

PROPERTIES

- Rigid urethane resin for vacuum casting (PP type)
- Hardness 73-75 Shore D
- High workability (demolding 60 minutes at 70°C)

PHYSICAL PROPERTIES

	Part A	Part B	MIXED
Composition	Modified polyol	Modified MDI	
Mix ratio by weight	100	135	
Aspect	Liquid	Liquid	
Colour	Colorless	Colorless	White
Density at 20°C (g/cm ³)	1.05-1.07 -	1.15-1.17 -	- 1.12-1.14
Viscosity at 23°C (mPas)	400-500	150-200	180-200
Pot life at 20-25°C (min) 100g			6 - 7.5
Demolding time at 60-70 °C (min) 2 - 3mm			60

MECHANICAL PROPERTIES at 23°C ⁽¹⁾

Hardness	Shore D	73-75
Tensile Strength	MPa	30-35
Flexural Strength	MPa	50-60
Compressive Strength	MPa	-
Elongation at break	%	50-60
Flexural modulus of elasticity	MPa	1200-1250
Impact Strength (IZOT)	J/m ²	140-145

(1) Typical Cure schedules

Mold temperature: 60-70°C
 Liquid temperature: 25-30°C
 60-90minutes at 60-70°C, 2-3mmt

THERMAL AND SPECIFIC PROPERTIES ⁽¹⁾

Heat deflection temperature	°C	80
Shrinkage	%	0.34

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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

1 x 1 kg

1 x 1.35 kg

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.