



PX 100

URETHANE CASTING FOR TECHNICAL
AND PROTOTYPES PARTS
FLEXURAL MODULUS 1,500 MPa - Tg 75°C

APPLICATIONS

Used by casting in silicone moulds for the realisation of prototype parts and mock-ups whose mechanical properties are close to those of thermoplastics.

PROPERTIES

Low viscosity
Long pot-life
Good mechanical properties
Can be painted
Thermoplastic aspect

PHYSICAL PROPERTIES

		PART A	PART B	MIXING
Composition		ISOCYANATE	POLYOL	
Mixing ratio by weight		100	100	
Mixing ratio by volume at 25°C		88	100	
Aspect		liquid	liquid	liquid
Color		straw yellow	light to dark amber	off-white
Brookfield LVT viscosity at 25°C (mPa.s)	-	50 - 70	150 - 200	80 - 120
Specific gravity at 25°C	ISO 1675-75	1.13 - 1.17	1.00 - 1.04	-
Specific gravity at 23°C	ISO 2781-88	-	-	1,04 - 1.08
Pot life at 25°C on 200g (min.)	-			12 - 18

PROCESSING

Weigh according to the indicated ratio. Mix until a homogeneous and transparent mixing is obtained.

Degas for 5 minutes.

Cast in a silicone mold at room temperature or pre-heated at 35 - 40°C to accelerate the process.

After demolding cure 2 hours at 70°C in order to obtain the optimal properties.

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.



PX 100

URETHANE CASTING FOR TECHNICAL
AND PROTOTYPES PARTS
FLEXURAL MODULUS 1,500 MPa - Tg 75°C

MECHANICAL PROPERTIES AT 23°C AFTER HARDENING (1)

Final hardness	ISO 868-85	Shore D1	74
Hardness at 80°C	ISO 868-85	Shore D1	65
Maximal tensile strength	ISO 527-84	MPa	40
Elongation at break	ISO 37-77	%	20
Flexural modulus of elasticity	ISO 178-93	MPa	1,500
Maximal flexural strength	ISO 178-93	MPa	55
CHARPY impact strength	ISO 179/2D-94	kJ/m ²	25

THERMAL & SPECIFIQUES PROPERTIES (1)

Glas temperature transition (1)	TMA METTLER	°C	75
Linear shrinkage (1)		mm/m	1
Maximal casting thickness		mm	5
Demoulding time @ 23°C		hr	4
Complete hardening time @ 23°C		d	4

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

STORAGE

Shelf life is 6 months in a dry place and in original unopened containers at a temperature between 15 and 25° C. Any open can must be tightly closed under dry nitrogen blanket.

PACKAGING

PART A

6 x 1 kg
1 x 5 kg

PART B

6 x 1 kg
1 x 5 kg

GUARANTEE

The information of our technical data sheet are 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, under their own conditions before commencing with the proposed application. AXSON refuse any guarantee about the compatibility of a product with any particular application. AXSON disclaim 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.