

**DESCRIPTION**

Negatives, moulds masters and mock-ups using the unfilled product or filled with RZ 30150 mineral filler in order to limit exothermal reaction and to get easy machining.  
Thermoforming tools using the product filled with RZ 209/6 aluminum powder in order to increase its thermal conductivity.

**PROPERTIES**

- Very low shrinkage
- Low viscosity even filled
- Easy to use mix ratio (1:1 by weight)
- High filler content possible

PHYSICAL PROPERTIES					
Composition		ISOCYANATE F 19	POLYOL F 19	MIXED UNFILLED	MIXING FILLED WITH RZ 30150
Mix ratio by weight		100	100	-	360
Aspect		liquid	liquid	liquid	liquid
Colour		dark amber	off-white	beige	beige
Viscosity at 25 °C (mPa.s)	BROOKFIELD LVT	55	100	78	2,600
Specific gravity at 25 °C (g/cm <sup>3</sup> )	ISO 1675 : 1985	1.08	0.96	-	-
Specific gravity of cured product at 23 °C	ISO 2781 : 1996	-	-	1.07	1.69
Pot life at 25 °C on 200 g (min)	Gel Timer TECAM			6 - 8	8 - 10

**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. For casting thicknesses between 5 mm and 60 mm maximum, it is advised to add fillers as follows (ratio by weight):

POLYOL	ISOCYANATE	RZ 30150	RZ 209/6
100	100	360	380

MECHANICAL PROPERTIES at 23 °C (1)			UNFILLED MIXING	MIXING (filled with 360 parts of RZ 30150)
Hardness	ISO 868 : 2003	Shore D1	72	79
Flexural strength	ISO 178 : 1993	MPa	50	41
Flexural modulus	ISO 178 : 1993	MPa	1,200	4,100
Compressive strength at yield	ISO 604 : 1993	MPa	48	55
Impact resistance Charpy	ISO 179/1eU / 1994	kJ/m <sup>2</sup>	16	-

THERMAL AND SPECIFIC PROPERTIES (1)			UNFILLED MIXING	MIXING (filled with 360 parts of RZ 30150)	
Glass transition temperature	ISO 11359 : 2002	°C	100		
CTE (+ 20°C to + 70°C)	ISO 11359 : 2002	10 <sup>-6</sup> K <sup>-1</sup>	-	80	
Linear shrinkage	-	mm/m	0.8	-	
- thickness 10 mm					0.7
- thickness 60 mm					
Demoulding time at 25°C for:		min	90	-	
- thickness 10 mm					150
- thickness 60 mm					

(1) Average values obtained on standardized specimens / Hardening 16 hours at 80 °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

ISOCYANATE F 19	POLYOL F19
1 x 4.50 kg	1 x 4.50 kg
1 x 18.00 kg	1 x 18.00 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.