RIM 620

Fire resistant

High mechanical performances

Best PU RIM technology on the market

Product performances

- Developed to long **lasting use**
- **Very easy** to set up
- **Compatible** with Low Pressure machines
- **Comply** with EC in force
- **Certified UL94V0 (3mm) - *www.ul.com***
- **Conform ROHS**
- **Quick setting system**
- **2 Colors (black and beige)**
- **Easy painting**

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Applications

Every parts located in public area

- Electrical industry : gaskets receiving electrical equipment
- Engine housing
- Medical applications (medical instruments, scanner, MRI, …)
- Front of cash dispensers
- Diverse technical parts

Blows out

Comparison with RIM 610

RIM 620 made to replace the RIM 610
The principal material became toxic at the end of 2013
as a result of the evolution of the regulation

	RIM 620	RIM 610
MIX RATIO	100 / 68	100 / 100
POT LIFE (sec)	60 – 80	50 - 70
Mix viscosity (mPa.s)	3500	6000
Demoulding time (min)	20	15 - 20
E-Modulus (mPa)	2.500	2.100
IMPACT (kJ/m²)	18	13
TG (°C)	100	105
CTE (10^{-6} K^{-1})	80	100
COLOUR	BE + BK	BE + BK
UL RANKING	94 V0 3 mm	94 V0 3 mm
ROHS Conformity	YES	NO

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Recommandations

Moulds	Epoxy resin and aluminum
Post curing / Stabilization	2h at 80 C
Moulds temperature	From 50 to 70 C
Components temperature	From 20 to 40 C

① **Polyol must be stirred carefully before pouring in the machine tank as usual for all filled systems.**
Machines equipped with gears pumps could be used for RIM 620 dispensing as the fillers are not abrasive and cannot make any damages to the pumps.

② **To allow a better viscosity and mixing, polyol could be heat up to 30 to 40 C in the tank. In such case the machine must be equipped of recirculation circuit or stirring device. Dynamic mixing heads give better results than static heads.**

③ **Moulds could be made of resins (fastcast, epoxy resins, metal). Release agent 851 is well adapted for RIM 620 injection.**

④ **Release agent : Apply at least 3 layers, prior to process to the first injection. Afterward when production is running only apply a thin layer of 851 at each casting.**

⑤ **Although injection process could be done at Room temperature the advised ideal moulds temperature is from 40 to 60 C in order to achieve shorter demoulding time and immediate properties.**

⑥ **Parts must be stored with caution : Just after release from mould to avoid deformation when cooling down. Some partial fixture should be used to stabilize complicated parts.**

⑦ **Post curing : treatment to get final thermal properties use fixtures to support the part in order to avoid deformations.**

⑧ **Painting : make a thermal treatment if the painting process include a thermal curing of that paint. Sand the surface prior to apply a primer before final tinted layer.**

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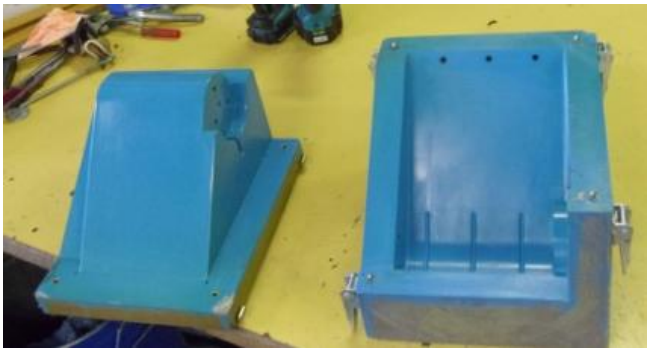
Ancilliary products

- **Demoulding for the means of implementation of the RIM 620 :**
  - Demoulding 851
  - Demoulding 870
- **Moulds :**
  - Epoxy resin
  - Fastcast
  - Machinable board
- **Gelcoat :** GC1 080 gelcoat
- **Resin :** EPO 4030 (cast)



Mould example

CODE	DESIGNATION	PACKAGING
09167	RIM 620 BG Polyol	25 kg
09129	RIM 620 BK Polyol	25 kg
09130	RIM 620 ISO	17 kg
09131	Kit RIM 620 BK	17 + 25 kg
09186	Kit RIM 620 BG	17 + 25 kg

Adhesive : Adekit A310-1

RIM 620 part bonding

Photo crédit : Société INR S.A

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