

## Product information Flexonal® PU 4506

|                        |   |
|------------------------|---|
| <b>Material type</b>   | : Compact cast system<br>Soft setting   |
| <b>Characteristics</b> | : Component A – Flexonal® PU 4506<br>(Polyetherpolyol)<br>Component B – Flexonal® PU 5880<br>(Diphenylmethan-Diisocyanat, MDI)  |
| <b>Application</b>     | : Production of elastic moulds for casting resins and<br>Polyurethane e.g. for. slightly undercut finished parts; castings;<br>small series; copy models; moulds for the concrete industry. |

### General characteristics

|                   | Density (20°C) |                   | Viscosity (20°C) |       |
|-------------------|----------------|-------------------|------------------|-------|
| Flexonal® PU 4506 | 1.04           | g/cm <sup>3</sup> | 2400 ± 300       | mPa*s |
| Flexonal® PU 5880 | 1.22           | g/cm <sup>3</sup> | 150 ± 20         | mPa*s |

### Delivery form

|                  | PU 4506 | PU 5880 |
|------------------|---------|---------|
| <b>Cans</b>      | 30 kg   | 30 kg   |
| <b>Cans</b>      | 60 kg   | 60 kg   |
| <b>Drums</b>     | 200 kg  | 200 kg  |
| <b>Container</b> | 600 kg  | 600 kg  |

### Storage

- Store temperature 15°C – 30°C
- Avoid direct sunshine
- Keep containers under lock and key
- When stored in a tank or in the working container of the machine, avoid contact with non-ferrous metals
- Storage stability 6 month

## Safety instructions

Comprehensive instructions are given in the corresponding Material Safety Data Sheets. They are available on request from Bachmann Kunststoff Technologien GmbH subsidiaries.

## Reaction behavior (Cup test at 20°C, standard value)

|                      |   |   |
|----------------------|---|---|
| <b>Mixture ratio</b> | : | <b>Flexonal® PU 4506</b> = 100 g<br><b>Flexonal® PU 5880</b> = 21 g |
| <b>Pot life</b>      | : | 5 - 10 min.   |
| <b>Density</b>       | : | ca. 1100 kg/m <sup>3</sup>  |

Modifications of the reaction behaviour are available.

## Processing instruction

|                             |   |                                      |
|-----------------------------|---|--------------------------------------|
| <b>Processing machine</b>   | : | All kind of casting machines         |
| <b>Preparation</b>          | : | very good homogenisation before use. |
| <b>Material temperature</b> | : | 23 ± 2°C                             |
| <b>Mould temperature</b>    | : | 40 – 50°C                            |

## Mechanical characteristics

|                                  |   |      |                   |
|----------------------------------|---|------|-------------------|
| <b>Density (DIN 53420)</b>       | : | 1100 | kg/m <sup>3</sup> |
| <b>Härte Shore A (DIN 53505)</b> | : | 18   |                   |

For more detail information about **Flexonal® PU 5880** quod vide separated technical data sheet.

These figures are intended as a guide and should not be used in preparing specifications. The characteristics stated have been determined in accordance with the stated DIN regulations. The test specimens required were taken either from serial coatings or from test plates manufactured under production conditions.