



## PX521 HT

### APPLICATIONS

Casting in Silicone moulds: transparent prototype parts until a 50 mm thickness: headlights, glazier....

### PROPERTIES

- High transparency (water clear)
- Good UV resistance
- Easy Polishing
- Easy Processing
- High Reproduction accuracy

### PHYSICAL PROPERTIES

		<b>PART A</b>	<b>PART B</b>	<b>MIXING</b>
Composition		ISOCYANATE	POLYOL	
Mixing ratio by weight		100	55	
Aspect		Liquid	Liquid	Liquid
Colour		Bluish	Transparent	Transparent
Brookfield LVT viscosity at 25°C (mpa.s)	-	150-250	900-1.300	400-600
Density of parts before mixing	ISO 1675-85	1.06-1.08	1.03-1.07	-
Density of the cured product	ISO 2781-88	-	-	1.04-1.08
Pot life @ 25°C on 155g	-			16-24

### VACUUM CASTING PROCESSING CONDITIONS

- Use a vacuum casting machine.
- Heat the mould at 70°C.
- Heat both parts at 20°C in case of storage at a lower temperature
- Weigh part A in the upper cup
- Weigh part B in the lower cup
- After degassing for 10 minutes under vacuum pour part A in and part B and mix for 2 minutes
- Cast in the silicone mould, previously heated at 70°C
- Put in an oven at 70°C minimum

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## PRECAUTIONS

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

- Ensure good ventilation
- Wear gloves, safety glasses and waterproof clothes

<b>MECHANICAL PROPERTIES AT 23°C</b>			
Hardness	ISO 868-85	Shore D1	80
Flexural modulus of elasticity	ISO 178-93	Mpa	2,100
Flexural strength	ISO 178-93	Mpa	105
Tensile modulus of elasticity	ISO 527-96	Mpa	2,700
Tensile strength	ISO 527-96	Mpa	75
Elongation at break in tension	ISO 527-96	%	9
Charpy impact strength	ISO 179/2D-93	kJ/m <sup>2</sup>	27

<b>THERMAL AND SPECIFIQUES PROPERTIES <sup>(1)</sup></b>			
Glass temperature transition (T <sub>g</sub> )	TMA METTLER	°C	110
Maximal casting thickness		mm	50
Time before demoulding at 70°C		Min.	120
Heat deflection temperature	ISO 75 Ae-93	°C	100