

## Rapid Cast / Flame Retardant / Low viscosity

Flame retardant elastomer

### Key Properties

- Excellent physical properties after RT cure
- Free of mercury, MOCA or TDI
- UL94 V-0 certified and yellow card certified
- Low viscosity, allowing for better mold-flow

### Applications

- Formulated for room temperature meter-mix dispensing systems and short mold cycle times

### Processing Properties

			Resin (Isocyanate)	Hardener (Polyol)
Mix ratio		pbw	100	33
		pbv	100	36
Density	ASTM D-792	g/cm <sup>3</sup>	ca. 1.16	ca. 1.06
Viscosity at 77°F (25°C)	ASTM D-2393	cP	ca. 100	ca. 1,800

			Mixture
Mix viscosity at 77°F (25°C)	ASTM D-2393	cP	ca. 500
Gel time at 77°F (25°C)		sec	30-50
Demold time at 77°F (25°C)		min	10-20

### Cured / Mechanical Properties (approximate values)

Cure 1: 7 days at 77°F			Cure 1
Aspect	visual		Buff
Density	ASTM D-792	g/cm <sup>3</sup>	1.14
Shore hardness D	ASTM D-2240		70-80
Deflection temperature, HDT (66psi)	ASTM D-648	°F (°C)	167 (75)
Tensile strength	ASTM D-638	psi	6,000
Elongation at Break	ASTM D-638	%	8
Flexural strength	ASTM D-790	psi	8,200
Flexural modulus	ASTM D-790	psi	225,000
Notched Izod	ASTM D-256	ft·lbf/in	0.5
Linear shrinkage	ASTM D-2566	in/in	.001-.005

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### Processing

**The processing and material temperature should be between 68-77°F (20-25°C).**

RC-542 can be used at room temperature. Meter-mix equipment is recommended due to the short working life of the formulation.

**Agitate hardener before mixing to ensure that the formula is homogeneous.**

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### Packaging

RC-543 Quart Kit	2.66 lbs.
RC-543 1 Gal. Kit	10.64 lbs.
RC-543 5 Gal. Kit	53.2 lbs.
RC-543 Drum Kit	598.5 lbs.

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### Storage

Original containers should be kept tightly sealed and stored at ambient temperatures 59-86°F (15°C to 30°C). If properly stored the products have the shelf-life indicated on the product label.

Partly used containers should always be sealed appropriately and used up as soon as possible.

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### Handling Precautions

Good workplace ventilation is to be ensured during processing. At the same time, the employer's liability insurance association's industrial hygiene safety regulations regarding the handling of reaction resins and their hardeners are to be observed. Please take heed of the appropriate safety data sheets.

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