

### APPLICATIONS

Negatives, molds, masters, mock-ups and decorative parts using the unfilled product or filled with RZ 30150 mineral filler in order to avoid an exothermic reaction and to get easy machining.

Thermoforming masters using the product filled with RZ 209/6 aluminum powder in order to increase thermal conductivity.

### PROPERTIES

- Quick setting system
- Reduced viscosity
- Impact resistant
- Low shrinkage
- Adequate viscosity even with high rate of filler

### PHYSICAL PROPERTIES

Composition		POLYOL	ISOCYANATE	UNFILLED MIXING	MIXING FILLED WITH RZ 30150
Mixing ratio by weight		100	100	-	360
Aspect		liquid	liquid	liquid	liquid
Color		off white	light amber	light beige	beige
Viscosity at 25°C (mPa.s)	BROOKFIELD LVT	52	110	80	4000
Density of parts before mixing at 25°C	ISO 1675 : 1985	0.94	1.10	-	-
Density of cured mixing at 23°C	ISO 2781 : 1996	-	-	1.06	1.65
Pot life at 25°C on 200g (min)	Gel Timer TECAM			3'30	5'30

### MECHANICAL PROPERTIES AT 23°C (1)

			UNFILLED MIXING
Hardness	ISO 868 : 2003	Shore D1	74
Flexural modulus of elasticity	ISO 178 : 2010	MPa	1130
Flexural strength	ISO 178 :2010	MPa	41
Charpy impact resistance	ISO 179/1eU :1994	kJ/m <sup>2</sup>	18

(1) : Average values obtained on standardized specimens / Hardening 14 hours at 60°C.

### THERMAL AND SPECIFIC PROPERTIES

			UNFILLED MIXING
Glass transition temperature (16 hours at 80°C)	ISO 11359-2 : 1999	°C	98
Demoulding time at 25°C - thickness : 10 mm	-	min	45
Linear shrinkage on : - 200x70x3 mm sample - 1000x50x10 mm sample	-	mm/m	4 5



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## FASTCAST POLYURETHANE - CAN BE FILLED

IMPACT RESISTANCE – LOW SHRINKAGE

### PROCESSING CONDITIONS

Before use, the polyol must be mixed until both color and aspect become homogeneous. The polyol and the isocyanate must be mixed at a temperature above 18°C according to the mix ratio indicated on this technical data sheet.

For casting thicknesses above 10 mm it is recommended to add filler as follows (maximum advised rate):

Polyol 100	Isocyanate 100	RZ 30150 (mineral) 360	RZ 209/6 (aluminum) 400
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We advise to add half of the total quantity of fillers in each of the two parts. Mix and homogenize them separately prior to mix these two pre-filled parts together.

### HANDLING 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.

### STORAGE CONDITIONS

Shelf life of both components is 12 months in a dry place and in their original unopened containers at a temperature between 15 to 25°C. Isocyanate is UV sensitive. It must be kept in its original container protected from the light. Any open must be tightly closed under dry inert gas (dry air, nitrogen, etc.).

### PACKAGING

POLYOL	ISOCYANATE	KIT
6 x 0.9 Kg 1 x 4.5 Kg 1 x 18 Kg	6 x 0.9 Kg 1 x 4.5 Kg 1 x 18 Kg	6 x (0.9+0.9) Kg 1 x (4.5+4.5) Kg 1 x (18+18) Kg

### GUARANTEE

Information of our technical data sheet is based on our present knowledge and the result of tests conducted under precise conditions. It is the responsibility of the user to determine the suitability of AXSON products for his application under his own conditions. AXSON refuses any guarantee about the compatibility of a product with any particular application. AXSON disclaims all responsibility for damage from any incident which results from the use of these products. The guarantee conditions are regulated by our general sale conditions.