

APPLICATIONS

Prototypes and small-scale patterns by casting in silicone moulds.

PROPERTIES

- Casting of very thin parts possible
- Resistant while demoulding
- Good impact resistance
- Easy-to-use mix ratio (1:1 mixing ratio by weight)
- Low viscosity
- Good ability for being painted
- Opaque even in small thickness
- Low chemical attack towards silicone moulds

PHYSICAL PROPERTIES				
		PART A	PART B	MIXING
Composition		POLYOL	ISOCYANATE	
Mixing ratio by weight		100	100	
Mixing ratio by volume at 25°C		100	88	
Aspect		liquid	liquid	liquid
Colour		light amber	dark amber	beige
Brookfield LVT viscosity at 25°C (mPa.s)	-	35	20	28
Density of parts before mixing	ISO 1675 : 1985	0.97	1.10	-
Density of cured mixing	ISO 2781 : 1996		-	1.07
Pot life at 25°C on 200g (min.)	-			2

MECHANICAL PROPERTIES AT 23°C (1)			
Hardness	ISO 868 : 2003	Shore D1 / D15	73 / 70
Flexural modulus of elasticity	ISO 178 : 2001	MPa	860
Flexural strength	ISO 178 : 2001	MPa	38
Charpy impact resistance	ISO 179/1D : 1994	kJ/m ²	24

(1) Average values obtained on standard specimens / Hardening 7 days at 23°C

PROCESSING CONDITIONS

Before use part A (polyol) must be mixed until both colour and aspect become homogeneous. Both parts (polyol and isocyanate) must be mixed at a temperature above 18°C according to the indicated mixing ratio. A casting thickness of no more than 2 mm is advised. Before casting check that parts or moulds are free of any trace of moisture.

Silicone elastomer ESSIL 120 is particularly well suited for the production of moulds for casting F 33.

THERMAL AND SPECIFIC PROPERTIES (1)			
Use temperature	-	°C	-20 / +80
Glass transition temperature	ISO 11359 : 2002	°C	100
Demoulding time at 23°C - (2 mm thickness)	-	min.	> 30
Complete hardening at 23°C	-	days	3
Maximum casting thickness	-	mm	5

STORAGE CONDITIONS

Shelf life of both components is 12 months in a dry place and in their original unopened containers at a temperature between 15 to 25°C.

Any open can must be tightly closed under dry inert gas (dry air, nitrogen, etc.).

HANDLING 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.

PACKAGING

POLYOL (Part A)

6 x 0.9 kg
1 x 4.5 kg
1 x 18 kg

ISOCYANATE (Part B)

6 x 0.9 kg
1 x 4.5 kg
1 x 18 kg

GUARANTEE

Information of our technical data sheet is 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 for his application under his own conditions. AXSON refuses any guarantee about the compatibility of a product with any particular application. AXSON disclaims 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.