

Advanced Materials**RenCast® 6425 A / RenCast® 5425 B**

FOR THE PRODUCTION OF CASTINGS AND IN APPLICATIONS REQUIRING HIGH LEVELS OF TOUGHNESS AND DURABILITY

KEY PROPERTIES

- **Withstand moisture well, thus also suitable for thin layers**
- **High tear strength and elongation**
- **High abrasion resistance**

APPLICATIONS

- Foundry Patterns
- Core boxes
- Abrasion and impact-resistant parts
- Percussion tools
- Impact protection
- Conveyor rollers
- Machinery Parts
- Assembly jigs

PRODUCT DATA

Property	Unit	RenCast® 6425 A	RenCast® 5425 B
Appearance Colour	visual	Liquid brown	Liquid pale yellow
Viscosity at 25°C	mPas	1800 - 3200**	200 - 400**
Density at 23°C	g/cm ³	1.11	1.13

** Specified data are on a regular basis analysed. Data which is described in this document as 'typical' is not analysed on a regular basis and is given for information purposes only. Data values are not guaranteed or warranted unless if specifically mentioned.

TYPICAL SYSTEM DATA**PROCESSING**

Mix ratio	Parts by weight
RenCast® 6425 A	100
RenCast® 5425 B	24

Mix the two components thoroughly in the ratio indicated.

Evacuated material will improve properties. Post-curing will improve final properties.

PROPERTIES

Resin/Hardener mix:	Volume	Unit	RenCast® 6425 A RenCast® 5425 B
Appearance			Brown
Mix viscosity 25°C		mPa s	1900 - 2100
Pot life at 25°C	1000 ml	min	15 - 20
Max. layer thickness		mm	10 - 12
Demoulding time* at 23°C		hours	20 - 24

Density	ISO 1183	g/cm ³	1.20
Hardness	ISO 868	Shore D	60 - 65
Tear propagation resistance	DIN 53356	kN/m	28 - 30
Tensile strength	ISO 527-2	MPas	30 - 35
Elongation at break	ISO 527-2	%	130 - 170
Torsional Test DMA, 2K/Min	ISO 6721	°C	90
Linear shrinkage**		mm/m	1.8
Abrasion***	Taber	mg	1600

* For parts with uniform face-cast layers of 8-12 mm, allow 20 - 24 hours of final cure time prior to demoulding. To avoid creep, always store parts on a flat surface without stressing. Follow recommendation for curing before subjecting the parts to loading.

**Shrinkage measurement using test specimen size 500 x 50 x 10mm

*** Lost weight by 4000 cycles, 60 rpm, 1kg load, S 60 sandpaper strips

STORAGE

Provided that RenCast® 6425 A and RenCast® 5425 B are stored in a dry place in their original, properly closed containers at the storage temperatures mentioned in the MSDS they will have the shelf lives indicated on the labels.

Partly emptied containers should be closed immediately after use.

**WORKING
CONDITIONS**

The product should be used when in the temperature range 18-25°C

PACKAGING

System	RenCast® 6425 A	RenCast® 5425 B
Quantity and Weight	4 x 5 kg	4.8 kg

**HANDLING
PRECAUTIONS****Caution**

Our products are generally quite harmless to handle provided that certain precautions normally taken when handling chemicals are observed. The uncured materials must not, for instance, be allowed to come into contact with foodstuffs or food utensils, and measures should be taken to prevent the uncured materials from coming in contact with the skin, since people with particularly sensitive skin may be affected. The wearing of impervious rubber or plastic gloves will normally be necessary; likewise the use of eye protection. The skin should be thoroughly cleansed at the end of each working period by washing with soap and warm water. The use of solvents is to be avoided. Disposable paper - not cloth towels - should be used to dry the skin. Adequate ventilation of the working area is recommended. These precautions are described in greater detail in the Material Safety Data sheets for the individual products and should be referred to for fuller information.

Huntsman Advanced Materials
(Switzerland) GmbH
Klybeckstrasse 200
4057 Basel
Switzerland

Tel: +41 (0)61 299 11 11
Fax: +41 (0)61 299 11 12

www.huntsman.com/advanced_materials
Email: advanced_materials@huntsman.com



Huntsman Advanced Materials warrants only that its products meet the specifications agreed with the user. Specified data are analysed on a regular basis. Data which is described in this document as 'typical' or 'guideline' is not analysed on a regular basis and is given for information purposes only. Data values are not guaranteed or warranted unless if specifically mentioned.

The manufacture of materials is the subject of granted patents and patent applications; freedom to operate patented processes is not implied by this publication. While all the information and recommendations in this publication are, to the best of Huntsman Advanced Material's knowledge, information and belief, accurate at the date of publication, nothing herein is to be construed as a warranty, whether express or implied, including but without limitation, as to merchantability or fitness for a particular purpose. In all cases, it is the responsibility of the user to determine the applicability of such information and recommendations and the suitability of any product for its own particular purpose.

The behaviour of the products referred to in this publication in manufacturing processes and their suitability in any given end-use environment are dependent upon various conditions such as chemical compatibility, temperature, and other variables, which are not known to Huntsman Advanced Materials. It is the responsibility of the user to evaluate the manufacturing circumstances and the final product under actual end-use requirements and to adequately advise and warn purchasers and users thereof.

Products may be toxic and require special precautions in handling. The user should obtain Safety Data Sheets from Huntsman Advanced Materials containing detailed information on toxicity, together with proper shipping, handling and storage procedures, and should comply with all applicable safety and environmental standards.

Hazards, toxicity and behaviour of the products may differ when used with other materials and are dependent on manufacturing circumstances or other processes. Such hazards, toxicity and behaviour should be determined by the user and made known to handlers, processors and end users.

Except where explicitly agreed otherwise, the sale of products referred to in this publication is subject to the general terms and conditions of sale of Huntsman Advanced Materials LLC or of its affiliated companies including without limitation, Huntsman Advanced Materials (Europe) BVBA, Huntsman Advanced Materials Americas Inc., Huntsman Advanced Materials (UAE) FZE, Huntsman Advanced Materials (Guangdong) Company Limited, and Huntsman Advanced Materials (Hong Kong) Ltd.

Huntsman Advanced Materials is an international business unit of Huntsman Corporation. Huntsman Advanced Materials trades through Huntsman affiliated companies in different countries including but not limited to Huntsman Advanced Materials LLC in the USA and Huntsman Advanced Materials (Europe) BVBA in Europe.

All trademarks mentioned are either property of or licensed to Huntsman Corporation or an affiliate thereof in one or more, but not all, countries.

Copyright © 2014 Huntsman Corporation or an affiliate thereof. All rights reserved.