

Details

JCL FC 11 is an un-filled, low viscosity two component PU fast cast 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.

Advantages

- Low Shrinkage
- Low Viscosity
- Used in rapid prototyping or production, function fit environments.
- Offering excellent demouldable strength at room temperatures.

Applications

- Casting requiring high impact strength.
- Rapid prototyping.
- Fine detail castings.
- Cast up to 10mm wall thickness.
- Can be easily filled.

Product data

Property	Unit	FC 11 Polyol	FC 11 Isocyanate
Appearance	Visual	Clear liquid	Pale liquid
Viscosity at 25°C	mPas	80	80
Density	g/cm ³	1.08	1.12

Mix ratio	Parts by weight
FC 11 Polyol	100
FC 11 Isocyanate	100

Mixing / Processing

These products are rapid curing materials and are generally processed through 2 component meter mixing machines.

Delta Technical Service Department can discuss specific requirements and advise on suitable equipment for evaluation.

The materials in their containers should be thoroughly stirred prior to decanting into the meter mix machine.

If the materials are left loaded in the machine overnight then provision should be made to stir the materials prior to processing.

Typical Properties

Property	Volume	Unit	Result
Appearance		Visual	White
Usable life at 20°C	100 ml	Mins	6 - 8
Demoulding time		Minutes	45
Maximum cast thickness (unfilled)	mm		10

Cured Properties

Test	Method	Unit	Value
Density	ISO 1183	g/cm ³	1.1
Hardness	ISO 868	Shore °D	70 - 75
Flexural strength	ISO 178	MPa	35
Flexural modulus	ISO 178	MPa	840
Tensile strength	ISO 527	MPa	26 - 30
HDT	ISO 75	°C	65 - 70
Impact strength	ISO 179	kJ /m ²	75

(Post Cure Schedule :- 16 Hours @ 80°C)

Storage

The materials described in this instruction sheet should be stored at 15 - 28°C in a dry place and sealed containers, preferably those in which they are supplied.

Working Conditions

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

Packaging

FC 11 Polyol and FC 11 Isocyanate are supplied in 25kg Containers

Handling precautions

For more detailed information please refer to the MSDS (Material Safety Data Sheet).

For further questions relating to processing and application, please contact our technical department.