

**obocastulan® 1600 sand** – polyurethane cast blocks and parts

Application	Properties
<ul style="list-style-type: none"><li>• design studies</li><li>• laminating models</li><li>• vacuum forming moulds</li><li>• checking fixtures</li></ul>	<ul style="list-style-type: none"><li>• very fine surface structure</li><li>• easily machined</li><li>• high edge resistance</li></ul>

Technical data (measured average values)		
Density approx.	1600 kg/m <sup>3</sup>	
Colour	sand	
Compressive strength	105 - 110 MPa	DIN EN ISO 604
Bending strength	75 - 80 MPa	DIN EN ISO 178
Linear thermal expansion coefficient temperature range from approx. 25 - 70 °C	45-50 x 10 <sup>-6</sup> · K <sup>-1</sup>	according to DIN 53752
Shore hardness	88 - 90 Shore-D	DIN 53505
Heat resistance	80 - 85 °C	
min. wall thickness for CCC	50 mm	
max. wall thickness for CCC	350 mm	
min. order volume	200 Liter	
max. cast volume	1000 Liter - The maximum casting volume depends on the geometry of the part.	
Recommended offset for each surface	10 mm	

Storage	The cast blocks and parts must be stored dry, on a flat underground, at room temperature! Strong temperature differences during storage and transport should be avoided.
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<b>Machining</b>	<p>Before machining, the boards should acclimatise at a temperature of 18 - 25 °C.</p> <p>The obocastulan® materials can be machined with all standard wood and metal working machines. The used milling cutters should be made of carbide. Solid carbide for small milling cutters and hard metal carbide blades for larger milling cutter diameters. The geometry of the cutting tools is the same as for the machining of aluminium. However, we recommend that you test your own machines in order to get the best possible results.</p>
<b>Working and safety recommendations</b>	<p>Please read the Material Safety Data Sheet for all necessary information on health and safety at work and the general safety recommendations.</p>
<b>Waste disposal</b>	<p>After prior consultation of the responsible authorities (waste management company, district, trade supervision office, etc.), cured PU foam can be disposed as household or commercial waste in most regions.</p>
<b>Legal notice</b>	<p>All information about the material, the processing and machining are given without obligation to the best of our knowledge and are not to be taken as an assurance of the properties of the material or the processing and application possibilities in individual cases.</p> <p>The user must check the product himself for its suitability for the intended application. In all other respects our terms of sale apply, which can be viewed and downloaded at any time from our homepage <a href="http://www.obo-werke.de">www.obo-werke.de</a>.</p>