



Processing notes for Biothan - Biodur casting resin systems

- Consider processing temperatures, lower temperatures extend, higher temperatures shorten the working time.
- Other amine-group containing resins like Epoxy or PU systems can have influence on the pot life.
- Humidity should be avoided during processing.
- After longer storage resin and hardener should be stirred.
- Always add the resin in the proper proportion to the hardener.
- Mix evenly approx. 30 seconds, more ideally, fills over the mix into a 2nd container and mix briefly again.
- To avoid air entrapment the mixture must be vacuumised thoroughly; pouring under vacuum is also possible.
- Lock containers after use and protect against humidity.
- Consider processing and deform times from the form of the respective casting system.
- Castings with small wall thicknesses and some of the transparent versions should be tempered by 80°C for approx. 1-2h. With the RS and RSS types (fast curing) this tempering isn't necessarily!
- A preliminary heating of the casting form to 45 °C is possible, this shortens the releasing times (execute preliminary tests, also regarding dimensional accuracy).
- Attention when using casting forms already used (epoxy -, Pu-castings, etc.), unwanted reactions with residual substances can occur, which can influence the casting result negatively!
- When using silicone rubber as casting form, volatile constituents of the silicone rubber unwanted reactions can occur, which can impair in particular the surface quality of the castings!