



APPLICATIONS

Used by casting in silicone moulds for production of prototyping and short production runs of flexible parts.

PROPERTIES

- Rubber-like aspect
- Excellent reproduction accuracy
- Good abrasion resistance
- Low viscosity
- Fast demoulding

PHYSICAL PROPERTIES				
		PART A	PART B	MIXING
Composition		ISOCYANATE	POLYOL	
Mixing ratio by weight @ 25°C		44	100	
Aspect		liquid	liquid	liquid
Colour		amber	black	black
Brookfield LVT viscosity @ 25°C(mPa.s)	-	25 - 45	800 - 1.200	600 - 800
Specific gravity @ 25°C Specific gravity of the cured product @ 23°C	ISO 1675-75 ISO 2781-88	1.18 - 1.22	1.03 - 1.07	1.08 - 1.12
Pot life @ 25°C on 100g (min.)	-			2 - 3

PROCESSING (Vacuum casting machine)

- The both parts have to be processed at a temperature above +18°C.
- **Important : Shake vigorously part B before each weighing.**
- Degas before using parts.
- Mix 30 seconds minimum.
- Cast in a mould at 65 - 70°C.
- Allow to cure 45 to 60 minutes at 70°C before demoulding.

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.



MECHANICAL PROPERTIES @ 23°C (1)			
Hardness	ISO 868-85	Shore A1	75
Tear strength <i>Angular specimen without cut</i>	ISO 34-94	kN/m	20
Maximal tensile strength	ISO 37-77	MPa	7
Elongation at break	ISO 37-77	%	300

THERMAL & SPECIFIC PROPERTIES (1)			
Operating temperature	-	°C	-40 / +80
Demoulding time @ 70°C	-	min	45
Complete hardening time @ 70°C	-	h	4

(1) : Average values obtained on standardized specimens, casting in moulds at 65-70°C / Hardening 4 hours at 70°C.

STORAGE

Shelf life is 12 months in a dry place and in original unopened containers at a temperature between 20 and 30°C. Any open can must be tightly closed under dry nitrogen blanket.

PACKAGING

*ISOCYANATE (Part A)
6 x 0.44 kg*

*POLYOL (Part B)
6 x 1.00 kg*

GUARANTEE

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