

## \*\*\*\*\* Hei-Cast Z2300 \*\*\*\*\*

## 1. Description

Hei-Cast Z2300 is an antistatic-grade polyurethane resin with physical properties similar to those of ABS resin developed for vacuum-casting.

## 2. Basic Properties

Item		Values	Remarks
Appearance	A Comp.	Black	Polyols
	B Comp.	clear, pale yellow	Isocyanates
Color of Article		Black	
Viscosity (mPa · s, 25°C)	A Comp.	1700	Viscometer Type TPE-100
	B Comp.	200	Viscometer Type BM
Specific Gravity (25°C)	A Comp.	1.09	Standard Hydrometer
	B Comp.	1.20	
Mixing Ratio	A : B	100 : 200	Parts by weight
Pot Life	25°C	6 minutes	Resin 100g
Product specific gravity		1.22	JIS K-7112

## 3. Basic Physical Properties

Item		Values	Remarks
Hardness	Type D	83	JIS K-7215
Tensile Strength	MPa	60	JIS K-7113
Elongation	%	8	
Bending strength	MPa	75	JIS K-7171
Young's modulus in flexure	MPa	1850	
Impact strength	kJ/m <sup>2</sup>	10	JIS K-7110 Izod V Notch
Shrinkage	%	0.3	Inhouse specification
Heat Deflection Temperature	°C	95	JIS K-7191(1.80 MPa)
		100	JIS K-7191(0.45 MPa)
Thermal conductivity	W/m · K	0.25	Probe method
Demold Time	Minute	60	Mold temperature 60 °C or higher

Physical properties listed above are typical values measured in our laboratory and not the values for specification. When using our product, it must be noted that physical properties of final product may differ depending on the contour of article and the molding condition.

## 4. Electrical property

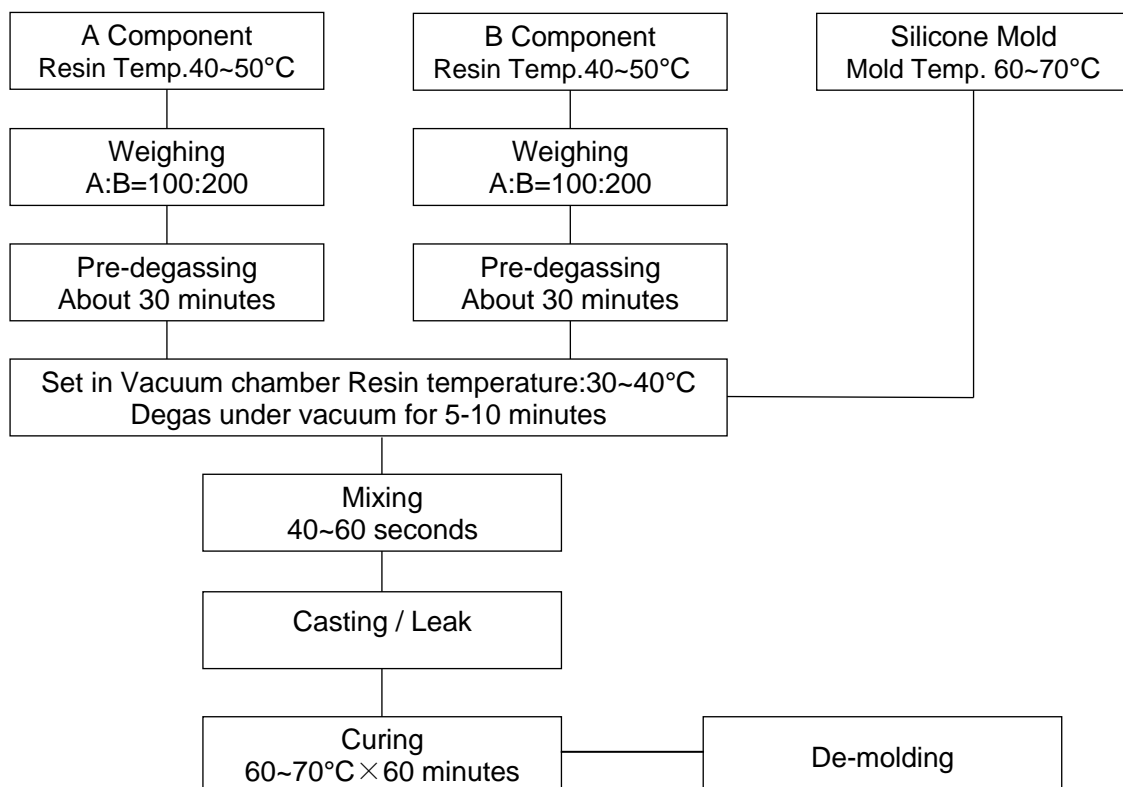
Measurement item	Unit and condition values	Values
Surface resistance	Ω (Applied voltage of 500V)	1.15×10 <sup>6</sup>
Specific Volume Resistance	Ω · cm (Applied voltage of 500V)	7.12×10 <sup>5</sup>

Measuring method: Double ring-electrode method (JIS K-6911)

## 5. Vacuum Casting Process

- Pre-degassing  
Degass both A and B components in a de-gassing chamber for about 5~10 minutes. Degass material as much as you need. We recommend to degas the material which has been pre-heated to temperature of 40~50°C.
- Temperature of resin  
Keep a temperature of 30~45°C for both A and B component during casting. The higher, the liquid temperature, the shorter is the pot life and the lower, the liquid temperature, the longer is the pot life. Extremely too low temperatures may cause insufficient mixing and improper curing.
- Mold temperature  
Keep the temperature of silicone mold to 60~70°C in advance. Too low mold temperatures may cause improper curing to result in lower physical properties. Mold temperatures should be controlled precisely as they affect the dimensional accuracy of the finished article.
- Casting  
Containers are set in such a way that B component is added to A component. Apply vacuum to the chamber and de-gass B component for 5~10 minutes while it is stirred from time to time. Add B component to A component and stir for 40~60 seconds and then cast the mixture quickly into the silicone mold. Immediately inject and leak into the silicone mold. (If the gap between the stirring blade and the container is large, unmixed solution A may remain on the cup wall surface and mix with the product, causing poor curing. Adjust the gap between the stirring blade and the container so that the gap is small.)
- Curing condition  
Place filled mold in thermostatic oven of 60~70°C for 45 to 60 minutes and demold the article. Perform post curing at 70~80°C for 2-3 hours depending on the requirements.

## 6. Flow chart of vacuum casting



### 7. Precautions in handling

- As both A and B components are sensitive to water, don't allow water get into material or don't allow moisture in the air come into prolonged contact with the material. Close container tight after use.
- Penetration of water into A component may lead to generation of much air bubbles in the cured product. If this should happened, we recommend to heat A component to 100°C and degas it under vacuum for about 30 minutes.
- B component will react with moisture to become turbid or to cure into a solid material. Do not use the material when it has lost the transparency or it has shown any hardening as these materials will lead to much lower physical properties.
- B component in part or in whole may freeze when it is stored for longer period of time at temperatures below 5°C. Frozen material can be used after melting. Warm up container to 60 ~70°C for 1~2 hours and use the material after stirring it well.
- B component is prone to deteriorate by the prolonged heating at temperatures over 50°C and the cans can be inflated by the increased inner pressure.
- When B component is stored in a frozen state, it deteriorates more quickly on age than a liquid material. We recommend to melt it completely and store at 20~25°C.

### 8. Precautions in Safety and Hygiene

- B component contains more than 1% of 4,4'-Diphenylmethane diisocyanate. Install local exhaust within the work shop to secure good ventilation of the air.
- Take care that hands or skin are not coming in direct contact with raw materials. In case of contact, wash with soap and water immediately. It may irritate hands or skin if they are left in contact with raw materials for longer period of time.
- If raw materials get into eyes, rinse with flowing water for 15 minutes and call a doctor.
- Install duct for vacuum pump to ensure that air is exhausted to the outside of the work shop.

### 9. Delivery Form

- A Component: 1 kg tin can.
- B Component: 1 kg tin can.

In using our products based on the technical information contained herein, you are requested to thoroughly test our products as to their suitability for your intended application and determine their validity with your own responsibility. As the applications and processing conditions of our products to be applied by users are beyond our control, we can not bear any responsibility for this technical information in terms of accuracy, the results obtained from their use and the possible infringement of patent rights of any third parties.