

## APPLICATIONS

- *Negatives, molds, masters and mock-ups using the unfilled product or filled with RZ 30150 mineral filler in order to limit exotherm and to get easy machining.*
- *Thermoforming masters using the product filled with RZ 209/6 aluminium powder in order to increase thermal conductivity.*

## PROPERTIES

- *Fast demolding*
- *Low viscosity*
- *Good temperature resistance after heat curing*
- *Adjustable filler content*
- *Easy-to-use mix ratio (1:1 by weight)*

PHYSICAL PROPERTIES					
		F16	F16	UNFILLED MIXING	MIXING FILLED WITH RZ 30150
		POLYOL	ISOCYANATE		
Composition					
Mixing ratio by weight		100	100	-	360
Aspect		liquid	liquid	liquid	Liquid
Color		off white	amber	beige	beige
Brookfield LVT viscosity at 25 °C (mPa.s)	-	120	40	80	1.500
Density of parts before mixing	ISO 1675-75	1.01	1.10		-
Density of cured mixing	ISO 2781-88	-	-	1.05	1.61
Pot life at 25 °C on 200g (min)	-			2'10 - 2'30	-

MECHANICAL PROPERTIES AT 23 °C (1)				
			UNFILLED MIXING	MIXING FILLED WITH 360 phr RZ 30150
Hardness	ISO 868-85	Shore D1	72	82
Flexural modulus of elasticity	ISO 178-93	MPa	1,000	3,600
Flexural strength	ISO 178-93	MPa	37	39
Compressive strength	ISO 604-97	MPa	33	60
Charpy impact resistance	ISO 1791/D	kJ/m <sup>2</sup>	13	-

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

## THERMAL AND SPECIFIC PROPERTIES <sup>(1)</sup>

			UNFILLED MIXING	MIXING FILLED WITH 360 phr RZ 30150
Glass transition temperature	T.M.A.-Mettler	°C	100	
Linear shrinkage (thickness 50 mm)		%	-	0.37
Coefficient of thermal expansion [+20, +90] °C	T.M.A.-Mettler	10 <sup>-6</sup> K <sup>-1</sup>	-	84
Demolding time at 25 °C - thickness : 10 mm - thickness : 40 mm	-	min. min.	30	20

## PROCESSING CONDITIONS

Before use POLYOL must be mixed until both color and aspect become homogeneous. The polyol must be mixed at a temperature above 18 °C according to the mix ratio indicated on this technical data sheet. For casting thicknesses above 5 mm it is recommended to add a filler as follows:

- up to 360 phr of RZ 30150 filler (mineral filler)
- up to 400 phr of RZ 209/6 filler (aluminium powder)

For thicknesses no more than 40 mm.

## 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 can must be tightly closed under dry inert gas (dry air, nitrogen, etc.).

## 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.

## PACKAGING

POLYOL	ISOCYANATE
6 x 0,9 kg	6 x 0,9 kg
1 x 5,0 kg	1 x 5,0 kg
1 x 20,0 kg	1 x 20,0 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.