

DESCRIPTION

Tools for small to medium series, thermoforming tools, checking fixtures, positioning fixtures, prototyping parts, decorative application (e.g. furniture ornaments, statues, bas reliefs), foundry negatives.

PROPERTIES

- Friendly use system (1:1 mix ratio)
- Short pot life
- Low viscosity
- Good ability for being painted
- Quick setting
- Good temperature resistance (after thermal treatment)

PHYSICAL PROPERTIES			
Composition		POLYOL F1	ISOCYANATE F1
Mix ratio by weight		100	100
Mix ratio by volume at 25 °C		100	100
Aspect		liquid	liquid
Colours (the indicated colours for polyols are colours of the final mixing with Isocyanate)		black green ivory	dark amber
Viscosity at 25 °C (mPa.s)	BROOKFIELD LVT	2,000	1,700
Specific gravity at 25 °C (g/cm ³)	ISO 1675 : 1985	1.58	1.69
Pot life at 25 °C on 200 g (min)	Gel Timer TECAM	5	-

PROCESSING CONDITIONS

Before use Polyol and Iso 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. The maximum advised casting thickness is around 40 mm. Prior to cast, please check that parts or moulds are free of any traces of moisture.

MECHANICAL PROPERTIES at 23 °C (1)			
			F1
Specific gravity at 25 °C	ISO 2781 : 1996		1.63
Hardness	ISO 868 : 2003	Shore D1	73
Tensile strength	ISO 527 : 1993	MPa	33
Flexural modulus	ISO 178 : 2001	MPa	3,800
Flexural strength	ISO 178 : 2001	MPa	52
Compressive strength at yield	ISO 604 : 2002	MPa	62

THERMAL AND SPECIFIC PROPERTIES (1)			
			F 1
Glass transition temperature - 7 days at T.A - 24 h T.A + 2 hrs at 80 °C	ISO 11359 : 2002	°C	60 90
Linear shrinkage (specimen 250x50x50mm)	(1) (2)	mm/m	2.5
Demoulding time -for 10 mm thickness - for 40 mm thickness		min	45 25
Maximal casting thickness	-	mm	40

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

(2) Measured shrinkage epoxy resin mold, mold release after 3:00 - mold Dimension: 250x50x40 mm

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 6 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

ISOCYANATE F1	POLYOL F1
6 x 0.750 kg	6 x 0.750 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.