

Biresin® U1303

Elastomeric casting system for mould making, Shore A 73 / A 81 / A 90

Areas of Application

- Casting of flexible moulds for ceramic and gypsum processing
- Moulds for concrete mouldings
- Manufacture of elastic, flexible mouldings and components

Product Benefits

- Insensitive to moisture
- Rubbery
- Good tensile strength and elasticity
- Several B components for different Shore hardness levels
- Very low shrinkage
- Dyeable with **Biresin® Farbpasten**

Description

- Basis Two component PUR system
- Component A **Biresin® U1303**, isocyanate prepolymer, colourless-transparent
- Component B **Biresin® U1302**, amine, reddish-transparent
- Component B **Biresin® U1402**, amine, coloured-transparent
- Component B **Biresin® U1419**, amine, brownish-transparent

Processing Data		Component A		Component B	
Individual components		Biresin® U1303	Biresin® U1302	Biresin® U1402	Biresin® U1419
Viscosity, 25°C	mPa.s	~ 9,000	~ 85	~ 180	~ 200
Density	g/ml	1.04	0.98	1.11	1.02
Mixing ratio	parts by weight	100	40	35	10
Mixtures					
Mixed viscosity, 25°C	mPa.s	~ 3,800	~ 4,000	~ 8,000	
Potlife, RT	min	20 - 25	25	15	
Demoulding time, RT	h	> 16	> 16	> 16	
Curing time, RT	d	7	7	7	

Physical Data (approx. values)

Biresin® U1303 (A)		with component B	Biresin® U1302	Biresin® U1402	Biresin® U1419
Colour		coloured - transparent*			
Density	ISO 1183	g/cm³	1.03	1.05	1.05
Shore hardness	ISO 868	-	A 73	A 81	A 90
Tear strength	ISO 34	N/mm	15	18	30
Tensile strength	ISO 527	MPa	7	10	15
Elongation at break	ISO 527	%	550	400	400
Linear shrinkage	internal	%	0.02	0.1	-

* dependent on raw materials the colour can differ without changing the mechanical properties

Packaging

Individual components	Biresin® U1303 (A)	200 kg; 20 kg; 10 kg; box with 6 x 1 kg net
	Biresin® U1302 (B)	4 kg; box with 6 x 0.4 kg net
	Biresin® U1402 (B)	7 kg; 1 kg net
	Biresin® U1419 (B)	1.6 kg net

Processing

- The material, processing and mould temperature must be from 18 to 25°C.
- It is possible to add Biresin® Farbpaste to the B component before processing if required.
- Pay attention to dry conditions and dry mould surfaces while processing.
- The resin and hardener components are to be mixed thoroughly and poured immediately into previously released moulds (e.g. with Sika® Liquid Wax-815 resp. Sika® Pasty Wax-818; for more information see product data sheet).
- Porous surfaces (wood, gypsum) have to be well sealed before processing.

Storage

- Minimum shelf life is 12 month under room conditions (18 - 25°C), when stored in original un-opened containers.
- After prolonged storage at low temperature, crystallisation of components may occur. This is easily removed by warming up for a sufficient time to a maximum of 70°C. Allow to cool to room temperature before use.
- Containers must be closed tightly immediately after use to prevent moisture ingress. The residual material needs to be used up as soon as possible.

Health and Safety Information

For information and advice on the safe handling, storage and disposal of chemical products, users shall refer to the most recent Safety Data Sheet (SDS) containing physical, ecological, toxicological and other safety related data. .

Disposal considerations

Product Recommendations: Must be disposed of in a special waste disposal unit in accordance with the corresponding regulations.

Packaging Recommendations: Completely emptied packagings can be given for recycling. Packaging that cannot be cleaned should be disposed of as product waste.

Value Bases

All technical data stated in this Product Data Sheet are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

Legal Notice

The information, and, in particular, the recommendations relating to the application and end-use of Sika products, are given in good faith based on Sika's current knowledge and experience of the products when properly stored, handled and applied under normal conditions in accordance with Sika's recommendations. In practice, the differences in materials, substrates and actual site conditions are such that no warranty in respect of merchantability or of fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred either from this information, or from any written recommendations, or from any other advice offered. The user of the product must test the product's suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request.

Further information available at:

Sika Deutschland GmbH

Subsidiary Bad Urach

Stuttgarter Str. 139

D - 72574 Bad Urach

Germany

Tel: +49 (0) 7125 940 492

Fax: +49 (0) 7125 940 401

Email: tooling@de.sika.com

Internet: www.sika.com



BUILDING TRUST

