



Technical Data Sheet

Resin Preparation

IMPORTANT: Stir/shake the Part A can thoroughly in order to homogenise the resin. For best results, make sure the two components are at least 20°C before mixing.

Mixing instructions

When using unfilled, add the correct amount of Part B to the Part A and stir for 30-40 seconds. Pour carefully and in one place into the mould in order to avoid air inclusion. If using filled, we do not recommend filler to be more than 2.5 parts i.e. for 100g of A + 100 g of B and maximum of 250 g of filler. Use OMYA CARB 5 or ATH mineral filler for shrinkage reduction, or Aluminium powder for higher temperature applications. Large quantities of resin filled or unfilled, will always produce more exotherm and will gel quicker than smaller amounts.

IMPORTANT: If the resin is over-mixed or stirred after pouring into the mould there is a possibility of oily surfaces on the casting.

Curing

The casting can generally be demoulded after 20 minutes at room temperature. The precise demould time will vary with casting thickness, as thin section units will cure slower than thicker section units. When casting thin wall sections, ensure that the mould and resins are at least 20-25°C to facilitate a good cure. To reduce the cure time, the mould can be pre-warmed to 40-60°C. It is not recommended to heat the liquid components.

It is strongly recommended that, if the cast units are to be painted they must be wiped cleaned to remove any residual wax/oil from the release agent or resin.

Cured Properties*

Property	Cured 7 days @ 25°C UNFILLED	Cured 7 days @ 25°C FILLED 200% A91
Shore hardness (D)	70-75	80
Machinability	Average	Very Good
Linear Shrinkage (500 x 50 x 10 mm)	0.16%	0.062%
Tensile Strength ISO 527-2:1993	30 MPa	N/A
Elongation @ break ISO 527-2:1993	8 %	N/A
Flexural Strength ISO 178:1993	40 MPa	N/A
Flexural Modulus ISO 178:1993	800-1000 MPa	N/A
Glass Transition Temperature (Tg)	70°C	90°C

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*This data is not to be used for specifications. Values listed are for typical properties and should not be considered minimum or maximum.

Storage

Store both components A and B at 20-25°C. The Part B may crystallise partially or completely if not stored at above 20°C. The two components are moisture sensitive (like all PU's). KEEP THE PACKING TIGHTLY SEALED WHEN NOT IN USE. Moisture absorption will cause excessive aeration in cast parts. Shelf life of unopened containers stored at recommended temperature is 6 months. Once the container is opened the unused resin (part A or B) must ideally be kept under dry nitrogen. Use Poly Purge dry gas cap.

Packaging

A 0.5 kg, 1kg, 2kg, 5kg

B 0.5 kg, 1kg, 2kg, 5kg

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