

APPLICATIONS

Tools for small to medium series, thermoforming tools, checking fixtures, positioning fixtures, prototyping parts, decorative application (e.g. furniture ornaments, statues, bas reliefs), foundry negatives.

PROPERTIES

- Friendly use system (1:1 mix ratio)
- Quick setting
- Low viscosity
- Good ability for being painting
- Short pot life
- Good temperature resistance (after thermal treatment)

PHYSICAL PROPERTIES

Composition		POLYOL	ISOCYANATE	MIXING
Mixing ratio by weight		100	100	-
Aspect		Liquid	Liquid	Liquid
Color		Black Green Ivory	Amber	Black Green Ivory
Viscosity at 25°C (mPa.s)	BROOKFIELD LVT	3500	1700	2500
Density of liquid parts (g/cm ³)	ISO 1675	1.58	1.69	-
Density of cured mixing at 23°C	ISO 2781	-	-	1.64
Pot life at 25°C on 200g (min)	Internal method	-	-	4'45

MECHANICAL PROPERTIES AT 23°C (1)

Hardness	ISO 868	Shore D1	73
Tensile strength	ISO 527	MPa	20
Flexural modulus	ISO 178	MPa	3000
Flexural strength	ISO 178	MPa	35
Compressive strength at yield	ISO 604	MPa	33

THERMAL AND SPECIFIC PROPERTIES

Glass transition temperature (T _g) - 7 days at Room Temperature (RT) - 24 hours at RT + 2 hours at 80°C	ISO 11359-2	°C	71 107
Demolding time at 25°C - Thickness 10 mm - Thickness 40 mm	Internal method	min	45 25
Linear shrinkage on 1000x50x10 sample at 23°C	Internal method	mm/m	1
Maximal casting thickness	-	mm	40

(1): Average values obtained on standardized specimens / Hardening 7 days at RT

PROCESSING CONDITIONS

Before making a mixing, each component must be stirred until both color and aspect become homogeneous. Polyol and Isocyanate must be mixed together at a temperature above 18°C according to the indicated mixing ratio. Prior to cast, please check that parts or moulds are free of any traces of moisture.

HANDLING PRECAUTIONS

Normal health and safety precautions should be observed when handling these products:

- Ensure good ventilation
- Wear gloves, safety glasses and clothes.

For further information, please consult the product safety data sheet.

STORAGE CONDITIONS

Shelf life of both parts is 6 months, in a dry place and in their original unopened containers at a temperature between 15 to 25°C. Any open must be tightly closed under dry inert gas (dry air, nitrogen, etc.).

PACKAGING

F10 POLYOL	F1 ISOCYANATE
6 x 0.75 Kg	6 x 0.75 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.