

Main features

- low-viscous
- easy to process
- low shrinkage
- good curing properties with a long pot life
- based on renewable resources approx. 55%*

Applications

- production of negatives/positives
- universally for all kinds of moulds and patterns

Properties in the non-crosslinked state (approx. values)

		AltroGreen PU 019 Comp. A	AltroGreen PU 010 Comp. B	Unfilled mixture	Mixture filled with NEUKADUR filler B
Colour		beige	yellowish	beige	beige
Mixing ratio	p.b.w.	100	100	-	300
Density (20 °C)	g/cm ³	0.95	1.10	1.05	1.6
Viscosity (RT)	mPa·s	260	100	200	3,100

Properties of the mixture (approx. values)

			Unfilled mixture	Filled mixture
Pot life (RT, 100g)	Minutes		5	9
Demoulding time at 25°C 4 – 5 mm	minutes		-	100
30 – 40 mm	minutes			60
Hardness	Shore D	DIN 53505	65	75

Mechanical values of the cured product (approx. values)

Tensile strength	MPa	DIN 53455	33	15
Tensile elongation	%	DIN 53455	8	4
Flexural strength	MPa	DIN 53452	35	28
Bending elongation	%	DIN 53452	-	2
Modulus in flexure	MPa	DIN 53457	850	2,850
Dimensional stability under heat	°C	According to HDT	45	-
Impact strength	KJ/m ²	DIN 51230	15	8
Compressive strength	MPa	DIN 53454	-	-
Linear shrinkage	%	500 x 50 x 25 mm	-	0.12

*=related to Comp. A

How to process the material

Before using AltroGreen PU 019 Comp. A, mix the same thoroughly until it has got a homogeneous appearance.

Mix both components thoroughly with each other at room temperature (> 18°C) according to the indicated mixing ratio.

Before casting make sure that parts and moulds are free from humidity and non-evaporated release agent.

For layers with a thickness of > 5 mm, we recommend the use of fillers, e. g. NEUKADUR filler B.

We also recommend sharing out the quantity of fillers between both components.

Form of delivery

AltroGreen PU 019 Comp. A	1 kg	5 kg	10 kg	25 kg
AltroGreen PU 010 Comp. B	1 kg	5 kg	10 kg	25 kg
NEUKADUR filler B	1 kg	5 kg	10 kg	25 kg

Storage

We recommend keeping the material in tightly closed original receptacles at temperatures of 20 - 25 °C. When duly stored, the material can be used within the shelf life indicated on the labels (the first 2 digits of the batch number indicate the week, the 3rd digit indicates the year).

Measure of precaution

With the aid of the current safety data sheets, which contain physical, ecological, toxicological and other data relating to safety, the user can inform himself on the safe handling and storage of the products.

Our technical service - in words, in writing or by trials - is given according to the current state of our knowledge. It does however not relieve the customer / user from the duty to check by himself if the products supplied by us are suitable for the intended processes and purposes. Application, use and processing of the products take place beyond our control possibilities and lie therefore exclusively in the area of responsibility of the processor. Any existing property rights of third parties are to be considered. We guarantee the perfect quality of our products in accordance with our general terms and conditions of business. When handling our products you have to observe the legal rules and the rules for the industrial hygiene. As for the rest, we refer to the corresponding safety data sheets.

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