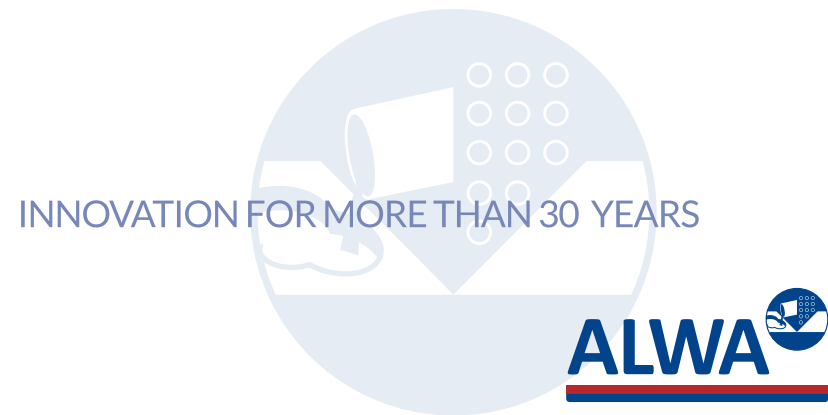




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CASTING RESIN FOR THE THERMOFORMING PROCES

ALWA MOULD D
(patented)



ALWA MOULD D consists of two resin components and an aluminium filler. The fast curing of the material allows to produce technologically highest quality moulds in just one day. **ALWA MOULD D** is characterized by the following advantages:

- Fast curing in approx. 50 min.
- Good castability
- Cast without air inclusions
- Good mechanical finishing
- Post-curing is unnecessary
- High temperature resistance
- Low linear shrinkage
- Highly accurate mould surface reproduction
- Easy casting of small and big quantities (<1 kg – 2500 kg)



Characteristic	Norm	Value	Unit
Temperature resistance	DIN 53462 / ISO 75	~ 135	°C
Short-term exposure		~ 180	°C
Pot life		~ 17 - 20	Min.
Reaction temperature		120 - 130	°C
Hardness		~ ±D86	Shore D
Compressive strength at RT 20 °C / 100 °C		8 - 9 / 7 -8	KN / cm²
Impact strength	DIN 53453	3400 (3,5)	J / n (kJ / m²)
Viscosity of the mixture		~ 7000	mPa s
Specific density		1,7	kg/l
Thermal conductivity	DIN 1341	~ 1 (~ 0,86)	W/mk (Kcal / hm °C)
Linear shrinkage after the curing process (specimen 500 x 100 x 25 mm)		~ ±0,1	%
Vicat softening temperature	DIN 53460	180	°C
Shelf life at 16 °C to 22 °C		~ 18	Months
Thermal expansion coefficient	DIN 53572	10 - 6 / °C 45	