

**AltroGreen PU 04**  
2-C PUR Fast Cast System  
low-viscous, fast curing

**altropol**

**Main features**

- low-viscous
- easy to process
- low shrinkage
- good through-curing with a relatively long pot life
- approx. 40% based on renewable raw materials

**Applications**

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

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

		AltroGreen PU 04 Comp. A	AltroGreen PU 04 Comp. B	Unfilled mixture	Mixture filled with NEUKADUR filler B
Colour		beige	yellowish	white	white
Mixing ratio	p.b.w.	100	100		300
Density (20 °C)	g/cm <sup>3</sup>	0.95	1.15	1.08	1.6
Viscosity (RT)	mPa·s	75	20	40	1,300

**Properties of the mixture (approx. values)**

			Unfilled mixture	Filled mixture
Pot life (RT, 100 g)	minutes		2.5	4
Demoulding time at 25°C				
4 - 5 mm	minutes		10-30	-
30 - 40 mm	minutes		20-40	-
Hardness	Shore D	DIN 53505	70	80

**Mechanical values of the cured product (approx. values)**

Tensile strength	MPa	DIN 53455	30	-
Tensile elongation	%	DIN 53455	4	-
Flexural strength	MPa	DIN 53452	*	*
Bending elongation	%	DIN 53452	-	*
Modulus in flexure	MPa	DIN 53457	*	*
Dimensional stability under heat	°C	according to HDT	*	*
Impact strength	kJ/m <sup>2</sup>	DIN 51230	15	5
Compressive strength	MPa	DIN 53454	-	*
Linear dimensional change	%	500 x 50 x 25 mm	-	0.15

**How to process the material**

Before using AltroGreen PU 04 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 filler between both components.

For release agents, please visit our homepage under <http://www.altropol.de/en/produkte/weitere-produkte/trennmittel>

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**Form of delivery**

AltroGreen PU 04 Komp. A	on request		
AltroGreen PU 04 Komp. B	on request		
NEUKADUR filler B	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.

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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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• [www.altropol.de](http://www.altropol.de) •

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