

Vac 25

Filled Casting Urethane

Product Description:

Alumilite's Vac 25 provides users with an extremely durable and abrasion resistant rigid urethane that has good overall physical properties and low shrink. The Vac 25 has a mix ratio of 1:1 by weight and needs to be agitated prior to measuring. The material features a 6-8-minute work time with a demold time that ranges from 2-3 hours depending on the mass of the material being cast. The Vac 25 is a great choice for vacuum or thermo form tooling as well as nests, check fixtures, and applications where high abrasion is required. Vac 25 is not recommended for machining as some of the raw materials that provide high abrasion resistance are very hard on tools and bits.

Physical Properties:

Color	Green
Mixed Viscosity (cps)	2,000
Hardness, (ASTM D-2240) Shore D	80
Specific Gravity	1.15
Shrinkage (in/in)	.003
Tensile Strength (ASTM D-638) (psi)	4,000
Elongation (in/in)	<1%
Heat Deflection (ASTM D-648) (Degrees F)	250
Compression (psi)	9,000

General Properties:

Color	"A" Side	Brown
	"B" Side	Green
Mix Ratio		1:1 by wt.
Shelf Life		6 months
Work Time at 75 Degrees F (100g mass)		6-8 minutes
Demold Time at 75 Degrees F (100g mass)		2-3 hours
Full Cure Schedule		72 hours

Packaging:	Quart Kit	2.5 lbs A/2.5 lbs B
	Gallon Kit	10 lbs A/10 lbs B
	5 Gallon Kit	50 lbs A/50 lbs of B