strength	MPa	108 - 128
Tensile strength	MPa	59 - 69
Elongation at break	%	15 - 16
Impact strength (IZOD)	J/m	34 - 44

#### THERMAL AND SPECIFIC PROPERTIES <sup>(1)</sup>

Tg	°C	237
Heat deflection temperature	°C	190 - 200
Maximum casting thickness	mm	5
Shrinkage	%	0.7 – 0.9
Demolding time at 70 °C 2mm	min	40 - 60

(1) Average values obtained on standard specimens / Hardening 60 minutes at 70 °C, 2mm + 90 minutes at 100°C + 120 minutes at 120°C + 120 minutes at 160°C

#### 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.

#### STORAGE CONDITIONS

Shelf life is 6 months in a dry place and in original unopened containers at a temperature between 15 and 25°C. And open must be closed under dry nitrogen blanket.

#### PACKAGING

UP 6160ALS

UP 6160BL

1 x 1.00KG

2 x 1.00KG

#### GUARANTEE

*The information of our technical data sheet are 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.*