

Main features

- fast curing
- high capability of being wetted
- low-odour product

Applications

- foundry patterns
- negatives, moulding plates
- control casts
- duplication patterns

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

		NEUKADUR PN 1853	NEUKADUR Hardener H 118 V	NEUKADUR Hardener PU 172
Colour		milky	amber	yellowish
Mixing ratio	p.b.w.	100	50	70
Density 20 °C	g/cm ³	1.0	1.15	1.15
Viscosity 20 °C	mPa·s	90	200	350

Properties of the mixture and the cured product (approx. values after 7 days of storage at room temperature)

Mixed viscosity	mPa·s		120	150
Density (20 °C)	g/cm ³		1.1	1.1
Pot life (RT)	minutes		2.5	3
Demouldable RT	minutes		70	70
Hardness	Shore D	DIN 53505	75	72
Tensile strength	MPa	DIN 53455	33	40
Flexural strength 20°C	MPa	DIN 53452	30	40
Bending elongation	%	DIN 53452	6	7
Modulus in tension	MPa	DIN 53457	470	600
Impact strength	KJ/m ²	DIN 51230	12	14
Dimensional stability under heat	°C	HDT	70	70

(RT = room temperature)

How to process the material

Stir up component A thoroughly.

NEUKADUR PN 1853 is sensitive to humidity. Prior to casting, make sure that parts and moulds are free from humidity and non-evaporated release agent.

To prevent the release agent to be applied later on from soaking into the capillaries of the mould surface, seal porous and sucking mould surfaces such as rigid foam, wood, concrete or plaster down to the pores.

Suitable for this purpose is our NEUKADUR release wax TW.

For demoulding, we recommend our NEUKADUR release agent SE and NEUKADUR release spray P 6.

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

Before mixing the compound, you can stir any quantity desired of suitable fillers into component A and also into the two hardeners. Take extra care that the fillers are absolutely dry.

Observe the indicated mixing ratio.

Form of delivery

NEUKADUR PN 1853	1.00 kg	5.00 kg	10.00 kg	25.00 kg	200.00 kg
NEUKADUR Hardener H 118 V	0.50 kg	2.50 kg	5.00 kg	12.50 kg	25.00 kg
NEUKADUR Hardener PU 172	0.70 kg	3.50 kg	7.00 kg	25.00 kg	

Storage

We recommend keeping the material in tightly closed original receptacles at temperatures of 15 – 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 datasheets, 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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