

Technical Data Sheet

PT FLEX 97

1. PT FLEX 97

Two Part Fast Polyurethane casting rubber System / Shore A 95 – 97 Hardness.

PT Flex 97 is a tough, durable, polyurethane elastomer of 95 -97 Shore A, used for mould making or prototype parts requiring high tear strength and excellent abrasion resistance.

High tear strength • Tough and durable • Excellent abrasion resistance

2. MIX RATIO

	Material	Mix ratio by weight	Pot life (200g, 25°C)	Demould Time (200g, 25°C)	Full cure Time (200 g / 25°C)	Tensile Strength MPa	Elongation at break %	Tear Strength kN/m	Linear Shrinkage	Hardness Shore A
	Aluminium filled epoxy casting system.									
PT Flex 97	Polyurethane	100A:100B	4– 4,5 min.	1 hours.	7 days	9-10	300-400	65-75	< 0,2 %	95-97

3. MOULD PREPERATION

Ensure that the mould is clean and dry and if the mould is made from metal, wood or resin, use a release agent such as Pol-Ease 2300, VL, 2450. Wooden moulds should be sealed well before casting. For flexible moulds, we recommend Eurosil RTV addition Silicone Rubber, please contact our technical department for more advice. Never use silicone release agents if the cast units are to be painted.

4. MIXING INSTRUCTIONS

Shake the PT Flex Comp. A container thoroughly in order to homogenize the resin before start. Ensure that both components are at least 20°C before mixing. Part A should be mixed with Part B according to the indicated mixing ratio. Both components should be thoroughly mixed, care should be taken to avoid air entrapment and make certain that material at bottom and sides of container is thoroughly stirred into the centre. After thorough mixing, the material should be poured into the mould. To avoid air entrapment, pour the material slowly, and into one place in the mould. In order to obtain a bubble free cast, the material should be degassed after mixing and pouring. Mixing, pouring and degassing must be completed within the stated pot life.

5. CURING AND POST CURING

The precise demould time will vary with the casting thickness, as thin sections will cure slower than thicker sections. If cured at room temperature, the casting can generally be demoulded after 1 hour. If quicker demould times are required, the product can be cured at elevated temperatures (up to 70-80°C). Curing at high temperatures will increase shrinkage, but will decrease demould times dramatically.

6. STORAGE

PT Flex part A and part B should be stored in original, unopened containers between 20 and 25°C. Part B may crystallise partially or completely if not stored at above 20°C. Like all polyurethanes, both components are moisture sensitive. Moisture absorption will cause excessive aeration in cast parts. KEEP THE PACKING TIGHTLY SEALED WHEN NOT IN USE OR REPACK THIS WITH POLY PURGE.

If stored under the above conditions, PT Flex 97 part A and part B will have a shelf life of 12 months, from the date of production.

Further Information: This data is not to be used for specifications. Values listed are for typical properties and should not be considered minimum or maximum. Our technical advice, whether verbal, or in writing is given in good faith, but without warranty – this also applies where proprietary rights of third parties are involved. It does not release you from the obligation to test the products supplied by us as to their suitability for the intended process and use. Before using any of our products, users should familiarise themselves with the relevant TDS and MSDS provided by Schouten Group | SynTec.