

Material Properties			Vacuum casting: flexible materials					
Name			6130	9070	UPX 8400-1	KÖRAFORM	T4	RTV 3428
Supplier			SLM	SLM	Axson	CHT	Dow	Bluestar
Material type			PUR	PUR	PUR	Silicon	Silicon	Silicon
Base colour			translucent	colourless	off-white	beige	translucent	translucent
Characterisation			LD PE	Silicon	Silicon			
Physical properties	unit							
Density	g/cm ³		1.15	1.1	1.1	1.3	1.1	1.15
Shore hardness	Shore		A 90	A 70	A 25 - A 95	A 60	A 40	A 28
Tensile modulus	MPa		64					
Flexural modulus	MPa							
Tensile strength	MPa		17	4.3	15**	4.5	6.7	7.5
Flexural strength	MPa							
Elongation to yield	%							
Elongation to break	%		200	255	390**	140	400	600
Impact resistance (unnotched)	kJ/m ²							
Impact resistance (notched)	kJ/m ²							
Tear resistance	N/mm		60	20	11.5**	5	30	20
Glass transition (Tg)	° C							
Heat deflection temp @ 0.46 MPa	° C							
Heat deflection temp @ 1.81 Mpa	° C							
Coeff. of linear expansion (0-100 C)	10 ⁻⁴ K ⁻¹							
Dielectric constant @ (kHz)								
Dielectric strength	kV/mm							
Thermal conductivity	W/mK		0.19	0.2				
Processing								
Shrinkage	%		0.3	0.4				0.1
Colourability			good	unlimited	limited	good	good	good
# parts / mould / day			6 - 8	6 - 8	4 - 6	4 - 6	4 - 6	4 - 6
Turnover* (typical) :	days		2 - 4	2 - 4	2 - 4	3 - 4	3 - 4	2 - 4
Remarks:			* for first moulded part		** values for Shore A 65			FDA