# RAKU<sup>®</sup> TOOL InnoClear<sup>™</sup> OC-5090



## 90A Water Clear

Water clear, semi-flexible polyurethane elastomer

© RAMPF Tooling Solutions GmbH & Co. KG	PC - RevStatus: 01- 2016/07/01	Page 1 of 2
Key Properties	Applications	
Excellent physical properties after RT cure	<ul> <li>For room temperature hand-batch, va assisted casting and meter mix disper methods</li> </ul>	
<ul> <li>Free of mercury, MOCA or TDI</li> </ul>		
• Excellent optical clarity as well as U.V. stability	,	

## Processing Properties

			Resin (Isocyanate)	Hardener (Polyol)
Mix ratio		pbw	50	100
		pbv	50	100
Density	ASTM D-792	g/cm <sup>3</sup>	ca. 1.07	ca. 1.07
Viscosity at 77°F (25°C)	ASTM D-2393	cP	ca. 200	ca. 1,000

			Mixture
Mix viscosity at 77°F (25°C)	ASTM D-2393	cP	ca. 750
Gel time at 77°F (25°C)		min	13-19
Demold time at 77°F (25°C)		h	2-4

### **Cured / Mechanical Properties (approximate values)**

Cure 1: 24 hours at 77°F + 16 hours a Cure 2: 7 days at 77°F	t 150°F		Cure 1	Cure 2
Aspect	visual		Clear	Clear
Density	ASTM D-792	g/cm <sup>3</sup>	1.07	1.07
Shore hardness A	ASTM D-2240		85-95	85-95
Tensile strength	ASTM D-638	psi	2,100	1,950
Elongation at Break	ASTM D-638	%	65	65
Tear strength	ASTM D-624	pli	225	250
Linear shrinkage	ASTM D-2566	in/in	0.001-0.005	0.001-0.005

#### RAKU<sup>®</sup> TOOL InnoClear<sup>™</sup> OC-5090

#### 90A Water Clear

Water clear, semi-flexible polyurethane elastomer



© RAMPF Tooling Solutions GmbH & Co. KG	PC - RevStatus: 01- 2016/07/01	Page 2 of 2
---	--------------------------------	-------------

#### Processing

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

Certain silicone rubbers, including platinum silicones, will inhibit the OC-5000 series. Tin based silicones will yield the most favorable results. It is recommended that a test plaque be cast on the outside of the silicone tool to test for compatibility. Contact your RAMPF Group Inc. representative for more information. For best results, de-air the material prior to casting, then pressurize to 60 psi until cured. If pigment has been added to the hardener component, it will separate during storage.

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

Packaging		
OC-5090 Quart Kit	3 lbs.	
OC-5090 1 Gal. Kit	12 lbs.	
OC-5090 5 Gal. Kit	60 lbs.	
OC-5090 Drum Kit	675 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.

RAMPF Group, Inc. 49037 Wixom Tech Drive Wixom, MI 48393 T +1 248. 295.0223 F +1 248. 295.0224 E info.us@rampf-group.com

www.rampf-group.com

Our recommendations on the use of the material are based on many years of experience and current scientific and practical knowledge. They are, however, provided without any obligation on our part and do not relieve the buyer of the need for suitability tests. They do not constitute a legal relationship, nor are any protected third party rights whatsoever affected thereby.