



## DATA SHEET: VACUUM CASTING RESIN 6091

<b>Description:</b>			Simulates ABS
<b>Features:</b>			UV Stable
<b>Suitable for:</b>			Lenses, optical applications
<b>Cured Properties</b>		<b>Test/ISO standard where applicable</b>	
Colour	Colourless		
Transparency	Transparent		
Shore hardness	At 23 °C	81 D	868
	At 60 °C	81 D	
	At 80 °C	78 D	
Flexural strength	101 N/mm <sup>2</sup>		178
Flexural modulus	2835 N/mm <sup>2</sup>		178
Tensile strength	58.9 N/mm <sup>2</sup>		R 527
Tensile modulus	2220 N/mm <sup>2</sup>		R 527
Izod impact	7.3 kj/ m <sup>2</sup>		180
Yield strength	69.8 N/mm <sup>2</sup>		R 527
Elongation yield	Not measured		
Elongation at break	11%		R 527
Tear Strength	Not measured		34
Thermal Conductivity	0.208 W/mK		BS 874
Heat deflection temperature	75 °C		(test piece 110mm x 12.7mm x 6.4mm)
Glass transition temperature	Not measured		
Optical Properties	Refractive Index 1.515	Transmissivity 93.7	
	Diffused lights 0.7	Paralleled lights 93	
<b>Processing Information</b>			<b>Notes</b>
Viscosity	Part A	800 cPs	At 25 °C
	Part B	160 cPs	
Specific gravity	Part A	1.10	At 25 °C
	Part B	1.09	
Mix ratio A:B	100:180		By Weight
Mixing Time	30 s to 90 s		
Resin temperature	40 °C		Heating Chamber
Mould temperature	70 °C to 75°C		Heating Chamber
Curing temperature	70 °C		Heating Chamber
Curing time in mould	120 - 150 min		
Pot life	460 s		100 g at 25 °C
Post curing process	None		
Typical shrinkage	0.7%		

The information in this data sheet is provided for general guidance only and must not be relied upon as a definitive statement of the product's properties or suitability. CBM will not be liable for the consequences of any decision by you to use the product and you must conduct your own testing to determine whether or not the product is suitable for your needs.