



**FASTCAST POLYURETHANE  
CAN BE FILLED  
POT LIFE : 7 MIN - VERY LOW SHRINKAGE**

## APPLICATIONS

- *Negatives, molds, masters and mock-ups using the unfilled product or filled with RZ 30150 mineral filler in order to limit exotherm and to get easy machining.*
- *Thermoforming molds using the product filled with RZ 209/6 aluminium powder in order to increase its thermal conductivity.*

## PROPERTIES

- *Very low shrinkage*
- *Low viscosity*
- *Easy-to-use mix ratio (1:1 by weight)*
- *High filler content possible while retaining a low viscosity*

PHYSICAL PROPERTIES					
		PART A	PART B	UNFILLED MIXING	MIXING FILLED WITH RZ 30150
Composition		POLYOL	ISOCYANATE		
Mixing ratio by weight		100	100	-	360
Aspect		liquid	liquid	liquid	liquid
Color		off-white	dark amber	beige	beige
Brookfield LVT viscosity at 25°C (mPa.s)	-	100	55	78	2,600
Density of parts before mixing	ISO 1675-85	0.93 - 0.99	1.05 - 1.11	-	-
Density of cured mixing	ISO 2781-88	-	-	1.04 – 1.10	1.66 – 1.72
Pot life at 25°C on 200g (min)	-			6 - 8	8 - 10

MECHANICAL PROPERTIES AT 23°C (1)				
			UNFILLED MIXING	MIXING FILLED WITH 360% OF MIXING RZ 30150
Hardness	ISO 868-85	Shore D1	72	79
Flexural modulus of elasticity	ISO 178-93	MPa	1,200	4,100
Flexural strength	ISO 178-93	MPa	50	41
Compressive strength	ISO 604-93	MPa	48	55
Charpy impact resistance	ISO 179/1eU-93	kJ/m <sup>2</sup>	16	-

(1) : Average values obtained on standardized specimens / Hardening 16 hours at 80°C



## THERMAL AND SPECIFIC PROPERTIES <sup>(1)</sup>

			UNFILLED MIXING	MIXING FILLED WITH 360% OF MIXING RZ 30150
Glass transition temperature	T.M.A.-Mettler	°C	100	
Linear shrinkage - thickness : 10 mm - thickness : 60 mm		mm/m	0.8 -	- 0.7
Coefficient of thermal expansion [+20, +70]°C	T.M.A.-Mettler	10 <sup>-6</sup> K <sup>-1</sup>	-	80
Can be demolded at 25°C after - thickness : 10 mm - thickness : 60 mm	-	min. min.	90 -	- 150

## PROCESSING CONDITIONS

Before use part A (polyol) must be mixed until both color and aspect become homogeneous. Both parts (polyol and isocyanate) must be mixed at a temperature above 18°C according to the mix ratio indicated on this technical data sheet. For casting thicknesses between 5 mm and 60 mm maximum it is recommended to add a filler as follows:

Part A	Part B	RZ 30150	RZ 209/6
100	100	360	380

For bigger casting thicknesses please contact our Customer Service.

## STORAGE CONDITIONS

Shelf life of both parts is 12 months in a dry place and in their original unopened containers at a temperature between 15 and 25°C. Any open can must be tightly closed under dry nitrogen.

## 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.

## PACKAGING

Polyol (Part A)	Isocyanate (Part B)
1 x 4.5 kg	1 x 4.5 kg
1 x 18.0 kg	1 x 18.0 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.