

with hand and head



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<https://www.apraktika.hu/en/zero-bubble-poliurethane>

## aP-321 Bubble Free Polyurethane Resin: Technical Data Sheet

This bubble free polyurethane resin system consists of polyol and isocyanate components that cure at room temperature and is suitable for manual processing.

Practically bubbles-free pieces can be cast from this resin without using any vacuuming tools.

Therefore, the surface can be sanded and polished smoothly.

Main properties of the hardened product:

- 7-9 minutes pot time
- off-white base color
- excellent polishability glossy finishing
- odorless
- bubble-free casting



## 1. Instructions for use

1. Prepare the two components (resin / base and catalyst) and mix them separately. Weigh out the amounts of polyol and isocyanate components given in the table below. You can use a simple syringe for volume and pocket scale for weight.
2. Keep the mixing ratio exactly. The technical properties listed below are guaranteed only this case.
3. Do not leave unmixed components on the wall of the mixing bowl.
4. Stir at least for 1 minute to achieve the best result. The polyurethane resin can then be cast.

Crystallization can occur with both the isocyanate and the polyol component.

After opening the bottles possibly use up the resin. Otherwise store under vacuum or oxygen-free environment to keep the resin usability longer.

Ensure the components are mixed at least 18 °C.

## 2. Important Recommendations

- Observe the general health and safety regulations
- Wear protective gloves
- Ensure adequate ventilation
- Wear safety goggles and suitable safe clothing



### 3. Chemical and Physical Properties

	Polyol	Isocyanate	Mixture
Mixing ratio by volume %	100	100	
Mixing ratio by weight %	90	100	
Consistency	liquid	liquid	
Colour	off-white	off-white	off-white
Viscosity at 25 °C (mPas)			80
Density (g / cm <sup>3</sup> ) 25 °C			1,05
Pot life at 25 °C (minutes)			7-9
Hardness Shore A			70
Flexural modulus of elasticity MPa			24,1
Flexural strength MPa			757
Tensile strength MPa			20,7
Modulus of elasticity MPa			922
Elongation at break %			8 %
Compressive strength MPa			24,5
Compressive modulus of elasticity MPa			277
Bending temperature, °C			60
Disassembly time (minutes) after gelation 25 °C,			30 min
Shrinkage %			0,7

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The cured finished product is not classified as dangerous in accordance with Directive 88/379 / EEC and subsequent amendments. The hazards of the components can be seen in another document.

## 4. Shelf Life

This aP-321 bubble-free polyurethane resin is guaranteed for a period of 6 months if stored correctly at a temperature of between 5°- 27°C (41° - 80°F).

Polyurethane resins are sensitive to the oxygen and moisture content of the air, so try for use up as soon as possible.

Isocyanate is light sensitive and should be stored in a dark, airtight or nitrogen-rich container.

Be careful not to interchange the closing caps.

**The advice given verbally, in writing or through demonstrations on the use of the products are based on our knowledge.**

**The use and application of the product by the user lie beyond the control of the company and are therefore the user's own responsibility.**