

## DATA SHEET: VACUUM CASTING RESIN 8040

<b>Description:</b>	Low viscosity , good all-round material, similar to polypropylene (PP)		
<b>Features:</b>	Excellent flow properties, easy to colour		
<b>Suitable for:</b>	Thin wall section moulding		
<b>Cured Properties</b>	<b>Test/ISO standard where applicable</b>		
Colour	White		
Transparency	Opaque		
Shore hardness	At 23 °C	70 D	868
	At 60 °C	64 D	
	At 80 °C	37 D	
Flexural strength	42 N/mm <sup>2</sup>		178
Flexural modulus	1050 N/mm <sup>2</sup>		178
Tensile strength	27 N/mm <sup>2</sup>		R 527
Tensile modulus	942 N/mm <sup>2</sup>		R 527
Izod impact	15 kJ/m <sup>2</sup>		180
Yield strength	Not measured		R 527
Elongation yield	Not measured		
Elongation at break	50%		R 527
Tear Strength	Not measured		34
Thermal Conductivity	0.201 W/mK		BS 874
Heat deflection temperature	65 °C	(test piece 110 mm x 12.7 mm x 6.4 mm)	
Glass transition temperature	78 °C		
<b>Processing Information</b>	<b>Notes</b>		
Viscosity	Part A	1200 cPs	At 25 °C
	Part B	140 cPs	
Specific gravity	Part A	1.05	At 25 °C
	Part B	1.22	
Mix ratio A:B	110:90		By Weight
Mixing Time	30 s to 60 s		
Resin temperature	40 °C		Heating Chamber
Mould temperature	70 °C		Heating Chamber
Curing temperature	70 °C		Heating Chamber
Curing time in mould	90 to 120 min		
Pot life	300 s		100 g at 25 °C
Post curing process	None		
Typical shrinkage	0.50%		