



PX 761

**URETHANE CASTING
FOR TECHNICAL AND PROTOTYPES PARTS
HARDNESS A SHORE 60**

APPLICATIONS

Used by casting in silicone moulds for the manufacturing of prototype parts and flexible mock-ups.

PROPERTIES

- High reproduction accuracy
- "Molded rubber" aspect
- Max. peak temperature: 100°C (see ageing results page 2)
- Abrasion resistance
- Fast demolding

PHYSICAL PROPERTIES				
		PART A	PART B	MIXING
Composition		ISOCYANATE	POLYOL	
Mixing ratio by weight		100	45	
Aspect		liquid	liquid	liquid
Color		colorless	amber	amber
Brookfield LVT viscosity at 25°C (mPa.s)	-	3,500 - 4,500	150 - 250	1,200 - 1,800
Specific gravity at 25°C	ISO 1675-75	1.03 - 1,07	0.96 - 1,00	-
Specific gravity at 23°C	ISO 2781-88	-	-	1.00 - 1,04
Pot life at 25°C on 100g (min.)	-			8 - 12

PROCESSING (Under vacuum casting machine)

Important: When storing the product at a temperature under 15°C the part B can crystallize. It is recommended to store the product at 50°C maximum until complete dicrystallization 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 degass the parts.
- Mix 45 seconds approx.
- Cast in a pre-heated mold at 65°C - 70°C.
- Allow to cure 60 to 90 minutes at 70°C before demolding.

PRECAUTIONS

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

- . ensure good ventilation
- . wear gloves and safety glasses

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



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MECHANICAL PROPERTIES AT 23°C AFTER HARDENING (1)

			Initial values	After ageing 14 days @ +100°C (2)
Maximal tensile strength	ISO 37-77	MPa	4.5	2
Elongation at break	ISO 37-77	%	800	1,000
Tear strength (angular specimen without cut)	ISO 34-94	kN/m	20	20
Hardness	ISO 868-85	A Shore	63	60

THERMAL & SPECIFIQUES PROPERTIES (1)

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

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

(2) Ageing in an oven with air renewal

STORAGE

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

ISOCYANATE (Part A)

POLYOL (Part B)

6 x 1.00 kg

6 x 0.45 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.