

Biresin® U1303

Elastomeric Casting system for mould making, Shore A 73 to A 90

Areas of Application

- Casting of flexible moulds for ceramic and gypsum processing
- Moulds for concrete mouldings
- Manufacture of elastic, flexible mouldings and components

Product Benefits

- Insensitive to moisture
- Rubbery
- Good tensile strength and elasticity
- Several hardeners with different potlife for different Shore hardness
- Very low shrinkage
- Dyeable with **Biresin® Farbpasten**

Description

- Basis Two-component-PUR-system
- Resin **Biresin® U1303**, isocyanate prepolymer, colourless-transparent, unfilled
- Hardener **Biresin® U1303**, standard hardener, amine, brownish, unfilled
- Hardener **Biresin® U1402**, amine, beige, unfilled
- Hardener **Biresin® U1419**, amine, brownish-transparent, unfilled

Processing Data		Resin		Hardener	
Individual components		Biresin® U1303	Biresin® U1303	Biresin® U1402	Biresin® U1419
Viscosity, 25°C	mPas	approx. 9.000	approx. 220	approx. 180	approx. 200
Density	g/ml	1.04	1.11	1.11	1.02
Mixing ratio	in parts by weight	100	15	35	10
Mixtures					
Mixed viscosity, 25°C	mPas	approx. 7.500	approx. 4.000	approx. 8.000	
Potlife, RT	min	45	25	15	
Demoulding time, RT	h	16	16	16	
Curing time, RT	d	7	7	7	

Physical Data (approx.-values)

Biresin® U1303 resin			Biresin® U1303	Biresin® U1402	Biresin® U1419
with hardener			amber-transparent	coloured - transparent*	
Density	ISO 1183	g/cm³	1.05	1.05	1.05
Shore hardness	ISO 868	-	A 73	A 81	A 90
Tear strength	ISO 34	N/mm	9	18	30
Tensile strength	ISO 527	MPa	9	10	15
Elongation at break	ISO 527	%	280	400	400
Linear shrinkage	internal	%	0.14	0.1	-

* dependent on raw materials the colour can differ without different mechanical properties

Packaging

Working packages	Biresin® U1303 A+B Pack	6 x 1 kg net resin + 6 x 0.15 kg net hardener in a box
Individual components	Biresin® U1303 resin Biresin® U1303 hardener Biresin® U1402 hardener Biresin® U1419 hardener	200 kg; 20 kg; 10 kg net 1.5 kg net 7 kg; 1 kg net 1.6 kg net

Processing

- The material temperature must be 18 - 25°C.
- It is possible to add Biresin® Farbpaste to the hardener component before processing if required.
- Pay attention to dry conditions and dry mould surfaces while processing.
- The resin and hardener components are to be mixed thoroughly and poured immediately into previously released moulds (e. g. with Sika® Trennmittel 810 or 815 Quick resp. Sika® Trennwachs 818, for more information see Technical Data Sheet).
- Porous surfaces (wood, gypsum) have to be well sealed before processing.

Storage

- Minimum shelf life is 12 month under room conditions (18 - 25°C), when stored in original un-opened containers.
- After prolonged storage at low temperature, crystallisation of components may occur. This is easily removed by warming up for a sufficient time to a maximum of 70°C. Allow to cool to room temperature before use.
- Containers must be closed tightly immediately after use to prevent moisture ingress. The residual material needs to be used up as soon as possible.

Health and Safety Information

For information and advice on the safe handling and storage of products, users should refer to the current Safety Data Sheet containing physical, ecological, toxicological and other safety related data.

Disposal considerations

Product Recommendations: Must be disposed of in a special waste disposal unit in accordance with the corresponding regulations.

Packaging Recommendations: Completely emptied packagings can be given for recycling. Packaging that cannot be cleaned should be disposed of as product waste.

Value Bases

All technical data stated in this Product Data Sheet are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

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Ideeën Krijgen Vorm

Distributeur voor Nederland, België en Luxemburg: Scabro Composites

Vliegveld Valkenburg Wassenaarseweg 75-3265 NL - 2223 LA Katwijk The Netherlands
Tel: +31 (0) 71 4017246 Fax: +31 (0) 84 7402572 Email: info@scabro.com www.scabro.com