



DESCRIPTION	<p>HydroSpan 400 is a unique single component, Flexible, 100% solids (contains no V.O.C.), polyurethane elastomeric compound. HydroSpan 400, when fully cured provides for simple method for reducing three dimensionally molded parts. Reduction of parts is done by simply molding the part with HydroSpan 400 to form a rubber master. After curing 30 minutes at room temperature the molded HydroSpan 400 part is removed from the mold and allowed to shrink at room temperature. Reductions from 55 % to 86% the original part can be made depending on how much water is added in the initial curing process. Full reduction of parts can be achieved in 5 to 14 days depending on cross section thickness of the part. Thicker cross sections take longer while thinner cross sections require less time.</p>		
MIXING	<p>Mix HydroSpan 400 with COLD WATER (40°F-50°F) to extend working life. See Polymer/water mixing chart to determine the amount of water to use to achieve a specific reduction. Use a maximum batch size of no more than one gallon total mix of HydroSpan 400/Water.</p> <p>Pour both the water and HydroSpan 400 into a clean plastic container and quickly mix using a spatula for batch sizes of ½ gallon or less or less mix by hand with a flat spatula, for larger mixes use a jiffy mixer and electric drill. Take care to scrape bottom of the container to include all of the unmixed HydroSpan 400 polymer (do not use square or round rod as mixers). Mix for about 30 seconds and quickly pour into the prepared mold. After about 3 to 5 minutes HydroSpan 400 cures to a firm white gel.</p> <p>Mold preparation HydroSpan 400 can be molded in almost any kind of mold as long as it is fully prepared before filling with uncured polymer. Release agents used in the molding process inhibit the evaporation of water thus slow down the reduction process of the part. Depending on relative humidity and temperature, parts can be handled in 30 minutes.</p> <p>Reduced Parts Once the HydroSpan 400 parts have reduced to the desired size a final mold should be made as soon as possible. If molds are made from flexible RTV urethane or silicone rubber a light layer of Vaseline petroleum jelly should be applied to prevent any unwanted reaction of the absorbed water in the HydroSpan 400.</p> <p>Reduced HydroSpan 400 parts maintain their reduced size if stored in a dry environment.</p>		
PHYSICAL PROPERTIES	<p>Color</p> <p>Working Life @ 72°F</p> <p>Specific Gravity:</p> <p>Weight/Gallon</p>	<p>Cured:</p>	<p>White</p> <p>3-5 minutes</p> <p>1.07</p> <p>8.95 lbs.</p>
CLEAN UP	<p>Dispose of all empty HydroSpan 400 component containers in accordance with local, state and federal regulations. Empty component containers can be rendered non-hazardous by rinsing the containers with a small amount of mixed material and allowing the solvents to evaporate. The containers will then contain non-hazardous cured urethane.</p>		
STORAGE AND SHELF LIFE	<p>The containers should be stored in a cool dry area that is protected from direct sunlight and moisture. Storage temperatures should not exceed 80°F. The shelf life of factory sealed containers stored under these conditions is six months.</p>		
SHIPPING CLASS	<p>Class 55 Non-hazardous</p>		
WATER CURING SOLUTION BY WEIGHT	** LESS THAN 2 PARTS WATER IS NOT RECOMMENDED **		
	HydroSpan 400 resin/water solution	Gel Time	Size of finished part Compared to Master (100%)
	1 part / 2 Parts	1 min 10 sec	45%
	1 part / 3 Parts	1 min 15 sec	36%
	1 part / 4 Parts	1 min 15 sec	30%
	1 part / 5 Parts	1 min 15 sec	27%
	1 part / 6 Parts	1 min 20 sec	23%
	1 part / 7 Parts	1 min 19 sec	21%
	1 part / 8 Parts	1 min 30 sec	19%
	Greater than 8 parts water is not recommended.		