

Water Clear For Mass Castings

Water-clear, semi-rigid polyurethane formulated

Key Properties

- Excellent physical properties after RT cure
- Free of mercury, MOCA or TDI
- Excellent optical clarity as well as U.V. stability
- Specially formulated for mass castings into either tin or platinum silicone molds

Applications

- For room temperature hand-batch or vacuum assisted casting methods

Processing Properties

			Resin (Isocyanate)	Hardener (Polyol)
Mix ratio		pbw	100	57
		pbv	100	59
Density	ASTM D-792	g/cm ³	ca. 1.13	ca. 1.10
Viscosity at 77°F (25°C)	ASTM D-2393	cP	ca. 450	ca. 1,300

			Mixture
Mix viscosity at 77°F (25°C)	ASTM D-2393	cP	ca. 650
Gel time at 77°F (25°C)		min	80-120
Peak Exotherm	200gr	°F (°C)	125 (52)
Demold time at 77°F (25°C)		h	16-24

Cured / Mechanical Properties (approximate values)

			Cure 1	Cure 2
Cure 1: 24 hours at 77°F + 16 hours at 150°F				
Cure 2: 7 days at 77°F				
Aspect	visual		Water Clear	Water Clear
Density	ASTM D-792	g/cm ³	1.10	1.10
Shore hardness D	ASTM D-2240		75-85	75-85
Deflection temperature, HDT (66psi)	ASTM D-648	°F (°C)	203 (95)	129 (54)
Tensile strength	ASTM D-638	psi	10,500	8,000
Elongation at Break	ASTM D-638	%	8	8
Tensile modulus	ASTM D-638	psi	265,000	230,000
Flexural strength	ASTM D-790	psi	16,000	14,000
Flexural modulus	ASTM D-790	psi	345,000	350,000
Notched Izod	ASTM D-256	ft·lbf/in	1.1	0.3
Linear shrinkage	ASTM D-2566	in/in	0.001-0.005	0.001-0.005

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

For best results, de-air the material prior to casting, then pressurize to 60 psi until cured. However, if pressure cannot be used, this material has been designed for vacuum degas only. OC-5085 can be easily buffed when cured.

Agitate the hardener before use to ensure that the formula is homogeneous.

Packaging

OC-5085 Quart Kit	3.14 lbs.
OC-5085 1 Gal. Kit	12.56 lbs.
OC-5085 5 Gal. Kit	62.8 lbs.
OC-5085 Drum Kit	706.5 lbs.

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.

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.
