

Technical Data Sheet

ALCHEMIX® VC 3365

*Two Part Polyurethane Vacuum Casting System
Glass Filled, Extremely High Elastic Modulus*

ALCHEMIX VC 3365 is a two component polyurethane vacuum casting resin designed to simulate glass filled thermoplastics such as glass filled nylon and other polyamides. The system is specifically designed for use in gravity vacuum casting machines. A slow version, ALCHEMIX VC 3365S, is also available.

Special Features

- Glass filled
- Extremely rigid
- High thermal resistance
- Very strong on demould
- Rapid demould

Mix Ratio

By Weight VC 3365A : VC 3365B
100 : 110

Product Data

Property	Units	VC 3365A	VC 3365B	Mix
Material	-	Filled Polyol blend	Isocyanate	Polyurethane
Appearance	-	Beige liquid	Straw coloured Liquid	Translucent white resin
Viscosity (25 °C)	mPa.s	1500 – 3500	200 – 400	500 – 1000
Density (25 °C)	g/cm ³	1.24 – 1.29	1.18 – 1.23	1.21 – 1.26
Pot life (200g, 40 °C)	Minutes	-	-	3 – 4
Demould Time (70 °C)	Minutes	-	-	45 – 60 (depending on thickness)
Maximum Casting Thickness	mm	-	-	20

Technical Data Sheet

Cured Properties

Properties	Standard	Units	Result (Full Post Cure)
Hardness	BS EN ISO 868	Shore D	87 – 92
Linear Shrinkage	500 x 50 x10 mm	%	0.20 – 0.40
Tensile Strength	BS EN ISO 527	MPa	62 – 72
Elongation at Break	BS EN ISO 527	%	6 – 7
Flexural Strength	BS EN ISO 178	MPa	105 – 115
Flexural Modulus	BS EN ISO 178	MPa	2900 – 3300
Heat Distortion Temperature	TMA	°C	90 – 95

Mould Preparation

Carefully clean the mould, then spray silicone release agent onto the surface. Ensure that the surface is dry before coupling the mould parts. Heat the mould in an oven to 60 – 70 °C; this may take several hours if the mould is very large. Splitting the tool will speed up the warming process. We do not recommend the use of condensation cured silicone rubber with this product. For best results, use ALCHEMIX RTV 250 silicone rubber.

Resin Preparation

Open both A and B containers and examine for any signs of crystallization, place in the oven at 45 – 60 °C if any crystals are observed. Both components should be heated to 40 °C before use. If using pigments, add the pigment to the part A. We suggest using 1 – 3% pigment.

Mixing/casting

Weigh ALCHEMIX VC 3365A into cup A and ALCHEMIX VC 3365B into cup B. When making the first mix allow an additional amount of A to account for the cup loss. Degas for at least 5 minutes, whilst slowly mixing cup B. After degassing, pour cup A into cup B while mixing. Mix the A and B components for 45 seconds, this will ensure thorough mixing of the components. When mixing is complete pour the mixed material into the mould. When material can be seen exiting from the risers break the vacuum.

Technical Data Sheet

Curing

Place the mould in an oven at 70 °C for 45 – 60 minutes immediately after casting. Curing time, especially in thin sections, will depend on mould temperature. The warmer the mould, the quicker the cure. We do not recommend this resin to be cast to more than 20 mm depth.

Post Cure

To achieve full high temperature properties, a step wise post cure treatment is recommended. Heat to 70 °C for 1 hour, followed by 80 °C for 2 hours, followed by 110 °C for 2 hours. Then allow the product to slowly return to room temperature. The product can be used without post cure or with partial post cure, but will not achieve full high temperature properties.

Storage

ALCHEMIX VC 3365A and B should be stored in original, unopened containers between 20 and 25 °C. ALCHEMIX VC 3365B may crystallize partially or completely if not stored at above 20 °C. Like all polyurethanes, both components are moisture sensitive. Moisture absorption will cause excessive aeration in cast parts. KEEP THE PACKING TIGHTLY SEALED WHEN NOT IN USE.

If stored under the above conditions, ALCHEMIX VC 3365A and B will have a shelf life of 6 months, from the date of production.

Packaging

VC 3365A is supplied in 910g containers.
VC 3365B is supplied in 1kg containers.

Further Information

All data listed relates to typical values. This data should not be considered a product specification.

Our technical advice, whether verbal, or in writing is given in good faith, but without warranty – this also applies where proprietary rights of third parties are involved. It does not release you from the obligation to test the products supplied by us as to their suitability for the intended process and use.

Before using this product users should familiarize themselves with the relevant MSDS provided by Alchemie Ltd.

Technical Data Sheet

Alchemie Limited

Alchemie Ltd develop, formulate and distribute Epoxy Resins, Polyurethane Resins, Silicones, Model Boards and Sheet Wax for use in the following applications:

- Electrical encapsulation
- Rapid Prototyping
- Prototypes
- Casting
- Gel Coating
- Laminating
- Model Making
- Master Models
- Flexible and rigid mould making

We offer fast service, technical support, development expertise, innovative products, diverse knowledge and experience.

We are a well-established company, with a high level of investment and experience. We implement BS EN ISO 9001.

Alchemie® and Alchemix® are registered Trademarks of Alchemie Ltd, Warwick Road, Kineton, Warwick, England, CV35 0HU, England, United Kingdom. Ph: +44 (0)1926 641600; FAX: +44 (0)1926 641698