

APPLICATIONS

Used by casting in a low pressure machine for production of prototype parts and flexible mock-ups, seals, groundsheets, shift lever boot, anti-vibration parts.

PROPERTIES

- Very easy processing
- Quick demoulding

- Good mechanical properties

PHYSICAL PROPERTIES

Composition		ISOCYANATE	POLYOL	Mixing
Mix ratio by weight		100	100	
Mix ratio by volume at 25 °C		92	100	
Aspect		Liquid	Liquid	Liquid
Colour		amber	black	black
Brookfield LVT viscosity at 25 °C (mPa.s)	-	2,000 - 2,600	900 - 1,500	1,300 - 1,900
Specific gravity at 25 °C	ISO 1675-75	1.10 - 1.14	1.01 - 1.05	-
Specific gravity of the cured product at 23 °C	ISO 2781-88	-	-	1.05 - 1.09
Pot life at 25 °C on 100g (s)	-			50 - 70

PROCESSING CONDITIONS

Used with a 2-component low pressure injection machine fitted out preferably with an agitator in the polyol tank. Before each use of polyol check there is no crystallization (see Storage §) and plasticate until a homogenous color is obtained. The two parts (polyol and isocyanate) must be mixed at a temperature higher than 18 °C according to the mix ratio indicated on the technical data sheet.

It is better to cast in a tooling heated to a temperature between 40 and 60 °C. Before casting check the 851 demoulding agent is applied to moulds free of any trace of moisture (demoulding agent specified for a low pressure injection to 80 °C). For further information please see the AXSON's technical data sheet about RELEASE AGENTS.

The optimum properties of the material are obtained after a 4 hours post-curing at 80 °C.

Caution : according to the part geometry, it may be necessary to use a conformer when post-curing.

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.

MECHANICAL PROPERTIES AT 23 °C (1)

Hardness	ISO 868-85	Shore A1	73
Tensile strength	ISO 527-66	MPa	7
Elongation at break	ISO 527-66	%	300
Tear strength (Non cut angular specimens)	ISO 34-94	kN/m	30

THERMAL AND SPECIFIC PROPERTIES (1)

Using temperature	-	°C	-40 / +70
Demolding time at 23°C	-	min.	15 - 20
Maximal casting thickness	-	mm	10
Linear shrinkage on parts at 23°C : - thickness 2 to 3mm - thickness 4 to 5 mm	-	mm/m	5 - 6 8 - 9

(1) : Average values obtained on standardized specimens, casting in moulds at 60 °C / Hardening 4 h 00 at 80 °C.

CONSERVATION - STORAGE

Shelf life is 12 months in a dry place and in original unopened containers at a temperature between 15 and 25 °C. Any open can must be tightly closed under dry nitrogen blanket. The polyol, at low temperature may crystallize (evidence : non homogeneous liquid part). It is advised to heat the product at 40 °C until a homogeneous liquid product is obtained.

PACKAGING

ISOCYANATE
1 x 21,0 kg
1 x 5,0 kg

POLYOL
1 x 21,0 kg
1 x 5,0 kg

ANNEX I

APPLICATIONS

When using in a 100/100 mix ratio by volume the following equipment is recommended:

- 400 cc cartridge
- Static mixer
- 400 cc pneumatic gun (MIXPAC)

PROCESSING CONDITIONS

Before filling the 400 cc cartridges check the polyol for crystallization. Then plasticate until a homogenous color is obtained. The two parts (polyol & isocyanate) must be mixed at a temperature above 18 °C.

Use the cartridges within 2 hours following packaging.

MECHANICAL PROPERTIES AT 23 °C (100/100 MIX RATIO BY VOLUME)			
Hardness	ISO 868-85	Shore A1	72
Tensile strength	ISO 527-66	MPa	5.5
Elongation at break	ISO 527-66	%	200
Tear strength (Non cut angular specimens)	ISO 34-94	kN/m	27

(1) : Average values obtained on standardized specimens, casting in moulds at 60 °C / Hardening 4 h 00 at 80 °C.

GUARANTEE

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