

Product information Flexonal® VR 80/768

Material type	: Compact polyurethane cast system strong tear-resistance setting
Characteristics	: Component A – Flexonal® VR 80/768 (Polyetherpolyol) Component B – Flexonal® VR 80/910 (Diphenylmethan-Diisocyanat, MDI)
Application	: Production of male and female dies, hard moldings, casings, machine parts, etc.

General characteristics

	Density (20°C)		Viscosity (20°C)	
Flexonal® VR 80/768	1.10	g/cm ³	1100 ± 300	mPa*s
Flexonal® VR 80/910	1.22	g/cm ³	175 ± 20	mPa*s

Delivery form

VR 80/768	VR 80/910
30 kg	30 kg
60 kg	60 kg
200 kg	200 kg
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

(Beaker test at 20°C, standard value)

Mixture ratio	:	Flexonal® VR 80/768 = 100 g Flexonal® VR 80/910 = 65 g
Pot life	:	1-2 min.
Density	:	ca. 1100 kg/m ³

Modifications of the reaction behaviour are available.

Processing instruction

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

Mechanical characteristics

Density (DIN 53420)	:	1100	kg/m ³
Hardness Shore D (DIN 53505)	:	70	
Tensile strength (DIN EN ISO 527)	:	29.0	N/mm ²
Tearing resistance (DIN 53515)	:	37	N/mm
Elongation to break (DIN EN ISO 527)	:	23	%
Temperature stability	:	70 °C	

For more detail information about **Flexonal® VR 80/910** 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.