

Technical Datasheet of Hei-Cast 8400

Hei-Cast 8400 and 8400N is a vacuum casting material used for the manufacture of Polyurethane rubber which offers the following characteristics:

1. The hardness can be adjusted within the range of Shore-20 ~ 90 through controlling the amount of C Component;
2. The viscosity is low which allows a good liquidity.
3. It owns fast curing and also has good flexibility.

Project		Technical data		Remarks	
Name		8400	8400N		
Appearance	A Comp.	Black	Transparent	Polyol	
	B Comp.	Clear, pale yellow		Isocyanate	
	C Comp.	pale yellow translucent			
Color of Finished Article		Black	ivory-white	can be tinted	
Viscosity	A Comp.	600		Viscometer Type BM	
	B Comp.	40			
(mPa.s, 25℃)	C Comp.	900			
Specific Gravity(25℃)	A Comp.	1.11		Specific Gravity Cup	
	B Comp.	1.17			
	C Comp.	0.98			
Mixing Ratio	A:B:C	100:100:0	100:100:50	100:100:100	100:100:150
Pot Life	25℃	5-6 MINUTE	5-6 MINUTE	5-6 MINUTE	5-6 MINUTE
Hardness	Shore A	90	80	70	60
Tensile Strength	KG/cm2	180	140	80	70
Elongation	%	200	240	260	280
Bending strength	KG/cm	70	60	40	30
Rebound elasticity	%	50	52	56	56
Shrinkage	%	0.6	0.5	0.5	0.4
Mixing Ratio	A:B:C	100:100:200	100:100:300	100:100:400	100:100:150
Pot Life	25℃	5-6 MINUTE	5-6 MINUTE	5-6 MINUTE	5-6 MINUTE
Hardness	ShoreA	50	40	30	20
Tensile Strength	KG/cm2	50	25	20	15
Elongation	%	300	310	370	490
Bending strength	KG/cm	20	13	10	7
Rebound elasticity	%	60	63	58	55
Shrinkage	%	0.4	0.4	0.4	0.4

The test standard of property strength: JIS K-6301

The test standard of shrinkage: the standard of the company.