Similar to PC

PX 520

APPLICATIONS

Used by casting in silicone moulds for the realization of prototype parts and mock-ups whose mechanical properties close to those of transparent PC material.

PROPERTIES

- Good transparency
- Low viscosity
- Easy to operate
- Easy to mold release
- Longer available time

PHYSICAL PROPERTIES

	PART A	PART B	MIXING
Composition	ISOCYANATE	POLYOL	
Mixing ratio by weight	100	100	
Aspect	liquid	liquid	liquid
Color	transparent	transparent	Off-white
Brookfield LVT viscosity at 25°C(mPa.s)	200 - 250	70 - 90	130 - 190
Specific gravity at 23°C	1.13 - 1.17	1.06 - 1.10	1.10-1.15
Pot life at 25°C on 200g			9 min
Demould time (70°C)			1.5 H

PROCESSINT

- Weigh according to the indicated ratio . First B, A set of parts into the vacuum machine to separate the vacuum for 10 minutes, after mixing the vacuum for 4 5 minutes, and then put a small, injection mold.
- the temperature of the material used in the two components must be greater than 20 0 C
- debubbling in the oven to bake for 90 minutes under the 70 0 C to achieve the best performance
- mold cooling after the start of mold release

PRECAUTIONS

Normal health and safety precautions should be observed when handing these products:
. ensure good ventilation
. wear gloves and safety glasses
For further information, please consult the product safety data sheet.

Similar to PC

PX 520

MECHANICAL PROPERTIES AT 23 ℃ AFTER HARDENING			
Final hardness	ISO868-85	Shore D	80
Maximal tensile strength	ISO527-84	MPa	55
Elongation at break	ISO37-77	%	16
Flexural modulus of elasticity	ISO178-93	MPa	2200
Maximal flexural strength	ISO178-93	MPa	90
CHARPY impact strength	ISO179/IK-94	kJ/m^2	50

THERMAL & SPECIFIQUES PROPERTIES			
Glas temperature transition	TMA METTLER	℃	60
Linear shrinkage		mm/m	2
Maximal casting thickness		mm	5
Complete hardening time @23°C		d	4

Average values obtained on standardized specimens/Hardening 12 hr at 70 °C