

NEUKADUR ProtoCast 120 GF

2-C PUR Vacuum Casting System (glass fiber-filled)
PA / ABS

altropol

Main features

- properties similar to those of PA /ABS
- relatively low-viscous
- high dimensional stability under heat
- high impact strength
- high modulus of elasticity

Applications

- prototyping
- small-lot production
- production of technical parts

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

		NEUKADUR ProtoCast 120 GF Comp. A	NEUKADUR ProtoCast 120 Comp. B 1	NEUKADUR ProtoCast 120 Comp. B 2
Colour		black	transparent colourless	transparent colourless
Mixing ratio	p.b.w.	80	100	100
Density (20 °C)	g/cm ³	1.32	1.20	1.20
Viscosity (25 °C)	mPa·s	1,500	1,800	800

Properties of the mixture (approx. values)

Mixed viscosity (25 °C)	mPa·s		1,600	1,200
Pot life (RT, 100 g)	minutes		6	6
Demoulding time (70 °C)	minutes		60	60
Hardness	Shore D	DIN 53505	80	80
Colour			black	black

* RT = room temperature

Properties of the cured product after 1 h 80°C/ 1 h 100°C/ 2 h 110°C (approx. values)

Tensile strength	MPa	DIN 53455	47	52
Tensile elongation	%	DIN 53455	3.5	3
Flexural strength	MPa	DIN 53452	85	91
Bending elongation	%	DIN 53452	6	5
Modulus in flexure	MPa	DIN 53457	2,100	2,400
Impact strength	KJ/m ²	DIN 51230	85	60
Dimensional stability under heat	°C	HDT	110	130
Linear dimensional change (1 h 80°C + 1 h 100°C)	%	500 x 50 x 3 mm	0.3	0.25

How to process the material

Prior to use, homogenize NEUKADUR ProtoCast 120 GF Comp. A thoroughly. Preheat casting mould/tool to 70°C, Comp. A to approx. 40°C. Degas Comp. A for approx. 15 - 20 minutes under full vacuum, then mix both components with each other according to the indicated mixing ratio.

For casting, reduce the vacuum to approx. 100mbars. The indicated mechanical values are only achieved after the above described tempering.

To obtain a heat stability of 110 - 130 °C, you should carry out the following tempering steps:

1 h at 80 °C, 1 h at 100 °C and 2 h at 110 °C.

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

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Form of delivery

NEUKADUR ProtoCast 120 GF Comp. A	0.8 kg	4.8 kg
NEUKADUR ProtoCast 120 Comp. B1	1 kg	6 kg
NEUKADUR ProtoCast 120 Comp. B2	1 kg	6 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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