

FASTCAST POLYURETHANE RESIN
EASY TO SAND – VERY GOOD SURFACE ASPECT

DESCRIPTION

Tools for small to medium series, thermoforming tools, checking fixtures, positioning fixtures, prototyping parts, decorative applications when plaster aspect is needed (e.g. furniture ornaments, statues, bas reliefs).

PROPERTIES

- *Very good surface aspect after machining (non porous.*
- *Gloss recovering with polishing paste*
- *Easy to carve, to sand, to polish*

PHYSICAL PROPERTIES				
Composition		ISOCYANATE	POLYOL	MIXED
Mix ratio by weight		20	100	
Mix ratio by volume at 25 °C		23	100	
Aspect		liquid	liquid	liquid
Colour		light amber	pure white	white
Viscosity at 25 °C (mPa.s)	BROOKFIELD LVT	40	5,000	1,750
Specific gravity at 25 °C (g/cm ³)	ISO 1675 : 1985	1.22	1.64	-
Specific gravity of cured product at 23 °C	ISO 2781 : 1996	-	-	1.58
Pot life at 25 °C on 240 g (min)	Gel Timer TECAM			4'30 – 5'30

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. The maximum advised casting thickness is around 50 mm. Prior to cast, please check that parts or moulds are free of any traces of moisture to avoid bad surface aspect.

MECHANICAL PROPERTIES at 23 °C (1)			
Hardness	ISO 868 : 2003	Shore D1	80
Tensile strength	ISO 527 : 1996	MPa	24
Flexural modulus	ISO 178 : 1993	MPa	5,000
Flexural strength	ISO 178 : 1993	MPa	50
Compressive strength at yield	ISO 604 : 1997	MPa	62

THERMAL AND SPECIFIC PROPERTIES (1)			
Glass transition temperature	T.M.A Mettler	°C	55
Glass transition temperature (+ 3hrs at 80°C)	T.M.A Mettler	°C	90
Linear shrinkage (specimen 250x50x50mm)	-	mm/m	0.29
Demoulding time for 50 mm		min	30
Maximal casting thickness	-	mm	50

(1) Average values obtained on standardized specimens / Hardening 7 hours 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 06 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 F 23	POLYOL F23
6 x 0.20 kg	6 x 1 kg
1 x 1kg	1 x 5.00 kg

GUARANTEE

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