

Fast Cast 10

General Purpose Polyurethane Casting System

Product data sheet

- Advantages
- Excellent mechanical strength.
 - 5 minute pot life.
 - Low shrinkage.
 - Low viscosity.
 - Good room temperature cure properties.

Applications

- Casting requiring high impact strength.
- Rapid prototyping.
- Fine detail castings.
- Cast up to 5mm wall thickness.
- Can be easily filled.

Introduction

This is an unfilled two component polyurethane casting system designed to be easily mixed and poured by hand.

With a low exotherm and low shrinkage this system can be used for casting very detailed surfaces without trapping air.

Suitable for hand casting or vacuum casting processes.

Product data

Property	Unit	FC 10 Base	FC 10 Hardener
Processing Appearance	Visual	Clear liquid	Amber liquid
Viscosity at 25°C	mPas	90	100
Density	g/cm ³	1.08	1.01

Mix ratio	Parts by weight
FC 10 Base	100
FC 10H Hardener	100
Alumina Filler	300

Processing

- Measure (byweight) the base and the hardener.
- Add the hardener to the base making sure that the required amount of hardener is transferred to the base.
- Stir thoroughly until mixing is complete.
- If a filler is to be used, once the two liquid materials are thoroughly mixed then add the filler slowly and steadily while mixing, taking care not to add air in the process.

Typical Properties

Resin/Hardener mix:	Volume	Unit	FC 10 Base	FC10 Hardener
Appearance			Cream	Amber Liquid
Usable life @ 25°C	250 ml	Minutes	5 - 6	
Gel time @ 25°C	250ml	Minutes	8 - 10	
Demould time		Minutes	45	
Max. cast thickness		mm	5	
Post Cure Schedule:-	14 Hours @	40c		

Density	ISO 1183	g/cm ³	1.1
Hardness	ISO 868	Shore D	70
Deflection temperature	ISO 75	C	80
Flexural Strength	ISO 178	MPa	35
Flexural modulus	ISO 178	MPa	800
Compressive strength	ISO 604	MPa	32
Compressive modulus	ISO 604	MPa	600
Impact strength	ISO 179	KJ /M ²	70
Shrinkage @ 5mm		mm /m	1.2
Peak exotherm		C	40

Storage Conditions

The base resin and hardener described in this instruction sheet have the shelf lives shown provided they are stored at 6 - 28oC in a dry place and sealed containers, preferably those in which they are supplied.

The product should be used when in the temperature range 18-25 C.

Packaging

System

FC 10 Base

FC

10H Hardener

Quantity and Weight

1kg - 5kg - 25kg

1kg - 5kg - 25kg

HANDLING PRECAUTIONS

Please refer to the relevant SDS (Safety Data Sheet) regarding the safe handling of this material.

Note: *All materials, whether innocuous or not, should be handled in accordance with the principles of good industrial hygiene.*

Further technical support or information may be obtained from

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