

FLEXICAST® 65

FLEXIBLE HIGH-STRENGTH MOULDING RUBBER 65A POLYURETHANE ELASTOMER

PRODUCT DESCRIPTION

Flexicast 65 is a two part polyurethane elastomer that cures at room temperature to a flexible, high strength mould rubber. Moulds made from Flexicast 65 are durable and require little to no release when casting plasters and waxes. When used with the appropriate release system, Flexicast 65 moulds are excellent for casting FMG, concrete, polyurethane, polyester and epoxy.

The final parts or moulds made from Flexicast 65 will be tough and long wearing, making them ideal for long term moulding requirements. Flexicast 65 can be processed without the aid of vacuum degassing, allowing for larger mould pours and a wider variety of mouldmaking conditions. Flexicast 65 will provide excellent chemical resistance to most casting systems while maintaining a high standard of physical properties.

Physical Properties

Hardness		Shore A	65
Specific Gravity, cured		g/cc	1.04
Colour		Visual	Clear Yellow
Tensile Strength		psi [mPa s]	520 [3.59]
Tear Strength	Die C	pli [kN/m)	145 [25.44]
Elongation		%	1 070
Shrinkage, linear		in/in	Nil

Handling Properties

Mix Ratio	By Weight	Part A	100 pbw
		Part B **	100 pbw
Viscosity	cps @ 25°C	Mixed	3 000
Work Time	100g mass @ 25°C		25 minutes
Gel Time	100g mass @ 25°C		25-30 minutes
Demould Time	@ 25°C		16-24hrs (note 1)
Cure Schedule	7 days ambient; or demould followed with post cure of 6 hours @ 50°C is recommended to promote maximum physical properties. See Mix & Cure.		

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The data presented in this bulletin are in accordance with the present state of our knowledge, and does not absolve the user from carefully checking all supplies immediately on receipt. We reserve the right to alter product constants within the scope of technical progress or new developments. The recommendations made in this leaflet should be checked by preliminary trials because of conditions during processing over which we have no control, especially where other companies' raw materials are also being used. Recommendations for use do not constitute a warranty, either expressed or implied, of the fitness or suitability of the product for a particular purpose.

**** Note:**

- Both components should be mixed before each use to ensure uniformity of the materials. Part B requires stirring or mixing to ensure settled materials are thoroughly combined prior to use.
- Some Part B's may darken with age but cured rubber properties are not affected.

Storage:

- Opened containers of material should be purged with F720 Dry Air Blanket prior to replacing lids or caps, to prevent moisture contamination from humid air.
- Store at room temperature in a dry area.

Master Preparation:

- Porous masters made of timber or plaster may need to be sealed to prevent penetration of the rubber into the pores of the material/master.
- For most applications Stoner E236 or J-Wax will provide adequate release from a sealed or non-porous master.
- For multi-piece moulds, Flexicast will bond to cured Flexicast, ensure a suitable release such as E236 or J-Wax is applied to the cured Flexicast surface prior to pouring.
- Master sealed with Shellac must have sufficient release agent applied as Flexicast will readily bond to a shellac coat surface.
- When in doubt, a small sample pour is always recommended to test for complete curing and proper release.

Mix & Cure

- After correctly weighing Parts A and B, mix thoroughly whilst best avoiding trapping excess air into the rubber. Care must be taken to scrape the sides and base of the mix container to ensure a proper mix
- A common practice is to pour the mixed material into a second container and quickly mix again. This will ensure that no unmixed materials are poured.
- Pour the rubber as soon after mixing as possible for best flow and air release.
- To ensure a bubble free mould, deaerate the mixed Flexicast under vacuum.
- Avoid curing the material in temperatures below 15°C.
- Ultimate properties are achieved after 7 days at room temperature, however moulds can be used with care after curing for 48 hours.

Additives

- FLEXI-FIBRE can be added to the mixed material to thicken the liquid mix to a gel for application by brush or trowel. HDK-N20 can also be used.

Cured moulds

- When pouring plasters and molten waxes in Flexicast 65 release agent is generally not required, however an application of Pure Lube Mould Soap will help reduce air bubbles in plaster and aids release.
- E236 and J-Wax are the best choices for most resin casting systems.
- Water based release agents such as Flexi-Coat is preferred when casting concrete.
- Excess exposure to solvent containing releases should be kept to a minimum when required to reduce the chance of mould distortion due to swelling or shrinkage.
- Shrinkage and swelling may become apparent after repeated casting with resins having strong solvents or porous casting materials such as plaster and cement which can extract oils from the mould surface. Proper choice of mould release can help minimize this.

Pack Sizes Available:

U-FLEXI65-T	1kg
U-FLEXI65-S	2kg
U-FLEXI65-M	8kg
U-FLEXI65-L	36kg

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