

# ALCHEMIX® PU 3434F

*Two Part, Flexible Polyurethane System  
78 – 83 Shore A Hardness*

ALCHEMIX PU 3434F is a tough flexible polyurethane system of 78 – 83 Shore A, designed specifically for offshore applications requiring good tensile strength and chemical resistance. The system has a fast cure and exhibits a rapid development of properties

## Special Features

- Excellent physical properties
- Good chemical resistance
- Good resistance to sea water

## Mix Ratio

By Weight **PU 3434FA : PU 3434FB**  
100 : 14

## Product Data

Property	Units	PU 3434FA	PU 3434FB	Mix
<b>Material</b>	-	Formulated Polyol	Isocyanate	Polyurethane
<b>Appearance</b>	-	Beige Liquid	Brown Liquid	Beige Liquid
<b>Viscosity (25 °C)</b>	mPa.s	3,000 – 4,000	80 – 110	2,400 – 2,800
<b>Density (25 °C)</b>	g/cm <sup>3</sup>	1.35 – 1.40	1.20 – 1.25	1.34 – 1.39
<b>Pot life (200g, 25 °C)</b>	Minutes	-	-	4 – 6
<b>Demould Time (200g, 25 °C)</b>	Minutes	-	-	30 – 60
<b>Full Cure (200g, 25 °C)</b>	Days	-	-	7

**Cured Properties**

Properties	Standard	Units	Result (Full Cure)
Hardness	BS 2782: Part 3: Method 365B	Shore A	78 – 83
Tensile Strength	BS 2782: Part 3: Method 320B	MPa	2.5 – 3.5
Elongation at break	BS 2782: Part 3: Method 320B	%	65 – 70
Tear Strength	BS 903: Part A3	kN/m	10 – 12

**Mould Preparation**

Ensure that the mould or cavity to be filled is clean and dry. If demould is required, use a release agent such as RELEASE AGENT R7 or use silicone moulds, we recommend ALCHEMIX RTV Silicone Rubber, please contact our technical department for more advice.

**Mixing Instructions**

Stir the ALCHEMIX PU 3434FA container thoroughly in order to homogenize the resin. Ensure that both components are at least 20°C before mixing.

ALCHEMIX PU 3434F can be machine mixed or mixed by hand. ALCHEMIX PU 3434FA should be mixed with ALCHEMIX PU 3434FB according to the indicated mixing ratio. If mixing by hand, care should be taken to avoid air entrapment and make certain that material at bottom and sides of container is thoroughly stirred into centre. After thorough mixing, the material should be poured into the mould. To avoid air entrapment, pour the material slowly, and into one place in the mould. Vacuuming the mixed product can reduce the amount of trapped air in the product, but is not always necessary. Mixing, pouring and degassing must be completed within the stated pot life.

**Curing**

At room temperature, full cure is generally achieved after 7 days. The product can usually be demoulded after 30 – 60 minutes. The precise demould time and cure time will vary with the casting thickness and cure temperature. Thin sections will cure slower than thicker sections. Increased temperature (resin temperature, mould temperature or ambient temperature) will speed up the cure.

**Shrinkage**

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The shrinkage value above is quoted as a guide only. Shrinkage will vary with each casting, 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 3434FA and FB should be stored in original, unopened containers between 20 and 25 °C. ALCHEMIX PU 3434FB 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 3434FA and FB will have a shelf life of 6 months, from the date of production.

## **Packaging**

ALCHEMIX PU 3434FA is supplied in 1kg, 5kg and 25kg containers.  
ALCHEMIX PU 3434FB is supplied in 140g, 700kg and 3.5kg containers.

(Please contact Alchemie Ltd regarding bulk supply)

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## **Further Information**

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 and MSDS provided by Alchemie Ltd.

## **Alchemie Limited**

Alchemie Ltd develop, formulate and distribute Epoxy Resins, Polyurethane Resins, Silicones, Model Boards and Sheet Wax for use in the following applications:

- Electrical encapsulation
- Rapid Prototyping
- Prototypes
- Casting
- Gel Coating
- Laminating
- Model Making
- Master Models
- Flexible and rigid mould making

We offer fast service, technical support, development expertise, innovative products, diverse knowledge and experience.

We are a well-established company, with a high level of investment and experience. We implement BS EN ISO 9001.

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