

Biresin® U1404 with Biresin® U1419L Elastomeric casting resin for mould making, Shore A40 to A80

Areas of Application

- Casting of flexible moulds for ceramic and gypsum processing
- Moulds for foaming and casting of mouldings with complex structure
- Manufacture of elastic, flexible mouldings and components
- Casting of electrical components and high-voltage cable joint boxes

Product Benefits

- Insensitive to moisture
- Dependent on mixing ratio of both B components **Biresin® U1404** and **Biresin® U1419 L** Shore hardness is adjustable from A 40 to A 80
- With a higher level of component B **Biresin® U1419 L** the potlife increases
- Good tensile strength and elasticity
- Very low shrinkage
- Pigmentable with **Biresin® Farbpasten**

Description

- Basis Two component PUR system
- Component A **Biresin® U1404**, isocyanate prepolymer, colourless-transparent, unfilled, ~ 6,500 mPas, d=1.05 g/ml
- Component B **Biresin® U1404**, amine, reddish-transparent, unfilled, ~ 300 mPas, d = 1.05 g/ml
- Component B **Biresin® U1419 L**, amine, reddish-transparent, unfilled, ~ 300 mPas, d = 1.20 g/ml

Processing Data

Mixing ratio in parts by weight	Component A	Biresin® U1404	80	100	100	100	100
		Component B	Biresin® U1404	100	54	32	10
		Biresin® U1419 L	-	6	8	10	11
Mixtures							
Mixed viscosity, 25°C	mPa.s		3,000 - 5,800				
Potlife, 500 g / RT	min		25	60	90	100	110
Demoulding time, RT	h		24				
Curing time, RT	d		3 - 5	5 - 7			

Physical Data (approx. values)

Mixing ratio in parts by weight	Component A	Biresin® U1404	80	100	100	100	100
		Component B	Biresin® U1404	100	54	32	10
		Biresin® U1419 L	-	6	8	10	11
Density	ISO 1183	g/cm³	1.05				
Shore hardness	ISO 868	-	A 40	A 47	A 60	A 74	A 80
Tear strength	ISO 34	N/mm	7	12	16	25	40
Tensile strength	ISO 527	MPa	4	3	5	6	16
Elongation at break	ISO 527	%	> 600	1,000	1,000	1,000	800

Packaging

Individual components	Biresin® U1404 (A)	200 kg; 20 kg; 8 kg; 0.8 kg net
	Biresin® U1404 (B)	10 kg; 1 kg net
	Biresin® U1419 L (B)	5 kg; 0.9 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

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