



<b>DESCRIPTION</b>	InstaGel 20 is a two-component urethane elastomer that is specifically formulated as a brush on molding compound. After mixing, InstaGel 20 thickens to creamy butterable gel that can easily be brushed on to vertical or overhead surfaces without sagging or running. In 24-hours InstaGel 20 cures to a tough rubber mold and is ready for use.																																																																												
<b>APPLICATION AND MIX RATIO</b>	InstaGel 20 is fully cured in 24 hours at 72°F. Colder curing temperatures will lengthen cure times. Warmer temperatures will greatly reduce working and cure times. For clean-up use methyl ethyl ketone (M.E.K.), acetone or mineral spirits. Component A and component B are supplied in 1 to 5 gallon containers. Component B should be thoroughly mixed before using. Component A does not need mixing. Carefully measure out equal portions of component A and component B by volume in separate containers. Mix small batches by hand with a spatula. Larger batches should be mixed using a "Jiffy mixer" and electric drill. While mixing material carefully scrape down sides and bottom of container. Mixture gradually thickens over 3 to 4 minute period to a creamy butterable consistency. InstaGel 20 can also be mixed by weight: 100 parts A to 96 parts B.																																																																												
<b>WORKING PROPERTIES</b>	<table border="0"> <tr> <td>Mix Ratio By weight</td> <td></td> <td>100 parts A/ 96 part B</td> </tr> <tr> <td>Mix Ratio By volume</td> <td></td> <td>100 parts A/ 100 parts B</td> </tr> <tr> <td>Viscosity @ 72°F (A Side)</td> <td></td> <td>2500 CPS</td> </tr> <tr> <td>Viscosity @ 72°F (B Side)</td> <td></td> <td>1100 CPS</td> </tr> <tr> <td>Viscosity @ 72°F (Mixed)</td> <td></td> <td>500,000 CPS</td> </tr> <tr> <td>Color</td> <td>Part A:</td> <td>Clear</td> </tr> <tr> <td>Color</td> <td>Part B:</td> <td>Purple</td> </tr> <tr> <td>Color</td> <td>Mixed:</td> <td>Purple</td> </tr> <tr> <td>Working Life @ 72°F</td> <td></td> <td>9-15 minutes</td> </tr> <tr> <td>Set Time* @ 72°F</td> <td></td> <td>24 hours</td> </tr> <tr> <td colspan="3">* Set time and Demold time depends on temperature and relative humidity.</td> </tr> <tr> <td>Specific Gravity: (Part A)</td> <td></td> <td>1.11</td> </tr> <tr> <td>Specific Gravity: (Part B)</td> <td></td> <td>1.07</td> </tr> <tr> <td>Specific Gravity: (Mixed)</td> <td></td> <td>1.09</td> </tr> <tr> <td>Weight/Gallon Part A</td> <td></td> <td>9.23 lbs.</td> </tr> <tr> <td>Weight/Gallon Part B</td> <td></td> <td>8.88 lbs.</td> </tr> <tr> <td>Weight/Gallon Mixed</td> <td></td> <td>9.06 lbs.</td> </tr> <tr> <td>Cubic inch per lb. of product</td> <td></td> <td>25.52</td> </tr> <tr> <td>Hardness @ 72° F</td> <td>ASTM 2240-85</td> <td>20-30 Shore A</td> </tr> <tr> <td>Tear Strength</td> <td>ASTM D-624</td> <td>94 lb./in.</td> </tr> <tr> <td>Tensile Strength</td> <td>ASTM D-412 die C</td> <td>428 psi</td> </tr> <tr> <td>Elongation</td> <td>ASTM D-412 die C</td> <td>538%</td> </tr> <tr> <td>Modulus (100%)</td> <td>ASTM D-412 die C</td> <td>136 psi</td> </tr> <tr> <td>Modulus (200%)</td> <td>ASTM D-412 die C</td> <td>209 psi</td> </tr> <tr> <td>Modulus (300%)</td> <td>ASTM D-412 die C</td> <td>267 psi</td> </tr> </table>		Mix Ratio By weight		100 parts A/ 96 part B	Mix Ratio By volume		100 parts A/ 100 parts B	Viscosity @ 72°F (A Side)		2500 CPS	Viscosity @ 72°F (B Side)		1100 CPS	Viscosity @ 72°F (Mixed)		500,000 CPS	Color	Part A:	Clear	Color	Part B:	Purple	Color	Mixed:	Purple	Working Life @ 72°F		9-15 minutes	Set Time* @ 72°F		24 hours	* Set time and Demold time depends on temperature and relative humidity.			Specific Gravity: (Part A)		1.11	Specific Gravity: (Part B)		1.07	Specific Gravity: (Mixed)		1.09	Weight/Gallon Part A		9.23 lbs.	Weight/Gallon Part B		8.88 lbs.	Weight/Gallon Mixed		9.06 lbs.	Cubic inch per lb. of product		25.52	Hardness @ 72° F	ASTM 2240-85	20-30 Shore A	Tear Strength	ASTM D-624	94 lb./in.	Tensile Strength	ASTM D-412 die C	428 psi	Elongation	ASTM D-412 die C	538%	Modulus (100%)	ASTM D-412 die C	136 psi	Modulus (200%)	ASTM D-412 die C	209 psi	Modulus (300%)	ASTM D-412 die C	267 psi
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<b>CLEAN UP</b>	Dispose of all empty InstaGel 20 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 material to cure for 24 hours. The containers will then contain non-hazardous cured urethane.																																																																												
<b>STORAGE AND SHELF LIFE</b>	InstaGel 20 is shipped from the factory in sealed containers. 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 the factory sealed containers stored under these conditions is six months. Containers that have been opened should be resealed immediately after material has been removed in order to prevent solvent evaporation.																																																																												
<b>SHIPPING CLASS</b>	Class 55 Non-hazardous																																																																												