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TECHNICAL DATA SHEET

PU 364 A/B

Fast-cast polyurethane system
Unfilled, 100:100 mixing ratio by weight.

PU 364 is an odourless two component polyurethane system which is designed for thin sections, or castings up to 20mm thick that require very quick demould times. The product can be filled for reduced shrinkage.

Main Features

Very rapid demould times

Ultra low viscosity

Good thermal resistance

Simulates Polypropylene

Product Data

	PU 364A	PU 364B	MIXTURE
Material	Polyol	Isocyanate	
Appearance	White liquid	Brown liquid	Beige liquid
Density @ 25°C	0.99 g/ml	1.12 g/ml	1.06 g/ml
Viscosity @ 25°C	50-60 mPa.s	25-35 mPa.s	30-40 mPa.s
Pot life (200 g) @ 20°C			1'50"-2'10"
Demould time 20 g, 2mm @ 25°C			20-25 minutes
Demould time 50 g, 10mm @ 25°C			10-15 minutes

Mould Preparation

Ensure that the mould is clean and dry. If the mould is made from wood, metal or resin, use a release agent. For flexible moulds, use silicone rubber. If the mould is made from wood, ensure the wood is well sealed with varnish and/or wax based release. Never use silicone release agents if the units are to be painted.

Resin Preparation

Shake the Part A container thoroughly in order to homogenise the resin. For best results, make sure the two components are at least 20°C before mixing.

Mixing instructions

When using unfilled, add the correct amount of Part B to the Part A and stir for 15-30 seconds. Pour carefully in one place into the mould in order to avoid air inclusion. If using filled, we recommend the use of a 150% mixing ratio, i.e. for 100 g of A and 100 g of B, 300 g of filler maximum. Use mineral filler for shrinkage reduction, or Aluminium powder for higher temperature applications. Large quantities of material, filled or unfilled, will always produce more exotherm and will gel quicker than smaller amounts.

The casting can generally be demoulded in 15-30 minutes at room temperature. Very thin sections should be allowed at least 30 minutes before demoulding to avoid distortion. The precise demould time will vary with casting thickness, as thin section units will cure slower than thicker section units. When casting thin wall sections, ensure that the mould and resins are at least 20-25°C to facilitate a good cure and reduce the risk of brittleness.

Cured Properties

Property	Cured 48 hrs @ 25°C
Shore hardness (D)	70-75
Linear Shrinkage (500x50x 10 mm)	0.20%
Tensile Strength 130527-2:1993	22-25 MPa
Elongation @ break 180527-2:1993	10-15%
Flexural Strength 180178:1993	30-35 MPa
Flexural Modulus 180178:1993	1000-1350 MPa
Glass Transition (Tg) (D8C)	110°C

Storage

Store both components A and B at 20-25°C. The Part B may crystallise partially or completely if not stored at above 20°C. The two components are moisture sensitive (like all PU's) KEEP THE PACKING TIGHTLY SEALED WHEN NOT IN USE. Moisture absorption will cause excessive aeration in cast parts. Shelf life is 6 months unopened.

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