

PRC1719

References

Polyol : PRC 1719 P - SL 121000
Isocyanate : PRC 17XX I - SL 000121

Definition

Clear transparent polyurethane resin for vacuum casting.

Mercury free product in accordance with the European Directives : 2011/65/UE (RoHS), 2002/96/EC, 2000/53/EC, 2000/11/EC.

Suitable for optical prototyping parts simulating PMMA or PC. Very high UV stability.

Easy to polish and to colour.

Average physical properties of the components

	PRC 1719 P SL 121 000	PRC17XX I SL 000 121	PRC 1719
Aspect – Color	Liquid transparent Colorless	Liquid transparent Colorless	Liquid transparent Colorless
Brookfield Viscosity LVT (mPa.s) According to MO-051	450	320	400
Density at 25°C According to MO-032	1.08	1.10	1.10

Process data

	PRC 1719 P SL 121 000	PRC17XX I SL 000 121	Mix SL 121 121
Mixing ratio in weight	60	100	
Mixing time at 25°C (sec.)			150
Pot-life on 160g at 25°C (min.) Test method MO-062			19
Demoulding time at 70°C (min.) Test method MO-116			150

Average mechanical and thermal properties of the polymer

Average values measured on specimens after post curing 2 h 30 min. at 70°C + 16 h at 100°C+ 24 h at RT

	Test method	
Hardness / Shore D1	ISO 868	87
Glass transition temperature (1) (°C)	ISO 6721-10 : 2015	100
Heat Deflection Temperature (1) (°C)	ISO 75-2 : 2013	93
Flexural modulus of elasticity (1) (MPa)	ISO 178 : 2001	2200
Maximal flexural strength (1) (MPa)	ISO 178 : 2001	84
Tensile modulus of elasticity (1) (MPa)	ISO 527 : 1993	2400
Elongation at maximal tensile strength (1) (%)	ISO 527 : 1993	6,5
Maximal tensile strength (1) (MPa)	ISO 527 : 1993	65
Elongation at break in tension (1) (%)	ISO 527 : 1993	>15
Tensile strength at break (1) (MPa)	ISO 527 : 1993	60
Charpy Impact Strength (1) (kJ.m ²)	ISO 179-1/1eU^b: 2010	48
Hazen Coloration - 50 mm in thickness	ISO2211 : 1973	< 30
Refractive index at 20°C	ISO 489 : 1999	1,51
QUV- B Accelerated ageing. ΔE after 1000 hours		<4

This document can not be, in any case, used as specification data sheet .The values mentioned on this document are based on tests and researches carried on in our laboratories in precise conditions.

It's the responsibility of the user to check the convenience of the product in his own conditions defined and tried by himself. The SYNTHENE Company disclaims all responsibility for any consequence occurred by the use of this product.



LieuDit Ferme de L'Evêché – BP20308
60723 Pont-Sainte-Maxence CEDEX
France
Tél. :03 44 31 72 00 - Tél. international :+33 3 44 31 72 00
Fax : 01 57 67 44 58 - Fax international :+33 1 57 67 44 58
E-mail : contact@synthene.com
<http://www.synthene.com>

Safety for using :

Better wear safety clothes and accessories (gloves and glasses).
For information, read the medical and safety data sheet of the product.

Process with vacuum casting machine :

Pre-heat polyaddition silicone moulds at 70°C
Weigh Isocyanate part in the upper cup (don't forget the residual product)
Weigh polyol part in the mixing cup
After 10 min of vacuum, pour the isocyanate part in mixing cup and mix until total clearness of the mixing (at least 1 min 30 for a process at 25°C)
Pour in the mould
Put the mould in an oven at 70°C for approximately 150 min according to the thickness of the part.

Process with manual casting :

Pre-heat polyaddition silicone moulds at 70°C
Weigh the two parts in a clean mixing cup
Mix manually until total clearness of the mixing (at least 1 min 30 for a process at 25°C)
Pour the mixing in a second clean cup without scraping the cliffs and bottom of the first cup (to prevent from non-mixing area), mix again with clean spatula.
Degas in a vacuum chamber.
Pour in the mould in one step
Put the mould in an oven at 70°C for approximately 150 min according to the thickness of the part.

PACKAGING :

Parcel of : 6 x (0,6 + 1,0) kg
 2 x (3.0 + 5.0) kg

If any other packaging needed, please contact us.

STORAGE : 9 months in original unopened containers and stored between 15 and 25 °C.

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