

Biresin® U1320 NT

Elastomeric Casting system for foundry pattern making, Shore D 62

Areas of Application

- Casting of high tear and impact resistant parts and tools, e. g. core boxes and match plates
- Casting of tough-hard coatings

Product Benefits

- Both components without toxic classification
- Very high abrasion resistance
- Insensitive to moisture
- Short demoulding time **without brittleness phase**
- Low shrinkage
- Very good impact resistance and tensile strength
- Dyeable with **Biresin® Farbpaste**

Description

- Basis Two-component-PUR-system
- Resin (A) **Biresin® U1320 NT**, isocyanate prepolymer, yellowish-transparent
- Hardener (B) **Biresin® U1320 L Neu**, amine, beige

Processing Data		Resin (A)	Hardener (B)
Individual components		Biresin® U1320 NT	Biresin® U1320 L Neu
Viscosity, 25°C	mPas	~ 14,000	~ 270
Density	g /ml	1.10	1.15
Mixing ratio resin (A) to hardener (B) in parts by weight		100	40
Mixture			
Mixed viscosity, RT	mPas	~ 8,000	
Potlife, 500 g, RT	min	16	
Recommended casting thickness	mm	6 - 8	
Demoulding time, RT	h	> 16	
Machinable (e. g. installing of nozzles)	h	> 24 (dependent on casting thickness)	
Curing time, RT	d	3 - 5	

Physical Data (approx. values)

Biresin® U1320 NT resin (A)		with hardener (B)	Biresin® U1320 L Neu
Colour			beige*
Density	ISO 1183	g/cm³	1.15
Shore hardness	ISO 868	-	D 62
Tensile strength	ISO 527	MPa	50
Elongation at break	ISO 527	%	330
Abrasion resistance	ISO 4649	mm³	70

* dependent on raw materials the colour can differ without different mechanical properties

Packaging

Individual components	Biresin® U1320 NT resin (A)	10 kg; 5 kg net
	Biresin® U1320 L Neu hardener (B)	8 kg; 2 kg net



Processing

- The material temperature must be 18 - 25°C.
- The hardener component (B) must be mixed thoroughly before use.
- It is possible to add Biresin® Farbpaste to the hardener component (B) before processing if required.
- Pay attention to dry conditions and dry mould surfaces while processing.
- The resin and hardener components are to be mixed thoroughly and poured immediately into previously released moulds (e. g. with Sika® Trennmittel 810 or 815 Quick resp. Sika® Trennwachs 818, for more information see Product Data Sheet).
- Porous surfaces (wood, gypsum) have to be well sealed before processing.

Storage

- Minimum shelf life is 12 month under room conditions (18 - 25°C), when stored in original un-opened containers.
- After prolonged storage at low temperature, crystallisation of components may occur. This is easily removed by warming up for a sufficient time to a maximum of 60°C. Allow to cool to room temperature before use.
- Containers must be closed tightly immediately after use to prevent moisture ingress. The residual material needs to be used up as soon as possible.

Health and Safety Information

For information and advice on the safe handling and storage of products, users should refer to the current Safety Data Sheet containing physical, ecological, toxicological and other safety related data.

Disposal considerations

Product Recommendations: Must be disposed of in a special waste disposal unit in accordance with the corresponding regulations.

Packaging Recommendations: Completely emptied packagings can be given for recycling. Packaging that cannot be cleaned should be disposed of as product waste.

Value Bases

All technical data stated in this Product Data Sheet are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

Legal Notice

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