

## **Technical Data Sheet**

Issued: July 2014

## **Dalchem - Flexiclear 25**

**Product Characteristics:** Flexiclear 25 is a low viscosity, two component water clear polyurethane elastomer.

**Benefits:** Flexiclear 25 offers optical clarity, high tear strength, is easily pigmented to bold colours **Applications:** Flexiclear 25 is recommended for applications where a desired thermoplastic feel is required. It is commonly used to make models of all kinds, artwork, and can also be used for electronic component encapsulation.

Colour:	Clear	
Specific Gravity:		1.03 gm/cc
Hardness:		25 Shore A
Pot Life:		15 min
Demould Time:		6 hrs @ 60°c
Application:		Optimum @ 25°c
Mix Ratio:		100:275 by wgt
Shelf life:		6 month from Date of Manufacture
Tensile Strength		1.0 Мра
Elongation		277%
Tear strength		4.1 kN/m

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## Flexiclear 25

**Mould Preparation:** Carefully clean the mould, and then apply a suitable release agent onto the surface. Ensure that the surface is dry before coupling the mould parts. Heat the mould in an oven to 25°c; this may take several hours if the mould is very large. Splitting the tool will speed up the warming process.

**Prepare the mix:** Ensure that Part A and Part B are not below 20°c before using. Ensure both components are stirred mechanically prior to mixing.

Weigh out Part A as required and degas at 1-5mm of vacuum until excessive foaming stops.

Add Part B to Part A and mix thoroughly. Avoid mixing in air. Mixed product can then be degassed at 1-5mmHg vacuum if required.

Pour the mixed liquid into the moulds.

Allow the material to fully cure before demoulding.

Post Curing: Flexiclear 25 will offer a better surface finish and clarity of part when post cured at 60°c for 6-8 hours

Handling Precautions: Avoid breathing in vapors, avoid skin and eye contact.

Always use in a well-ventilated area.

For more details please refer to the **MATERIAL SAFETY DATA SHEET** 

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