PX 1000

URETHANE CASTING FOR TECHNICAL AND PROTOTYPES PARTS

FLEXURAL MODULUS 1,700 MPa - Tg 75°C

APPLICATIONS

Used by casting in silicone moulds for the realisation of prototype parts and mock-ups whose mechanical properties are close to those of thermoplastics.

PROPERTIES

- *Low viscosity*
- *Long pot-life*
- *Good mechanical properties*
- *Can be painted*
- *Thermoplastic aspect*

PHYSICAL PROPERTIES					
Composition			**ISOCYANATE PX 1000-215**	**POLYOL PX 1000**	**MIXING**
Mixing ratio by weight			100	100	
Aspect			liquid	liquid	liquid
Colour			light to dark amber	yellow straw	Off-white
Viscosity at 25°C	(mPa.s)	BROOKFIELD LVT	60	175	100
Specific gravity at 25°C Specific gravity at 23°C		ISO 1675 :1975 ISO 2781 :1988	1.15 -	1.02 -	- 1.06
Pot life at 25°C on 200g	(min.)	Gel Timer TECAM			15-20

PROCESSING

Weigh according to the indicated ratio. Mix until a homogeneous and transparent mixing is obtained.
Degas for 5 minutes.
Cast in a silicone mould at room temperature or pre-heated at 35 - 40°C to accelerate the process.
After demoulding cure 2 hours at 70°C in order to obtain the optimal properties.

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.

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MECHANICAL PROPERTIES AT 23°C AFTER HARDENING (1)			
Flexural modulus of elasticity	ISO 178 :2001	MPa	1700
Maximal flexural strength	ISO 178 :2001	MPa	67
Maximal tensile strength	ISO 527 :1993	MPa	38
Elongation at break	ISO 527 :1993	%	4
CHARPY impact strength	ISO 179/2D :1994	kJ/m^2	25
Hardness - at 23°C - at 80°C	ISO 868 :1985	Shore D1	78 69

THERMAL & SPECIFIQUES PROPERTIES			
Glass temperature transition (1)	TMA METTLER	°C	75
Linear shrinkage (1)	-	mm/m	1
Maximal casting thickness	-	Mm	5
Demoulding time @ 23°C	-	Hours	4
Complete hardening time @ 23°C	-	days	4

(1) Average values obtained on standard specimens/Hardening 12 hr at 70°C

STORAGE

Shelf life is 6 months for Isocyanate and 12 months for Polyol 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.

PACKAGING

Isocyanate	*Polyol*
6 X 1 kg *1 X 5 kg*	*6 X 1 kg* *1 X 5 kg*

GUARANTEE

The information of our technical data sheet are 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, under their own conditions before commencing with the proposed application. AXSON refuse any guarantee about 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 guarantee conditions are regulated by our general sale conditions.

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