PuCast 260 (W)

Polyurethane casting resin

Product description

PuCast 260(W) is an unfilled, two-component polyurethane casting resin. Different fillers can be added during mixing to obtain the required properties. Its long working time permits large castings, such as sheet-metal forming tools.

Key features

• Low resin viscosity and good flow • Can be filled

• Excellent toughness and impact resistance • Excellent compressive strength of castings

• Thick tooling sections can be cast with added filler

Physical properties

Property	PuCast260A(W) Polyol	PuCast260B Isocyanate	After mixing
Mix ratio by weight	100	100	-
Appearance	Liquid	Liquid	Liquid
Colour	Beige	Pale yellow	Beige
Viscosity at 25°C (mPa.s)	Approx. 2000	Approx. 150	Approx. 850
Density at 25°C (g/cm3)	Approx. 1.06	Approx. 1.22	Approx. 1.16
Working time (500g) at 23°C (minutes)	-	-	Approx. 55
Cure time at 25°C (hours)	-	-	16-24

			Unfilled	A:B:filler 1:1:2
Mixed density		g/cm3	Approx. 1.16	Approx. 1.56
Hardness	ISO868:1985	Shore hardness	Approx. 80D	85D
Flexural modulus	ISO178:2001	MPa	Approx. 2200	Approx. 3400
Flexural strength	ISO178:2001	MPa	Approx. 70	Approx. 77
Compressive strength	ISO604:1997	MPa	Approx. 70	Approx. 82
Charpy impact strength	ISO179/2D:1994	kJ/m2	Approx. 66	Approx. 8

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Other properties			Filled
Heat deflection temperature 1)	ISO75	°C	/
Maximum casting thickness	-	mm	400
Linear shrinkage	-	%	0.1

1) The values above are averages measured on standard specimens / Cure conditions: 80°C /6 hours

Processing instructions

• Thoroughly stir the polyol component before use

• Mix the polyol and isocyanate components thoroughly in the specified ratio

• Continue stirring after adding filler

• Leave to stand for 3-5 minutes, then pour the resin into the mould

• Demould after 16-24 hours at room temperature

Packaging

PuCast260A(W) Polyol	PuCast260B Isocyanate
20kg	20kg

Storage

The polyol and isocyanate have a shelf life of 12 months when stored dry in unopened containers at 15°C-25°C.

Promptly reseal opened containers in a dry environment. After using the hardener, blanket the container with nitrogen or dry air and close the lid tightly to prevent moisture-induced discolouration. Use any remaining material as soon as possible.

Safety precautions

Avoid skin contact during application. Wear protective clothing, a mask and protective gloves as necessary, and work in a well-ventilated area. Refer to the material safety data sheet for further information.

Notes

All data above were measured under specified conditions. As actual processing methods and other factors may affect performance, customers should conduct the necessary tests before use to confirm suitability for their application. We guarantee that our products meet our quality specifications.

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