



PRODUCT NAME	U. RESIN XK-019402C,N,K			
◆ USE / Characteristic Product used for vacuum casting polyurethane resin Prototype ports with ABS aspect Easy processing				
Product Name	XK-019402 POLYOL		XK-019402 ISOCYANATE	
Appearance	C: Low viscosity Liquid		Low viscosity colorless Liquid	
Composition	Modified polyol		Modified MDI	
Viscosity	800 – 850 mPa·s	23°C	280–320mPa·s	23°C
Density	1.05 – 1.07	23°C	1.15 – 1.17	23°C
Mixing ratio	100	Weight	200	Weight
Viscosity of Mixture	20 – 25°C / 500 – 600 mPa·s			
Pot life (20 – 25°C)	4.5 – 5.5 minuets at 100g			
Demolding time	30 minutes at 60 – 70°C, 2mm			
★ Typical Cure schedules 1)30 minutes at 60 – 70°C, 2mm 2) 40 minutes at 60 – 70°C, 0.5mm				
Typical Performance	Unites	Test Values		
Hardness	Shore D	80 – 81		
Specific gravity		1.12-1.14		
Tensile strength	MPa	60 – 65		
Flexural strength	MPa	85 – 90		
Flexural modulus	MPa	1900 – 2000		
TG (TMA)	°C			
Heat deflection temperature	°C	97		
Elongation at break	%	10 – 15		
Impact strength (IZOT)	KJ/m ²	9 –11(notched)		
Shrinkage	%	0.2		