

TECHNICAL DATA

KIRKSIDE CC60D

HIGH PERFORMANCE COLD CASTABLE URETHANE ELASTOMER

Kirkside CC60D is a premium grade cold castable polyurethane elastomer. The product is free from MOCA (methylene-bis-ortho-chloroaniline) and flammable solvents, which produces an elastomer with outstanding toughness, high elongation, and excellent tear strength and abrasion resistance.

It offers advantages in that it can be readily processed and cured at room or elevated temperatures.

Applications and uses include: moulds, drop hammer faces, metal forming pads, core box liners and foundry patterns.

PRODUCT SPECIFICATIONS

	Part A	Part B
Appearance	Clear, light amber	Clear, light green
Specific Gravity @ 25°C	1.07	1.2
Viscosity @ 25°C (cps)	10,500/1200	420 ± 20

MIXING AND CURING CONDITIONS

Mix Ratio, (Part A / Part B) (pbw)	100/16.5
Temperature of Part A (°C)	25-30
Temperature of Part B (°C)	25-30
Mix Time (minutes)	2-3
Mixed Viscosity @ 25° C (cps)	4500
Pot Life /minutes @ 25°C	6-7
Demould Time @ 25°C (hours)	6-8
Demould Time @ 70°C (hours)	2
Cure	24 hours at 25° C will result in an 80% cure. Fully cured at 7 days at 20° C or a post cure for 4-6 hours at 70° C.

NOTE: Both Part A and B components are moisture sensitive. Once opened, containers should be purged with nitrogen, if they are to be stored for a period of time.

Below 15°C Part A will appear as a white wax like substance. The Part A can be melted by placing the can in a bath of hot water for 15-30 minutes. Care should be exercised in keeping moisture away from the Part A.

This information is of general nature and is supplied without recommendation of guarantee. It does not make claim to be free from patent infringement. Properties shown are typical and do not imply specification tolerances. Kirkside Products cannot accept liability for loss or damage through use. Whilst these technical details are based on expert knowledge, practical experience and laboratory testing, successful application depends upon the nature and conditions in which the products are supplied. Users must, by comprehensive testing, evaluate this product in their own application.

PHYSICAL PROPERTIES

Hardness (Shore D)	60+3
Tensile Strength (MPa)	50.2
Elongation (%)	250
Abrasion Resistance (mm ³)	120
Rebound Resilience (%)	35
Cured Density (g/cm ³)	1.10
Linear Shrinkage @ 23°C (500 mm length x 46mm width x 16mm thick)	0.2

PROCESSING PROCEDURE

1. Carefully weigh the correct proportions of the two components together in one container, mix thoroughly. Be careful not to entrap air whilst mixing.
2. Pour the mixed material into moulds that have been prepared with release agent, being careful to avoid trapping air.
3. Allow casting to cure sufficiently before demoulding.

ADHESION

Adhesion of Kirkside CC60D elastomer to various substrates is at best marginal if a primer is not used. Please consult Kirkside Products for specific recommendations to improve adhesion.

HANDLING PRECAUTIONS

Kirkside CC60D Part A contains small amounts of free TDI. Therefore the product should be used in well-ventilated areas. Avoid breathing in vapours and protect skin and eyes from contact.

In case of skin contact, immediately remove excess, wash with soap and water. For eye contact, immediately flush with water for at least 15 minutes. Call a physician.

If nose, throat or lungs become irritated from breathing in vapours, remove exposed person to fresh air. Call a physician.

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