PRODUCT DATA SHEET

SikaBiresin® UR368

POLYURETHANE CASTING ELASTOMER – SHORE A 89 – COLD CURING

APPLICATIONS

- Production of parts requiring a high abrasion resistance (sanding masks etc.)

MAIN PROPERTIES

- High mechanical properties
- Good hydrolysis resistance
- High abrasion resistance

DESCRIPTION

Basis	Two component polyurethane system
Component A	SikaBiresin® **UR368**, isocyanate, amber
Component B	SikaBiresin® **UR368,** polyol, green*

*dependent on raw materials the colour can differ without changing the mechanical properties

PHYSICAL PROPERTIES

		Isocyanate (A)	Polyol (B)
Components		SikaBiresin® **UR368**	SikaBiresin® **UR368**
Viscosity, 25 °C	mPa.s	18,000	400
Density, 25° C		1.05	1.08
Mixing ratio A:B	in parts by weight	100	25
	In parts by volume	100	24
		Mixture	
Colour		Dark amber*	
Viscosity, 25 °C	mPa.s	5,000	
Pot life, 25 °C, 150 g	min	15	
Demoulding time at 23 °C Demoulding time at 80 °C	h	24 3	
Curing time at 23 °C Curing time at 80 °C (curing after gelification)	h	96 4	
Maximal casting thickness	mm	80	

*dependent on raw materials the colour can differ without changing the mechanical properties

MECHANICAL PROPERTIES

approx. values

Density	ISO 2781		1.09
Shore hardness	ISO 868	Shore A1 / A15	A 89 / A 88
Tensile strength	ISO 37	MPa	30
Tear strength	ISO 34	kN/m	95
Elongation at break	ISO 37	%	900
BASHORE resilience	ASTM 2632	%	48
Linear shrinkage (specimen 250x50x3mm)	-	mm/m	0.80
Abrasion resistance (TABER)	ISO 5470	mg / 100U	4

THERMAL AND SPECIFIC PROPERTIES

approx. values, hardening 4 h and 16 h at 70 °C

Working temperature	-	°C	- 40 / + 80
Glass transition temperature	ISO 11357	°C	- 70
Coefficient of thermal expansion (+0 °C to +40 °C)	ISO 11359	10^{-6} K^{-1}	200

PACKAGING UNITS

■ Isocyanate (A), SikaBiresin® **UR 368**	6 x 1 kg net
■ Polyol (B), SikaBiresin® **UR 368**	6 x 0.25 kg net

PROCESSING DATA

- The material, processing and mould temperature should be at least 18 – 25 °C.
- Recommended release agents are Wax based. For more information, see Product Data Sheets of the release agents.
- Pay attention to dry conditions and dry mould surfaces while processing.
- Both components have to be mixed thoroughly according to mixing ratio and poured immediately into the released mould with beginning at the lowest point.

STORAGE CONDITIONS

Shelf life	■ Isocyanate (A), SikaBiresin® **UR368**	12 months
	■ Polyol (B), SikaBiresin® **UR368**	12 months
Storage temperature	■ Isocyanate (A), SikaBiresin® **UR368**	18 – 25 °C
	■ Polyol (B), SikaBiresin® **UR368**	18 – 25 °C
Crystallization	■ After prolonged storage at temperature lower than 15 °C, crystallization of both components may occur. ■ This is easily removed by warming up for 4 to 6 hours at 50 °C. ■ Excessive heating of both components may cause a degradation of the product temperature > 60 °C or heating time > 12 hours	
Opened packagings	■ Containers must be closed tightly immediately after use to prevent moisture ingress. ■ The residual material needs to be used up as soon as possible.	

FURTHER INFORMATION

The information herein is offered for general guidance only. Advice on specific applications is available on request from the Technical Department of Sika Advanced Resins. Copies of the following publications are available on request: Safety Data Sheets

BASIS OF PRODUCT DATA
All technical data stated in this document are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

HEALTH AND SAFETY INFORMATION
For information and advice regarding transportation, handling, storage and disposal of chemical products, users shall refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety-related data.

LEGAL NOTICE
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