

Main features

- hard
- machinable
- good dimensional stability under heat
- aluminium-filled

Applications

- surface layer cast
- vacuum thermoforming moulds
- foaming moulds
- foundry facilities

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

		NEUKADUR EN 618	NEUKADUR Hardener SP 6	NEUKADUR Hardener 228
Colour			yellowish	colourless
Mixing ratio	p.b.w.	100	13.5	10
Density (20 °C)	g/cm ³	1.8	0.95	0.9
Viscosity (20 °C)	mPa·s	60,000	800	30

Properties of the mixture and the cured product – tempered step by step for 3 hours up to 120°C (approx. values)

Mixed viscosity (20°C)	mPa·s		40,000	30,000
Pot life (1000 g)	minutes		120	150
Curing time (depending on layer thickness at RT)	hours		24	24
Density	g/cm ³	DIN 53479	1.7	1.7
Hardness	Shore D	DIN 53505	83	85
Elongation at break	%	DIN 53455	3	2
Modulus in flexure	MPa	DIN 53457	4,600	5,800
Flexural strength	MPa	DIN 53452	90	75

How to process the material

Stir up resin component intensively. Filler might have deposited.

Add hardener component under careful but intensive mixing to ensure an optimal wetting and to prevent air inclusions. We recommend letting the prepared casting compound rest for 10 to 15 minutes prior to casting to allow the possibly included air to escape.

The pot life depends on the temperature and the batch size involved.

Recommendation for tempering

After a curing time of 24 to 36 hours at room temperature, we recommend tempering the material step by step to 70° C (2h 40° C, 2 h 60° C, 12 h 70°C). Then let it slowly cool down to room temperature.

Form of delivery

NEUKADUR EN 618	22.9 kg	
NEUKADUR Hardener SP 6	3.1 kg	
NEUKADUR Hardener 228	0.3 kg	1 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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