EN

Product Information

Elan-tech®
PU 630/G 8 100:100

Expanding polyurethane system

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Resin	Hardener	Mixing ratio by weight
PU 630	**G 8**	**100:100**

Application: Low-medium density components. Rigid and light filling of moulds and patterns.

Processing: Mechanical mixing. Manual mixing. Short pot-life (20-30 seconds). Room temperature curing. Better surface finishing can be obtained foaming into a hot mould (50-60°C).

Description: Two component foam system. fast The product expands in free air till 10-12 times. The system does not contain any ozone depleting agents.

SYSTEM SPECIFICATIONS

Resin					
Viscosity at:	25°C	IO-10-50 (EN13702-2)	mPas	800	1.100
Hardener					
Viscosity at:	25°C	IO-10-50 (EN13702-2)	mPas	160	240

TYPICAL SYSTEM CHARACTERISTICS

Processing Data					
Resin Colour				Pale/yellow	
Hardener Colour				Brown	
Mixing ratio by weight		for 100 g resin	g	100:100	
Mixing ratio by volume		for 100 ml resin	ml	100:90	
Density	25°C Resin	IO-10-51 (ASTM D 1475)	g/ml	1,08	1,12
Density	25°C Hardener	IO-10-51 (ASTM D 1475)	g/ml	1,20	1,24
Cream time	25°C 200ml	IO-10-77	sec	35	45
Gelation time	25°C (15ml;6mm)	IO-10-73 (*)	sec	90	140
Demoulding time	25°C (15ml;6mm)	(*)	min	20	30

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TYPICAL CURED SYSTEM PROPERTIES

Properties determined on specimens cured: 24 h TA + 15 h 60°C

Colour			Beige	
Machinability			Good	
Density 25°C	IO-10-54 (ASTM D 792)	g/l	110	150
Linear shrinkage	Indicativo	‰	0,50	1,00
Max recommended operating temperature	(***)	°C	65 - 75	

IO-00-00 = Elantas Italia's test method. The correspondent international method is indicated whenever possible.
nd = not determined na = not applicable RT = TA = laboratory room temperature (23±2°C)
Conversion units: 1 mPas = 1 cPs 1MN/m2 = 10 kg/cm2 = 1 MPa

(*) for larger quantities pot life is shorter and exothermic peak increases
(**) the brackets mean optionality
(***) The maximum operating temperature is given on the basis of laboratory information available being it function of the curing conditions used and of the type of coupled materials. For further possible information see post-curing paragraph.

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Instructions: Add the appropriate quantity of hardener to the resin, mix carefully. Cast quickly before 20-30 seconds from the starting of the mixing on shapes well insulated from moisture, dried and treated with the suitable release agents. Demoulding is possible after 20-30 minutes.
Attention: the shrinkage depends on the operative conditions used. It is necessary to verify the effective value referring to applications and conditions.

Curing / Post-curing: It is only necessary for use at temperatures higher than 70°C or to obtain a rapid stabilization of the material. In this case post-cure the component gradually avoiding thermal gradients over 10°C/hour and maintain the product at the maximum temperature for 2-4 hours.

Storage: Polyol resins and the isocyanate based hardeners can be stored for one year in the original sealed containers stored in a cool, dry place. The hardeners may present an increase in viscosity that does not change the cured system properties. Both components are moisture sensitive therefore it is good practice to close the vessels immediately after each use. Moisture absorption may cause the expansion of the product during application and/or the hardener may crystallize during storage.

Handling precautions: Refer to the safety data sheet and comply with regulations relating to industrial health and waste disposal.

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