



PX212

APPLICATIONS

Used by casting in silicone moulds for production (prototyping and short production runs) of thermoplastic-like parts with a flexible modulus of elasticity close to 1,200 MPa

PROPERTIES

- Low viscosity
- Fast demoulding
- Polypropylene modulus
- Excellent impact and shock resistance

PHYSICAL PROPERTIES

		PART A	PART B	MIXING
Composition		ISOCYANATE	POLYOL	
Mixing ratio by weight at 25°C		100	100	
Aspect		Liquid	Liquid	Liquid
Color		Light yellow	Transparent	Translucent
Brook field LVT viscosity at 25°C (mPa.s)		100-200	800-1.200	700-900
Specific gravity at 25°C Specific gravity of the cured product at 23°C	ISO 1675-75 ISO 2781-88	1.20-1.24 -	1.01-1.05 -	1.13-1.17
Pot life at 25°C on 200g (min)				4-6

PROCESSING (vacuum casting machine)

- The both parts have to be processed at a temperature above +18°C
- **IMPORTANT: Shake vigorously part B before each weighing**
- Degas before use parts
- Mix 30 seconds minimum
- Cast in a mould at 65 - 70°C
- Allow to cure 60 to 75 minutes at 70°C before demoulding

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PRECAUTIONS

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

- Ensure good ventilation
- Wear gloves and safety glasses

MECHANICAL PROPERTIES AT 23°C AFTER HARDENING ⁽¹⁾			
Flexural modulus of elasticity	ISO 178-93	Mpa	1,200
Maximal flexural strength	ISO 178-93	Mpa	80
Maximal tensile strength	ISO 527-66	Mpa	40
Elongation at break	ISO 527-66	%	25
Charpy impact resistance	ISO 179/1d-94	kJ/m ²	>50
Hardness	-	ISO 888-85	Shore D1
23°C	-		76
80°C	-		68

THERMAL AND SPECIFIQUES PROPERTIES ⁽¹⁾			
Glass transition temperature	TMA METTLER	°C	90
Linear shrinkage	-	mm/m	3
Maximal casting thickness	-	mm	5
Demoulding time @ 70°C	-	min	60-75
Complete hardening time @ 70°C	-	h	4