

PRODUCT DATA SHEET

SikaBiresin® UR132 NT (Biresin® U1320 NT)

ELASTOMERIC CASTING SYSTEM FOR FOUNDRY PATTERN MAKING, SHORE D 62

APPLICATIONS

- Casting of high tear and impact resistant parts and tools, e. g. core boxes and match plates
- Casting of tough-hard coatings

MAIN PROPERTIES

- Both components without toxic classification
- Simple hand casting without postcuring
- Very high abrasion resistance
- Insensitive to moisture
- Short demoulding time without brittleness phase
- Long potlife with **SikaBiresin® UR132 L Neu (B)**
- Very good impact resistance and tensile strength

DESCRIPTION

Basis	Two component polyurethane system
Component A	SikaBiresin® UR132 NT , isocyanate prepolymer, yellowish-transparent
Component B	SikaBiresin® UR132 L Neu , amine, beige

PHYSICAL PROPERTIES

		Isocyanate (A)	Amine (B)
Components		SikaBiresin® UR132 NT	SikaBiresin® UR132 L Neu
Viscosity, 25 °C	mPa.s	~ 14.000	~ 270
Density	g/cm ³	1.10	1.15
Mixing ratio A:B	in parts by weight	100	40
Colour		Beige*	
Viscosity, 25 °C	mPa.s	~ 8,000	
Pot life, room temperature, 500 g	min	~ 16	
Demoulding time	h	> 16	
Curing time	d	3 – 5	

Recommended casting thickness	mm	6 – 8
Machinable (e.g. installation of nozzles)	h	> 24 (depending on casting thickness)

MECHANICAL PROPERTIES

approx. values

		SikaBiresin® UR132 L Neu	
Density	ISO 1183	g/cm ³	1,15
Shore hardness	ISO 868	-	D 62
Tensile strength	ISO 527	MPa	50
Elongation at break	ISO 527	%	330
Abrasion resistance	ISO 4649	mm ³	70

PACKAGING UNITS

- Isocyanate (A), **SikaBiresin® UR132 NT** 10 kg; 5 kg
- Amine (B), **SikaBiresin® UR132 L Neu** 8 kg; 2 kg

PROCESSING DATA

- The material, processing and mould temperature must be at least 18 – 25 °C.
- Component B must be stirred thoroughly before use.
- When using pigments, it is recommended to add max. 1% of SikaBiresin® Colour Paste.
- Add the pigments prior to processing to component B.
- Both components have to be mixed thoroughly according to mixing ratio and poured immediately into the released mould with beginning at the lowest point.
- Porous surfaces have to be well sealed previously.
- If using wood (e. g. laminated wood) as supporting cores or PUR foam plates with low to middle density, a previous sealing is necessary.
- The compatibility of the sealing on PUR foam has to be tested separately.
- Recommended release agents are Sika® Liquid Wax-815 or Sika® Pasty Wax-818. For more information, see Product Data Sheets of the release agents.
- Pay attention to dry conditions and dry mould surfaces while processing.

STORAGE CONDITIONS

Shelf life	<ul style="list-style-type: none"> ■ Isocyanate (A), SikaBiresin® UR132 NT 12 months ■ Amine (B), SikaBiresin® UR132 L Neu 12 months
Storage temperature	<ul style="list-style-type: none"> ■ Isocyanate (A), SikaBiresin® UR132 NT 18 – 25 °C ■ Amine (B), SikaBiresin® UR132 L Neu 18 – 25 °C
Crystallization	<ul style="list-style-type: none"> ■ A visible cloudiness or a solid white consistency of the A component means that crystallization has either just begun or is in an advanced state. ■ This crystallization can be removed by simply heating for a short time at maximum 70°C and then cooling to room temperature again before use.
Opened packagings	<ul style="list-style-type: none"> ■ Containers must be closed tightly immediately after use to prevent moisture ingress. ■ The residual material needs to be used up as soon as possible.

FURTHER INFORMATION

The information herein is offered for general guidance only. Advice on specific applications is available on request from the Technical Department of Sika Advanced Resins. Copies of the following publications are available on request: Safety Data Sheets

BASIS OF PRODUCT DATA

All technical data stated in this document are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

HEALTH AND SAFETY INFORMATION

For information and advice regarding transportation, handling, storage and disposal of chemical products, users shall refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety-related data.

LEGAL NOTICE

The information, and, in particular, the recommendations relating to the application and end use of Sika products, are given in good faith based on Sika's current knowledge and experience of the products when properly stored, handled and applied under normal conditions in accordance with Sika's recommendations. In practice, the differences in materials, substrates and actual site conditions are such that no warranty in respect of merchantability or of fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred either from this information, or from any written recommendations, or from any other advice offered. The user of the product must test the product's suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request.

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PRODUCT DATA SHEET

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NT)

Oktober 2020, Version 01

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