

TECHNICAL DATASHEET

GRC FLEXIMOULD

GRC Fleximould is a two-part polyurethane rubber with exceptional physical properties yet formulated for ease of use in typical factory conditions.

USES

- For the manufacture of flexible moulds for casting Concrete GRC or Gypsum.

ADVANTAGES

- GRC Fleximould moulds are dimensionally stable and able to withstand the daily rigours of casting, demoulding and handling without damage.

PROPERTIES OF GRC FLEXIMOULD

	A	B
	ISOCYANATE COMPONENT	POLYOL COMPONENT
<i>Product Ref.</i>	7855223	7980295
<i>Colour</i>	Colourless	Red
<i>Viscosity at 25deg.C</i>	5000-9000 cps	500-1000 cps
<i>Specific Gravity at 25</i>	1.02-1.06	1.01-1.04
<i>Mixing Ratio By</i>	1.0	1.0

SYSTEM PROPERTIES

<i>Appearance</i>	RED
<i>Hardness Shore A</i>	45
<i>Elongation at Break %</i>	1000
<i>Angle Tear Strength</i>	24.0
<i>Tensile Strength Mpa</i>	5.4

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STORAGE

The two components of GRC Fleximould are sensitive to moisture and should be stored in a dry environment at 5-30 deg.C. Partly used containers should be sealed immediately after use. When stored according to these instructions there is a shelf life of 12 months.

MIXING

Before using GRC Fleximould or any components please read the appropriate Material Safety Data Sheet.

GRC Fleximould should be used at a ratio of 1 part A Isocyanate to 1.0 part B Polyol

The required quantities should be weighed into separate clean containers. The table below can be used to select the correct mix proportions.

PART A ISOCYANATE	PART B POLYOL
Kgs	Kgs
1.0	1.0
2.0	2.0
5.0	5.0
10.0	10.0

PRIOR TO USE THE TWO COMPONENTS MUST BE THOROUGHLY MIXED IN THE DRUM IN CASE SEGREGATION HAS OCCURRED DURING TRANSPORT AND STORAGE.

ENSURE THAT BOTH COMPONENTS ARE AT THE REQUIRED PROCESSING TEMPERATURE.

Stir the individual components and then add Part B to Part A and mix for 2-3 minutes.

Pour the mixed material into a second container and mix for a further 1-2 minutes. Total mixing time should be 3-5 minutes depending upon the quantity mixed after mixing there should be an even red colour without any streaks.

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When using a mechanical mixer be careful not to create a deep vortex which can entrain large quantities of air which will weaken the cured polyurethane and may show on the mould surface.

When thoroughly mixed pour the rubber onto the centre of the pattern and let it flow to the edges. Continue pouring until the pattern is completely filled. Small quantities of mixed in air will rise to the surface and although not a problem they can be removed by using a hot air blower over the back of the mould as it starts to gel.

The demoulding time will depend upon the temperature and the amount of material mixed but should be a minimum of 6 hours.

CARE OF MOULDS

When not in use moulds should be stored flat in dry conditions out of direct sunlight.