

Product	Initial consistency	Final consistency	Final Hardness Shore A	Maximum removal constraint*	Working Time at 20°C	Curing Time at 20°C	Accuracy		
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FLUID PRODUCTS IN 50 ML CARTRIDGES

F20	Fluid	Very Flexible	20	30%	+/- 1:30 mn	+/- 8 mn	+/- 1µm		
F30 Max	Fluid	Very Flexible	30	40%	+/- 2:00 mn	+/- 25 mn	+/- 1µm		
F30 Visual	Fluid	Very Flexible	30	20%	+/- 1:30 mn	+/- 10 mn	+/- 1µm		
F40	Fluid	Flexible	40	35%	+/- 1:30 mn	+/- 10 mn	+/- 1µm		
F50	Fluid	Semi-Flexible	50	10%	+/- 1:00 mn	+/- 8 mn	+/- 1µm		
F65	Fluid	Semi-Flexible	65	5%	+/- 1:00 mn	+/- 6 mn	+/- 1µm		
F85	Fluid	Rigid	85	0%	+/- 0:20 mn	+/- 1 mn	+/- 1µm		

FLUID PRODUCTS IN BIG VOLUME (400ML - 1,7L - 10,2L)

F20 XL	Very Fluid	Very Flexible	20	30%	+/- 10 mn	+/- 25 mn	+/- 1µm		
F30 XL	Very Fluid	Flexible	30	15%	+/- 10 mn	+/- 25 mn	+/- 1µm		
F50 XL	Very Fluid	Semi-Flexible	50	5%	+/- 10 mn	+/- 25 mn	+/- 1µm		
F70 XL	Very Fluid	Semi-Flexible	70	0%	+/- 10 mn	+/- 25 mn	+/- 1µm		
F85 XL	Very Fluid	Rigid	85	0%	+/- 10 mn	+/- 25 mn	+/- 1µm		

PASTY PRODUCTS IN 50 ML CARTRIDGES

P25	Pâteux (0)	Flexible	25	30%	+/- 1:30 mn	+/- 8 mn	+/- 1µm		
P35	Pâteux (0)	Flexible	35	20%	+/- 1:30 mn	+/- 8 mn	+/- 1µm		
P80 Ra	Pâteux (0)	Semi-Rigid	80	0%	+/- 0:30 mn	+/- 6 mn	+/- 1µm		
P51 SD	Pâteux (0)	Rigid	100	0%	+/- 0:20 mn	+/- 1 mn	+/- 1µm		

MANUAL PUTTY PRODUCTS (90 ML - 900 ML)

M25	Malléable	Flexible	25	15%	+/- 0:45 mn	+/- 4 mn	+/- 10µm		
M60	Malléable	Semi-Flexible	60	5%	+/- 1:00 mn	+/- 8 mn	+/- 10µm		
M70	Malléable	Semi-Flexible	70	5%	+/- 0:45 mn	+/- 4 mn	+/- 10µm		
M80 Lp	Malléable	Semi-Rigid	80	0%	+/- 8:00 mn	+/- 30 mn	+/- 10µm		
M90	Malléable	Rigid	90	0%	+/- 0:45 mn	+/- 4 mn	+/- 10µm		



Cut with the Twin Blade Cutter

Create a slice to measure the cross-section on a profile projector.



Possible to measure with contact

Only with low force instruments, suitable for soft materials.

PLASTIFORM Solutions

Dimensional Control

Easily control and measure hard-to-access features (thread, groove, bore...) and avoid destructive testings !



Roughness Control Ra

The roughness Ra can be measured directly on the **P80 Ra** impressions (and only on this product).



Visual Surface Finish Control

Check the surface finish, and detect every defect (striations, mechanical damages...).



Protection, Masking and Seal

Against surface treatments, impacts, erosion, sandblasting, chemical treatments, painting, coating...



Fix, Maintain and Clamp

Create custom-made fixing platforms and clamping molds in few minutes.



Create accurate Replicas

Produce exact duplicates to control forms or wear, without having to move the original part.

Add strength to fragile parts

Avoid vibrations and buckling during machining, and rigidify thin-wall parts.

How to choose your PLASTIFORM® ?

1 Choose the Initial Consistency of your PLASTIFORM®



FLUID PRODUCTS **F**

With a «liquid» consistency, these products are «self-placing» and can be poured easily, even in very small details (thread, small bore...). They are recommended for internal total casts, and for applications requiring flowing material.



PASTY PRODUCTS **P**

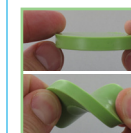
Non-flowing, these products are used for sectorial casts (internal or external), and can be applied on vertical or overhead surfaces.



MANUAL PUTTY PRODUCTS **M**

With a «modeling clay» consistency, these products are mixed and applied by hand, to create external or internal sectorial casts.

2 Choose the Final Hardness of your PLASTIFORM®

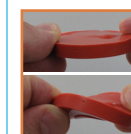


FLEXIBLE IMPRESSIONS

20-40 SHORE A

They accept a strong **Removal Constraint*** (up to 40%). The impression can be misshaped and stretched to be removed from its mould, then it will nevertheless invariably return to its original shape.

How to control the impression : Non-Contact Measurement (optical control, profile projector, laser scan...).



SEMI-FLEXIBLE IMPRESSIONS

50-70 SHORE A

They accept a low **Removal Constraint*** (up to 20%). The impression can be slightly misshaped to be removed from its mould, and return to its original shape.

How to control the impression : Non-Contact Measurement (optical control, profile projector, laser scan...) with the help of the Twin Blade Cutter.



SEMI-RIGID AND RIGID IMPRESSIONS

80-100 SHORE A

They do not accept any **Removal Constraint***, because of their rigidity. How to control the impression : Contact or Non-Contact Measurement (caliper, micrometer, optical control, profile projector, laser scan...).

3 Select the required PLASTIFORM® in the Products Table

The 7 unique technical features of PLASTIFORM® compounds :

■ Virtually no shrinkage

This polymerization, which lasts for approximately 6 minutes, does not lead to any loss of volume.

■ Micron accuracy (µm)

PLASTIFORM® products imitate all details of a surface (dimensions, form, surface finish...) to a precision better than 1 µm.

■ Shape retention memory

When solid, the PLASTIFORM® shape will return to its form, even if temporarily distorted.

■ No adhesion, no residue ⁽¹⁾

The PLASTIFORM® can be applied on every kind of surface⁽¹⁾ (metals, alloys, PVC, wood, plaster etc...), even under water.

■ Environmentally friendly

Non toxic, non polluting. PLASTIFORM® products can be handled with no specific precautions (except for Resin products).

Not subject to the REACH Regulation.

■ Dimensional stability

The cast will not degrade over time, and can be used for future reference.

■ Resistance ⁽¹⁾

PLASTIFORM® products are resistant to most chemical, mechanical and heat treatments (up to 250°C).

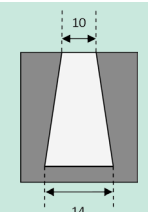
⁽¹⁾ a preliminary test is recommended.

* The Removal Constraint :

When making a replica casting, some internal complex forms can make it difficult to remove the impression from the mold: groove, thread, undercuts, internal angle...

It is called a **Removal Constraint** (or backdraft), and is calculated with the following formula :

$$1 - \left[\frac{\text{Minimum Dimension of the extraction hole}}{\text{Maximum Internal Dimension}} \right] = \text{Removal Constraint (\%)}$$



Example:
 $10 / 14 = 0,71$
 $1 - (0,71) = 0,29 = 29 \%$
Removal Constraint
29 %