

RenPIM[®] Parts In Minutes[®] Rapid Prototyping Polyurethanes Specifications

Product	Mix Ratio Resin to Hrd'nr by vol.	Gel Time (seconds)	Demold Time (min.)	Viscosity Resin Hrd'nr (cps.)	Density (g/cc)	Ultimate Compressi ve Strength (psi)	Hardness (Shore D)	Ultimate Flexural Strength (psi)	Ultimate Tensile Strength (psi)	Flexural Modulus (psi)	Deflection Temp.* (264 psi) (°F)	Izod Impact (ft.lb./in.)	Tg per DMA (°F)	Cured Colors
RenPIM 6450	67:100	45-65	15-30	170 1,600	1.14	23,100	77	7,000	4,900	184,000	208	0.9	306	Buff
RenPIM 6451	67:100	65-85	20-45	170 1,600	1.15	17,900	76	6,900	4,200	174,000	212	0.6	302	Buff
RenPIM 6452	67:100	50-70	15-30	30 1,600	1.15	22,300	79	7,900	4,300	198,000	162	0.8	252	Off-white
RenPIM 6453-1	65:100	50-70	15-30	200 2,000	1.23	20,200	81	7,300	4,600	240,000	174	0.5	275	Buff
RenPIM 6456	50:100	45-65	15-30	170 1,600	1.14	8700	72	5,700	3,800	143,000	190	0.5	270	Buff
RenPIM 6458	100:100	35-60	15-30	75 400	1.21	14,100	86	16,500	10,200	432,000	129	0.9	190	Clear Amber
RenPIM 6460	67:100	45-65	15-30	170 1,500	1.17	24,500	80	7,100	5,400	181,000	232	1.1	320	Buff
ASTM test				D2393	D792	D695	D2240	D790	D638	D790	D648	D256	D4065	

*Deflection Temperature is the temperature when a 1/2 x 1/2 x 5 bar (supported at both ends) deflects 0.010 of an inch under a 264 psi fiber stress. The maximum service temperature may be far above this value depending on the application and the stress of the plastic at high temperature.

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