

# SILICONES

## and more



### Characteristics

## Polyurethane casting system D80

This PU results in a hard plastic that is very suitable for small to medium castings, fixing molds, foundry models, replicas and prototypes..

### Description

A polyurethane casting system consisting of an A component and B component. Optional fillers can be added. This casting system is characterized in particular by its quality and ease of use. The system can be used perfectly for small to medium sized castings, fixing molds, foundry models, replicas and prototypes.

### Technical data

	Unit	Unfilled	stuffed
Mixing ratio (weight)	[Isocyanate: Polyol: Filler]	1: 1: 0	1: 1: 3
processing Time	[Min]	6-8	10
De-mould time @ 20°C	[Min]	60-90	180
Density	[g / cm <sup>3</sup> ]	1,1	1,6
Linear shrinkage	[%]	0.5	0.1-0.4
Maximum thickness per cast	[mm]	20	80
Glass Temperature	[OC]	89	89
Hardness	[Shore D]	70-75	75-80

- Beige colored two or three-piece system
- Designed for fast, accurate castings
- Can be molded to a thickness of 80 mm, provided you use enough filler
- Filler quantity is varies depending on application, and even entirely omittable
- Can be used with up to 600% (of the total weight) filler

### Processing

Pour the components together and mix well. Pour the mixed product with a constant flow into the mold, making sure no air is entrapped. Excessive heat in castings of more than 30 mm thickness can be prevented by pouring multiple successive layers (let the layer harden till it is over its exothermal peak before the next layer is poured). Hold the de-moulding until the specified time has elapsed. The thermal and mechanical properties will develop rapidly, but it is possible to improve the thermal behavior by "post curing" the cast for a few hours at a temperature of 60 OC.

### Important

The dehumidifiers in these products tend to settle out. We therefore recommend aggitating the components before decanting. The less filler you add, the higher the exothermic peak will be. Adding a heat conducting filler will make casting thicker layers possible. Use a mixing vessel with large surface area in order to make a maximum pot life. Adding to much filler might make the product more rigid and brittle.

### Packing

The polyurethane casting system is supplied in a kit consisting an A and a B Component

### Durability

The polyurethane casting system should be stored in a dry place between 6-28 ° C, the expiration date, which is based on storage within the specified conditions, is indicated on the packaging. Opened packages should be processed as quickly as possible to ensure product quality. Max shelf life is 6 months

### Safety

Please be aware that these are chemicals. Always be careful when using the liquids. Take proper precautions. Wear fluid tight safety gloves and safety goggles. Keep out of range of children!

### Use/ Do:

