

PR 2900

REFERENCES

Polyol : PR 2900 P - SH 110 000
Isocyanate : PR 2900 I – SH 000 290

DEFINITION

Polyurethane resin for vacuum casting.
High flexural modulus
Suitable with European directive: 2011/65/EC (RoHS)

PHYSICAL DATA OF THE COMPONENTS

	PR 2900 P SH 110 000	PR 2900 I SH 000 290	PR 2900
Aspect – Color	Liquid transparent Colorless	Liquid light yellow	Liquid light yellow
BROOKFIELD Viscosity LVT in mPa.s According to MO-051	700	250	400
Density at 25°C According to MO-032	1.08	1.21	1.17

PROCESS DATA

	PR 2900 P SH 110 000	PR 2900 I SH 000 290	PR 2900
Mixing ratio in weight	50	100	
Mixing time at 25°C (sec.)			2'20
Pot-life on 100g at 25°C (min.) Test method MO-062			6'30
Demoulding time at 70°C (min.) Test method MO-116			45'

AVERAGE POLYMER PROPERTIES

	Test Method	
Hardness Shore D1 (1)	ISO 868 - 2003	86
Heat Deflection Temperature (1)	ISO 75 Ae:2001	92°C
Flexural modulus of elasticity (1)	ISO 178 : 2001	2900 MPa
Maximal flexural strength (1)	ISO 178 : 2001	119 MPa
Tensile modulus of elasticity (1)	ISO 527 : 1993	2900 MPa
Elongation at break (1)	ISO 527 : 1993	7 %
Tensile strength at break (1)	ISO 527 : 1993	78 MPa
Charpy impact strength (1)	ISO 179/1D : 1994	70 kJ.m²

(1) Average values measured on specimens after post curing 2 h at 70°C + 5 h at 100°C + 24 h at room temperature

*This document can not be, in any case, used as specification data sheet . The values mentioned on this document are based on tests and researches carried on in our laboratories in precise conditions.
It's the responsibility of the user to check the convenience of the product in his own conditions defined and tried by himself. The Synthene Company disclaims all responsibility for any consequence occurred by the use of this product.*



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Safety for using :

Better wear safety clothes and accessories (gloves and glasses).
For more information, read the medical and safety data sheet of the product.

Process with vacuum casting machine :

Pre-heat polyaddition silicone moulds at 70°C.
Weigh isocyanate part in the upper cup (don't forget the residual product).
Weigh polyol part in the mixing cup.
After 10 min of vacuum, pour the isocyanate part in mixing cup and mix until total clearness of the mixing. (at least 1 min 30 for a process at 25°C).
Pour in the mould.
Put the mould in an oven at 70°C for approximately 2 hours according to the thickness of the part.

Packaging :

Please consult us.

STORAGE : 12 months in original unopened containers and stored between 15 and 25 °C.

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