

TECHNICAL DATA SHEET

UR 3490 A/B

POLYURETHANE CASTING SYSTEM 67 SHORE D HARDNESS

DESCRIPTION

UR 3490 A/B is a polyurethane surface casting resin designed for foundry tools (patterns, core boxes) on aluminum pre-forms, concrete resin etc.

APPLICATIONS

- Foundry Patterns
- Core Box Linings

PROPERTIES

- Good abrasion resistance
- Good shock resistance
- Quick hardening

PHYSICAL PROPERTIES

Property	Test Method	UR 3490 PART A	UR 3490 PART B	Mixed
Composition		Isocyanate	Polyol	
Mix ratio by weight		100	50	
Mix ratio by volume		100	50	
Appearance		Liquid	Liquid	Liquid
Color		White	Amber to dark amber*	Beige to dark beige*
Mixed viscosity at 77°F (25°C) (mPa.s)	Brookfield LVT	3,000	150	1,500
Specific Gravity at 77°F (25°C)	ISO 1675	1.08	1.08	1.08 (Cured)
Pot life at 77°F (25°C) (142 g) (Minutes)	Gel Timer			14

PROCESSING

Both parts (polyol and isocyanate) have to be mixed at a temperature equal or higher than 64°F (18°C). Part A may be warmed to reduce the viscosity, however, this will shorten the pot life. Before casting, make sure that parts or molds are free of any trace of moisture.

Cured Properties at 74°F (23°C)¹			
Property	Test Method	Units	Test Value
Hardness	ISO 868:2003	Shore A	95
Tensile Strength	ISO 37:2004	psi (MPa)	2,300 (16)
Elongation at break	ISO 37:2004	%	460
Tear strength (un-notched angular specimens)	ISO 34:2004	pli (kN/m)	325 (57)
BASHORE resilience	ASTM 2632:1992	%	53
Abrasion resistance (TABER 1000 revs/ H22)	ISO 5470:1999	mg/100 rev.	80
Working temperature		°F (°C)	-40 to 176 (-40 to 80)
Glass Transition Temperature (Tg)	ISO 11357:1999	°F (°C)	<-58 (<-50)
Coefficient of thermal expansion (CTE) (32° – 104°F, 0° - 40°C)	ISO 11359:1999	ppm/°F (°C)	111 (200)
Linear shrinkage (specimen size 10 in. x 2 in. x 0.125 in.) (250 mm x 50 mm x 3 mm)		%	0.35
Maximum recommended casting thickness		in. (mm)	2 (50)
Demolding time • At 74°F (23°C) • At 176°F (80°C)		Hours	8 2
Complete Hardening time • At 74°F (23°C) • At 176°F (80°C)		Hours	96 4

¹Average values on laboratory prepared test samples, postcured 16 hours at 158°F (70°C).

HANDLING PRECAUTIONS

Normal health and safety precautions should be observed when handling these products:

- Ensure good ventilation.
- Wear gloves, glasses and protective clothes.

For further information, please consult the Safety Data Sheets.

STORAGE CONDITIONS

- This product has a shelf life of 24 months for the resin and hardener as indicated by the expiration date on the container when stored in original unopened containers. Store closed containers at 65°F-85°F (18°C-29°). Partially used containers must be flushed with dry nitrogen and resealed. Materials are sensitive to moisture contamination.

PACKAGING

Packaging information on request, please contact your local sales representative or find your local contact on www.sikaadvancedresins.us

LEGAL NOTICE

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CONTACT

UNITED STATES

Sika Corporation

30800 Stephenson Highway
Madison Heights, Michigan 48071 – USA
Tel.: (+1) 248 588-2270
Fax: (+1) 248 577-0810
E-mail: advanced.resins@us.sika.com
Website: www.sikaadvancedresins.us

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