

## Description

ALCHEMIX PU 3842 is a two-component polyurethane system, which is designed to simulate thermoplastics such as polypropylene. The system is ideal for rapid prototyping and limited production runs using dedicated metering machinery. The product is ideal for applications requiring high impact resistance and dimensional stability at elevated temperatures.

## Features

- Fast room temperature cure (20 – 25°C)
- Fast demould
- Excellent impact strength
- Contains milled carbon fibre
- Dimensionally stable, even at elevated temperature

## Mix Ratio

	PU 3842A	PU 3842B
By Weight	100	50
By Volume	100	48

## Component Data

	Conditions	PU 3842A	PU 3842B
Description	-	Polyol	Isocyanate
Appearance	-	Black liquid	Brown liquid
Viscosity	25°C	2500 – 5000 mPa.s	150 – 250 mPa.s
Density	25°C	1.12 – 1.17 gcm <sup>-3</sup>	1.16 – 1.21 gcm <sup>-3</sup>

## Cure Data

	Conditions	Typical Value
Appearance	-	Black
Mixed Viscosity	25°C	TBC
Mixed Density	25°C	1.13 – 1.18 gcm <sup>-3</sup>
Pot Life	200g, 25°C	55 – 65 secs
Demould Time	3mm, 25°C	TBC
Maximum Casting Thickness	-	TBC

## Cured Properties

	Standard	Typical Value
Hardness	ISO 868	75 – 80 D
Linear Shrinkage <sup>1</sup>	500 x 50 x 4mm	< 1 mm/m
Tensile Strength	ISO 527	24 – 29 MPa
Elongation at Break	ISO 527	8.0 – 10.0 %
Tensile Modulus	ISO 527	1000 – 1300 MPa
Flexural Strength	ISO 178	31 – 36 MPa
Flexural Modulus	ISO 178	850 – 1150 MPa

<sup>1</sup> See "Shrinkage" section below.

## Mould Preparation

Ensure that the mould is clean and dry and if the mould is made from metal or resin, use a release agent such as Release Agent R7. For flexible moulds, use ALCHEMIX RTV Silicone Rubber. Never use silicone release agents if the units are to be painted.

## Resin Preparation

Stir the Part A can thoroughly in order to homogenise the resin. For best results, ensure the two components are at between 20 – 25°C before use.

## Processing Instructions

ALCHEMIX PU 3842 should be processed using a suitable low pressure RIM machine. For further information on processing ALCHEMIX PU 3842, or for recommended machinery suppliers, please contact Alchemie Ltd.

## Curing

The precise demould time will vary with the casting thickness, as thin section units will cure slower than thicker section units. When casting thin wall sections, ensure that the mould and resin components are at least 20 – 25°C to facilitate a full cure. Post cure is not usually required for this product.

## Shrinkage

The shrinkage value above is quoted as a guide only. Shrinkage will vary with each mould design, as factors such as mould size and geometry can affect the degree of shrinkage. Generally speaking, large, thick castings will have a greater degree of shrinkage than small, thin castings. Other factors, such as mould temperature and resin temperature can also have an effect. Post curing the part can also lead to a greater degree of shrinkage. Please contact Alchemie Ltd for more information.

## Storage

ALCHEMIX PU 3842A and B should be stored in original, unopened containers between 20 and 25°C. ALCHEMIX PU 3842B may crystallise partially or completely if not stored at above 20°C. Like all polyurethanes, both components are moisture sensitive. Moisture absorption will cause excessive aeration in cast parts. KEEP THE PACKING TIGHTLY SEALED WHEN NOT IN USE. If stored under the above conditions, ALCHEMIX PU 3842A and B will have a shelf life of 6 months, from the date of production.

## Packaging

ALCHEMIX PU 3842A is supplied in 5kg and 25kg kits.  
ALCHEMIX PU 3842B is supplied in 2.5kg and 12.5kg kits.  
Please contact Alchemie Ltd for bulk supply.

## Further Information

This is a Preliminary Data Sheet, product data may be revised at a later date following further testing.

This data is not to be used for specifications. Values listed are for typical properties and should not be considered minimum or maximum.

Our technical advice, whether verbal or in writing, is given in good faith, but without warranty. This also applies where proprietary rights of third parties are involved. It does not release you from the obligation to test the products supplied by us as to their suitability for the intended process and use.

Before using any of our products, users should familiarise themselves with the relevant Technical Data Sheet (TDS) and Safety Data Sheets (SDS) provided by Alchemie Ltd.

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