



UP 6160ALS/BL VACUUM CASTING POLYURETHANE RESIN

HIGH THERMAL RESISTANCE: 200°C

APPLICATIONS

Vacuum casting polyurethane resin. Casting for production of prototype parts having high thermal resistance.

PROPERTIES

- Good thermal resistance
- Easy processing

- Easy to paint
- Good reproduction accuracy

PHYSICAL PROPERTIES					
	UP 6160ALS	UP 6160BL	MIXED		
Composition	POLYOL	ISOCYANATE			
Mix ratio by weight	100	200			
Aspect	Liquid	Liquid	Liquid		
Colour	Yellowish	Colorless	Yellowish		
Density at 20°C (g/cm ³)	0.96 – 1.01 -	1.20 – 1.23 -	- 1.20		
Viscosity at 23°C (mPa.s)	300 - 400	200 - 300	200 - 300		
Pot life at 20-25°C (min) 100g			6 - 8		

PROCESSING CONDITIONS (Vacuum casting machine)

- Weigh both 2 parts, put Part B (ISOCYANATE) into the upper cup.
- Pour Part B to Part A and mix for 1 minute minimum after degassing for 5 -10 minutes under vacuum.
- Degas for 1 2min after mixing.
- Cast under vacuum in silicone mould previously heated at 50 60°C.
- Demould after 60 minutes minimum at 70°C
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MECHANICAL PROPERTIES at 23°C ⁽¹⁾				
Hardness	Shore D	80 - 81		
Flexural modulus of elasticity	MPa	2100 - 2200		
Flexural strength	MPa	108 - 128		
Tensile strength	MPa	59 - 69		
Elongation at break	%	15 - 16		
Impact strength (IZOD)	J/m	34 - 44		

Page 1/2 - 29 Nov. 2007 AXSON France AXSON GmbH AXSON IBERICA AXSON ASIA AXSON JAPAN AXSON SHANGHAI BP 40444 Dietzenbach Barcelona Seoul OKAZAKI CITY Zip: 200131 95005 Cergy Cedex Tel. (49) 6074407110 Tel. (34) 932251620 Tel. (82) 25994785 Shanghai Tel.(81) 564262591 FRANCE Tel. (33) 134403460 Tel. (86) 58683037 **AXSON Italie** AXSON UK AXSON MEXICO AXSON NA USA Fax.(86) 58682601 Eaton Rapids Tel. (1) 5176638191 Mexico DF Fax (33) 134219787 Saronno Newmarket E-mail: shanghai@axson.cn Tel. (52) 5552644922 Tel. (39) 0296702336 Tel. (44)1638660062 Email: axson@axson.fr Web: http://w axson com cr



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THERMAL AND SPECIFIC PROPERTIES ⁽¹⁾				
Tg	°C	237		
Heat deflection temperature	°C	190 - 200		
Maximum casting thickness	mm	5		
Shrinkage	%	0.7 – 0.9		
Demolding time at 70 °C 2mm	min	40 - 60		

(1) Average values obtained on standard specimens / Hardening 60 minutes at 70 °C, 2mm + 90 minutes at 100°C + 120 minutes at 120°C + 120 minutes at 160°C

HANDLING PRECAUTIONS

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

Ensure good ventilation

Wear gloves, safety glasses and waterproof clothes.

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

STORAGE CONDITIONS

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

PACKAGING

UP 6160ALS

UP 6160BL

1 x 1.00KG

2 x 1.00KG

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.

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