

**DESCRIPTION**

*Hand casting in silicone moulds of prototypes parts and scale models.*

**PROPERTIES**

- *Very quick setting*
- *Friendly use mix ratio (1:1 by weight)*
- *Low aggressiveness toward silicone moulds*
- *Opaque even in small thickness*
- *Good ability to being painted*

PHYSICAL PROPERTIES				
Composition		ISOCYANATE	POLYOL	MIXED
Mix ratio by weight		100	100	
Mix ratio by volume at 25 °C		88	100	
Aspect		liquid	liquid	liquid
Colour		dark amber	off white	beige
Viscosity at 25 °C (mPa.s)	BROOKFIELD LVT	24	55	40
Specific gravity at 25 °C (g/cm <sup>3</sup> )	ISO 1675 : 1985	1.10	0.97	-
Specific gravity of cured product at 23 °C	ISO 2781 : 1996	-	-	1.07
Pot life at 25 °C on 200 g (min)	Gel Timer TECAM			1'50 – 2'00

**PROCESSING CONDITIONS**

*Before use Polyol must be stirred until both color and aspect become homogeneous. Polyol and Isocyanate must be mixed together at a temperature above 18 °C according to the indicated mix ratio. Prior to cast, please check that parts or moulds are free of any traces of moisture to avoid bad surface aspect.*

*Silicone elastomer ESSIL 125 is particularly well suited to the production of moulds for casting F 31. A maximum casting thickness of 5 mm is advised.*

MECHANICAL PROPERTIES at 23 °C (1)			
Hardness	ISO 868 : 2003	Shore D1 /D15	73 / 70
Flexural modulus	ISO 178 : 2001	MPa	1,100
Flexural strength	ISO 178 : 2001	MPa	44
Charpy impact resistance	ISO 179/1D:1994	kJ/m <sup>2</sup>	16

**FASTCAST POLYURETHANE RESIN**  
FOR THIN PARTS – DEMOULDING TIME 20 MINUTES

<b>THERMAL AND SPECIFIC PROPERTIES (1)</b>			
Temperature of use		°C	-20 / +80
Glass transition temperature	ISO 11359 : 2002	°C	95
Demoulding time at 23°C – (2 mm thickness)	-	min.	20
Complete hardening time at 23°C		days	3
Maximal casting thickness	-	mm	5

(1) Average values obtained on standardized specimens / Hardening 7 days at 23 °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 of both parts is 12 months in a dry place and in their original unopened containers at a temperature between 15 and 25 °C

Any open can must be tightly closed under dry nitrogen.

## PACKAGING

<b>ISOCYANATE F 31</b>	<b>POLYOL F31</b>
6 x 0.90 kg	6 x 0.90 kg
1 x 5.00 kg	1 x 5.00 kg
1 x 20.00 kg	1 x 20.00 kg

## GUARANTEE

The information contained in this technical data sheet result from research and tests conducted in our Laboratories 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 guarantee the conformity of their products with their specifications but cannot guarantee 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 responsibility of AXSON is strictly limited to reimbursement or replacement of products which do not comply with the published specifications.