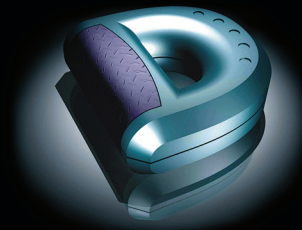


FLAME RETARDANT (VC3385)

Two Part, Flame Retardant Vacuum Casting System
85 - 90 Shore D Hardness



Drumlord Limited
Prototyping Technologies

VC 3385 IS A POLYURETHANE VACUUM CASTING RESIN WITH EXCELLENT MECHANICAL PROPERTIES WHICH PRODUCES PRODUCTS WITH HIGH IMPACT RESISTANCE AND ELASTICITY. VC 3385 IS A FIRE RETARDANT MATERIAL AND IS SPECIFICALLY DESIGNED FOR USE IN GRAVITY VACUUM CASTING MACHINES. THE PRODUCT IS APPROVED TO UL94 V-0.

APPLICATIONS:

- Low volume production
- Pre-production trials
- All applications where a UL94 V-0 rating is required.

PROPERTIES:

- Flame retardant (UL94 V-0)
- Low viscosity
- Excellent physical properties

PRODUCT DATA

PROPERTY	UNITS	MIX
Appearance	-	Straw coloured liquid
Density (25°C)	g/cm ³	1.17 - 1.23

CURED PROPERTIES

PROPERTY	STANDARD	UNITS	RESULT (VAC CAST CURE)
Hardness (25°C)	BS EN ISO 868	Shore D	85 - 90
Linear Shrinkage	500 x 50 x 3mm	%	< 0.2
Tensile Strength	BS EN ISO 527	MPa	80 - 85
Tensile Modulus	BS EN ISO 527	MPa	1500 - 1900
Elongation at Break	BS EN ISO 527	%	6.0 - 8.0
Flexural Strength	BS EN ISO 178	MPa	105 - 115
Flexural Modulus	BS EN ISO 178	MPa	2250 - 2750
Flame Retardancy	UL94 3mm thickness	-	V-0 (File: E213605)

PROPERTY	CURE	TEST METHOD	UNITS	RESULT
Heat Distortion Temperature (HDT)	Standard vacuum casting	TMA	°C	65 - 75
Glass Transition Temperature (Tg)	Standard vacuum casting	DMA	°C	79 - 83
Glass Transition Temperature (Tg)	Post cure (100°C)	DMA	°C	97 - 101

The information in this data sheet, as supplied by the material manufacturers, is provided for general guidance only, in good faith and without warranty. The performance characteristics may vary depending on the application, operating conditions or other materials in combination and it is the responsibility of the customer to determine the suitability of the product for its end use.

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