Product Data

Vacuum Casting Resins

Product Data Sheet	RenPIM™-VG 2185		
Type	Black, Similar to ABS and Polypropylene (PP), high temperature resistant		
Color (Product Color)	Black		Test / ASTM
Mixing Ratio	By weight (A) Polyol : (B) ISO	80 : 100	
Pot Life	Seconds (0.22 lb @ 77°F) (100 g @ 25°C)	330	
Viscosity cps @ 77°F (25°C) (A) Polyol (B) ISO		1600 200	
Specific Gravity g/cc @ 77°F (25°C) (A) Polyol (B) ISO		1.13 1.16	
Hardness @ 77 °F (25°C) Shore A/D		80 D	D-2240
Flexural Strength (psi)		8,700	D-790
Flexural Modulus (psi)		--	D-790
Tensile Modulus (psi)		189,000	D-638
Tensile Strength (psi)		6,500	D-638
Izod Impact (ft.-lbs./in^2) unnotched		3.9	D-256
Elongation @ Break %		34	D-638
Tear Strength (psi)		--	D-624
Thermal Conductivity (W/mK)		--	BS874
Heat Deflection Temp. °F (°C) @ 66 psi Test piece 4.5“ x 0.5“ x 0.25“ (110 x 12.7 x 6.4 mm)		230 – 266 (110-130)	D-648
Yield Strength (psi)		--	D-638
Elongation @ Yield (%)		32	
Minimum Demold Time @ 149°F-158°F (65°C-70°C)		45 min.	
Shrinkage (in/in) According to Wall Thickness		0.002	
POST CURING PROCESS:	*** yes**		
60 min. X 212 F (100 C) = 248 F (120 C)			
60 min. X 230 F (110 C) = 266 F (130 C)			

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Handling Procedure RenPIM™-VG 2185

Mixing ratio (A) Polyol : (B) ISO	80 : 100
Pot life / 0.22 lbs. @ 77°F (100 gr. @ 25°C) (seconds)	330
Resin temperature °F (°C) (Heating chamber)	104 (40)
Mold temperature °F (°C) (Heating chamber)	158 (70)
Mixing time (seconds)	30 – 60
Demold time @ 158°F (70°C) (minutes)	Approx. 45
Post curing procedure	See front page
Primary degassing (minutes)	--

Casting Procedure	Weigh the resins. Measure remaining amount in Cup "A"! Place cups in the machine and start vacuum pump. Switch on mixer motor. After reaching max. vacuum level mix both components together. Mix resins as fast as possible. Pour resin into silicone mold and leak vacuum chamber before the end of pot life.
Special Notes	Exact mold temperature is important. Resin temperature is important. Pre-heat cups in oven to 104°F (40°C). Shake (A) Polyol and (B) ISO component cans before use. Maximum wall thickness is 6 mm (0.24 in.)

Product information

MOLD LIFE	Mold life can be increased by de molding the casting immediately after curing.
Storage - unopened cans	68°F (20°C) / protect against frost
Storage - opened cans	Place opened cans with caps in oven at 104°F (40°C)
In case of crystallization of (B) ISO component	Place (B) ISO can in oven at 158°F (70°C) for 2- 4 hours and stir resin afterwards.

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