

APPLICATIONS

Casting of prototypes and small-scale models in silicone moulds.

PROPERTIES

- *Fast demoulding time*
- *Easy-to-use mix ratio (1:1 by weight)*
- *Low chemical attack towards silicone moulds*
- *Opaque even in small thickness*
- *Good ability for being painted*

PHYSICAL PROPERTIES				
Composition		POLYOL	ISOCYANATE	MIXING
Mixing ratio by weight		100	100	
Mixing ratio by volume at 25°C		100	86	
Aspect		liquid	liquid	liquid
Colour		off-white	dark amber	beige
Brookfield LVT viscosity at 25°C (mPa.s)	-	35	35	35
Density of parts before mixing	ISO 1675 : 1985	0.98	1.14	-
Density of cured mixing	ISO 2781 : 1988	-	-	1.08
Pot life at 25°C on 200g (min.)	-			2.0

MECHANICAL PROPERTIES AT 23°C (1)			
Hardness	ISO 868 : 2003	Shore D1 / D15	74 / 72
Flexural modulus of elasticity	ISO 178 : 2001	Mpa	1.100
Flexural strength	ISO 178 : 2001	Mpa	48
Charpy impact resistance	ISO 179/1D :1994	kJ/m ²	15

(1) *Average values obtained on standard specimens / Hardening 7 days.*

PROCESSING CONDITIONS

Before use Polyol must be mixed until both colour and aspect become homogeneous. Both parts (Polyol and Isocyanate) must be mixed at a temperature above 18°C according to the mix ratio indicated on this technical data sheet. Before casting check that parts or moulds are free of any trace of moisture.

Silicone Elastomer ESSIL 125 is particularly well suited to the production of moulds for casting F32. Casting thickness of no more than 5 mm is advised.

THERMAL AND SPECIFIC PROPERTIES ⁽¹⁾			
Glass transition temperature	ISO 11359 : 2002	°C	100
Demolding time at 23°C - (2 mm thickness)	-	min.	> 20
Maximum casting thickness		mm	5

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 Polyol part is 6 months, and 12 months for Isocyanate part, in a dry place and in their original unopened containers at a temperature between 15 and 25°C.
 Any open can must be tightly closed under dry nitrogen.*

PACKAGING

Kit N° 07570	POLYOL 4,5 kg	ISOCYANATE 4,5 kg
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GUARANTEE

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