

POLIMOLD HR 25-30-40-50

Polyurethane fluid rubber for moulds

INTRODUCTION:

Two component room temperature vulcanising fluid rubber which cures after addition and mixing with the appropriate catalyst: it produces an elastic and tenacious mass, free from bubbles and imperfections; it has a good stability to hydrolysis, very good mechanical resistance, is easy to demould and has a percent shrinkage approx. = 0. Poly-urethane rubbers of POLIMOLD HR series, once cured, have a light superficial greasiness caused by proper release agents in order to favour demoulding operations.

APPLICATION:

Low and medium hardness types (HR 25 – 30) are suitable for reproduction of complex patterns with undercuts; high hardness types are specially suited for reproduction of large-sized patterns. Moulds made of POLIMOLD HR are suitable for mass-production plaster and cement handworks, for artistic foundry (loose-wax method), in wax industry (decorative candles).

PACKING:

Component A: Kg. 5; Kg. 10; Kg. 20 Plastic bucket
Component B: Kg. 5; Kg. 10; Kg. 20 Plastic bucket

SHELF LIFE:

Both components (A and B) 8 months, stored in their original tightly closed containers, in a dry and fresh place at temperatures in the range from +5°C to +30°C.

TRANSPORT:

RID/ADR exempt: the product is not flammable.

TECHNICAL PROPERTIES (at +20° C. and 60% U.R.)

| POLIMOLD HR | HR 20 | HR 25 | HR 30 | HR 40 | HR 50 |
|---|--------------|--------------|--------------|--------------|--------------|
| Mixing ratio A+B (parts in weight) | 100:100 | 100:100 | 100:100 | 100:100 | 100:100 |
| Pot life mixture A+B (minutes) | 30 | 30 | 20 | 20 | 20 |
| Viscosity mixture A+B (cps) | 800±100 | 900±100 | 900±100 | 1000±100 | 1100±100 |
| Specific gravity mixture A+B (kg./dm ³) | 0,980-1 | 1 | 1 | 1-1,020 | 1-1,020 |
| Demoulding time (hours) | 24 | 24 | 24 | 24 | 24 |
| Hardening time (hours) | 72 | 72 | 72 | 72 | 72 |
| Hardness (Shore A) | 20±3 | 25±3 | 30±3 | 40±3 | 50±3 |
| Linear shrinkage after 5 day ageing (%) (ISO 4823) | < 0,1 | < 0,1 | < 0,1 | < 0,1 | < 0,1 |
| Elongation at break (%) | >1000 | >800-1000 | >1000 | >1000 | >800 |
| Tearing resistance (KN/mm) (DIN 53515) | 23±3 | 33±3 | 43±3 | 53±3 | 63±3 |

NOTE:

Regarding how to use this product and models' preparation, we suggest to see related technical sheet titled "How to use POLIMOLD HR".

Avoid product's catalysis at temperatures higher than +30°C.

Pouring time, pot life and moulding time will depend on environment's temperature and relative humidity value.

NOTE. The information given to users is based on our best experience. However, because of the many possible applications, which are outside of our knowledge and control, we cannot accept liability for loss or damage resulting from reliance upon such information. Typical data values should not be used as a basis for product specifications.