



PROTOTYPING SYSTEMS

POLYURETHANES & MOLD MAKING SILICONES

EASY PROCESSING • DURABLE • EXCEPTIONAL PROPERTIES

PROTOTYPING POLYURETHANE SYSTEMS

Product	Hardener	Flexural Modulus (psi)	Pot Life (min/g)	Tg (°F)	Shore Hardness	Cured Color	Description & Applications
PX 761	PX 761	Rubbery	10/100	n/a	63 A	Amber	■ System for simulating flexible rubber
PX 1000 NA	PX 1000 NA	200,000	17/200	167	78 D	Off-white	■ Casting system for simulating thermoplastic-like parts, mock ups, and prototypes
TCC-8020	TCC-8021	237,500	17/150	140	75 D	White	■ System for simulating RIM parts, polypropylene parts with thermoplastic characteristics, fastcast, and rapid prototyping
PX 523	PX 5210	321,000	17/156	237	85 D	Clear	■ UV-resistant system for crystal clear, glass/polycarbonate-like, mock up, and prototype parts for high temperature applications
SikaBiresin® PX224	224UF	333,300	1 - 2/150	208	83 D	Light Amber	■ Casting system for vacuum or hand casting used to make high impact strength prototype parts ■ Extremely tough and impact resistant with exceptional hardness and a base that readily accepts color for a range of pigments and thus cured colors
	224F		3 - 4/150	216			
	224		6 - 9/150	201			
	224L	386,000	12 - 16/150	213	85 D		
PX 223 HT	PX 223 HT	334,000	6/90	248	80 D	Black	■ System for parts out of HIPS (High Impact Polystyrene) with superior heat and impact resistance

PROCESSING RECOMMENDATIONS

Not Recommended	Could lead to surface imperfections, bubble entrapment and void space, resulting in loss of optical brilliance
Satisfactory	Brilliant against bottom mold surface, but potential for voids/imperfections in geometrically challenging designs, especially walls and top surface of the casted part
Recommended	Brilliant aspect for all surfaces of the casted part with very low potential for the loss of optical brilliance and/or the entrapment of air
Best	Stunning surface and highest obtainable level of optical brilliance with part free of entrapped air

Based on using a preheated silicone mold (≈158°F/70°C)

Product	Open Casting	Open Casting/ Pressure Pot	Vacuum Degas/ Open Casting	Vacuum Degas/ Pressure Pot	Vacuum Chamber/ Oven
PX 761	Satisfactory	Recommended	Satisfactory	Recommended	Best
PX 1000 NA	Satisfactory	Recommended	Satisfactory	Recommended	Best
TCC-8020/8021	Satisfactory	Recommended	Satisfactory	Recommended	Best
PX 523	Not Recommended	Not Recommended	Not Recommended	Recommended	Best
SikaBiresin® PX224	Satisfactory	Recommended	Satisfactory	Recommended	Best
PX 223 HT	Satisfactory	Recommended	Satisfactory	Recommended	Best

MOLD MAKING SILICONES

Product	Shore Hardness	Tear Resistance (ppi)	Cured Color	Mixed Viscosity	Description & Applications
ESSIL 125 NA	30 A	100	White	20,000	■ Condensation (tin) cure silicone for resin casting, fastcast urethanes, and epoxies. ■ Offered with 2 hardener options
			Blue		
AX-SIL 4240	38 A	120	Translucent	40,000	■ Addition (platinum) cure silicone ideal for reproducing intricate details. ■ Maintains close tolerances for mold-making from 3D printers
ESSIL 245-255	53 A	75	Gray	25,000	■ Addition (platinum) cure silicone with high strength and excellent release for pattern/model shop mold making and tooling applications

Our most current General Sales Conditions shall apply.
Please consult the Data Sheet prior to any use and processing.

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