***** Hei-Cast 3453 *****

1. Description

Polyurethane resin of ordinary temperature curing type developed as a sealing agent for automotive and household electrical appliance parts, which requires lens-like coating and transparency for various film sheets, aluminum plates, etc. It has the following features.

(1) A hard resin layer with good weather resistance is obtained.
(2) Because of its low viscosity, it can be easily cast into molds with complex shapes, resulting in molded products with good precision.
(3) It is energy-saving and economical because it cures at room temperature.

2. Basic Properties

項目		数値	備考
Appearance	A Comp.	Pale yellow liquid	Polyols
	B Comp.	Colorless transparent liquid	Isocyanates
Color of Article		Pale yellow	
Viscosity (mPa･s, 25℃)	A Comp.	1600	JIS K-7117
	B Comp.	170	
Specific Gravity (25℃)	A Comp.	1.08	JIS B-7525
	B Comp.	1.12	
Mix Ratio	A:B	100：110	Ratio by weight
Pot Life	25℃	15 分	Resin 105g(A/B=50g/55g)
Hardness	Type D	75	JIS K-7215

3. How to use

(1) Pre-defoaming

Vacuum defoaming is performed for about 5 to 30 minutes in the defoaming chamber beforehand. Be sure to defoam only the amount used.

(2) Resin temperature

Keep the liquid temperature at about 25°C to 30°C for both Solution A and Solution B during casting. If the liquid temperature is high, the pot life will be shortened, and if it is low, it will be longer. Extremely low liquid temperatures can lead to poor mixing or poor curing.

(3) Weighing

Measure Solution A and Solution B accurately. The mixing ratio is the ratio of 100g of solution A to 110g of solution B. The weighing error should be within ±5%.If the mixing ratio is different, not only the specified physical properties cannot be obtained, but also curing failure may occur.

(4) Mixing and stirring

Solution A and solution B are mixed and stirred, followed by vacuum defoaming. Mixing and agitation should be performed thoroughly. In particular, be careful because the walls and bottoms of the containers are hard to mix.

(5) Injection work

Fill the plate, case or mold immediately after vacuum defoaming. Infuse as soon as possible.

(6) Re-defoaming

Vacuum defoaming is performed again as necessary to treat entrained foam, etc.

(7) Curing

When the temperature is applied during curing, the smoothness of the resin surface may be impaired due to differences in curing speed and curing shrinkage. Allow to slowly cure at room temperature.

4. Handling precautions

Since both solution A and solution B are disrupted from moisture, avoid long contact with moisture as well as contamination, and be sure to seal them after use.

5. Safety and health precautions

(1) Solution B is an isocyanate component. Install a local exhaust ventilation system inside the work area and pay close attention to ventilation.

(2) Be careful not to allow the ingredients to come into direct contact with your hands or skin. In case of contact, immediately wash them off with soapy water. Leaving it in contact for a long time may cause rash.

(3) If the ingredients get into your eyes, immediately wash your eyes with running water for 15 minutes and consult an ophthalmologist.