Technical Data Sheet

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Dalchem - Flexithane 85

PRODUCT DESCRIPTION

FLEXITHANE 85 is a flexible polyurethane elastomer for producing flexible parts and moulds. The system is suitable for components which are not exposed to high impact, tensile or compression loads. Flexithane 85 is ideal for mould making where parts are to be cast with polyurethane foams, rigid urethanes, plaster, gypsum or concrete. Due to the products low viscosity and long gel time this elastomer gives highly detailed reproduction parts. Accelerated curing of the part or mould can be done at 60-80°C. FLEXITHANE 85 is not formulated for long term external exposure.

PHYSICAL PROPERTIES

Colour:	Translucent Amber
Hardness,	85-87 Shore A
Specific Gravity, gm/c:	1.03 mixed

HANDLING PROPERTIES

Mix Ratio (parts by weight)	Part A **100 : 42** Part B
Viscosity,cps @20°C	Part A: 1100
	Part B: 320
Mix Time:	1 minute, min.
Gel Time:	3-4 minutes.
Demould:	1 Hour nominal. Variable, due to volume of part.
Hardness:	85-87 Shore A. (After 7 days @ 20°C)

It is advisable to preheat both components to 20°C prior to mixing. Elevated temperatures of up to 30-35°C can be used. These elevated temperatures will lower the initial mixed viscosity, however a faster chemical reaction will occur, significantly reducing the gel and pour times.

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