



<b>DESCRIPTION</b>	InstaGel 50 is a two-component urethane elastomer that is specifically formulated as brush on molding compound. After mixing, InstaGel 50 thickens to a creamy butterable gel that can easily be brushed on to vertical or overhead surfaces without sagging or running. In 24-hours InstaGel 50 cures to a tough rubber mold and is ready for use. Some features of InstaGel 50 include good grease and oil resistance, easy 1 to 1 mix by volume, good adhesion between coats and it is insensitive to inhibition. It is also tough, with high tear resistance, is color coded for mix indication and has long mold storage life.																																																																											
<b>APPLICATION AND MIX RATIO</b>	Component A and component B are supplied in 1 and 5 gallon plastic 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. While mixing material carefully scrape down sides and bottom of container. Mixture gradually thickens over a 1 to 2 minute period to a creamy butterable consistency. Large batches should be avoided to insure even mixing. The ideal batch size is ½ gallon or less of total mix. It is important to mix correctly the exact amount of Part A to Part B to obtain maximum properties. Warmer temperature will decrease working life and cure time, whereas colder temperatures will increase the working life and cure time. InstaGel 50 can also be mix by weight: 100 parts of component A to 94 parts of component B by weight.																																																																											
<b>WORKING PROPERTIES</b>	<table border="0"> <tr> <td>Mix Ratio By weight</td> <td></td> <td>100 parts A/ 94 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>500000 CPS</td> </tr> <tr> <td>Color</td> <td>Part A:</td> <td>Clear</td> </tr> <tr> <td>Color</td> <td>Part B:</td> <td>Light Blue</td> </tr> <tr> <td>Color</td> <td>Mixed:</td> <td>Light Blue</td> </tr> <tr> <td>Working Life @ 72°F</td> <td></td> <td>10-15 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>1.10</td> </tr> <tr> <td>Specific Gravity: (Part B)</td> <td></td> <td>1.03</td> </tr> <tr> <td>Specific Gravity: (Mixed)</td> <td></td> <td>1.06</td> </tr> <tr> <td>Weight/Gallon Part A</td> <td></td> <td>9.15 lbs.</td> </tr> <tr> <td>Weight/Gallon Part B</td> <td></td> <td>8.57 lbs.</td> </tr> <tr> <td>Weight/Gallon Mixed</td> <td></td> <td>8.86 lbs.</td> </tr> <tr> <td>Cubic inch per lb. of product</td> <td></td> <td>25.70</td> </tr> <tr> <td>Hardness @ 72° F</td> <td>ASTM 2240-85</td> <td>45-55 Shore A</td> </tr> <tr> <td>Tear Strength</td> <td>ASTM D-624</td> <td>300 lb./in.</td> </tr> <tr> <td>Tensile Strength</td> <td>ASTM D-412 die C</td> <td>1500 psi</td> </tr> <tr> <td>Elongation</td> <td>ASTM D-412 die C</td> <td>375%</td> </tr> <tr> <td>Modulus (100%)</td> <td>ASTM D-412 die C</td> <td>385 psi</td> </tr> <tr> <td>Modulus (200%)</td> <td>ASTM D-412 die C</td> <td>576 psi</td> </tr> <tr> <td>Modulus (300%)</td> <td>ASTM D-412 die C</td> <td>822 psi</td> </tr> </table>	Mix Ratio By weight		100 parts A/ 94 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)		500000 CPS	Color	Part A:	Clear	Color	Part B:	Light Blue	Color	Mixed:	Light Blue	Working Life @ 72°F		10-15 minutes	Set Time* @ 72°F		24 hours	* Set time and Demold time depends on temperature and relative humidity.			Specific Gravity: (Part A)		1.10	Specific Gravity: (Part B)		1.03	Specific Gravity: (Mixed)		1.06	Weight/Gallon Part A		9.15 lbs.	Weight/Gallon Part B		8.57 lbs.	Weight/Gallon Mixed		8.86 lbs.	Cubic inch per lb. of product		25.70	Hardness @ 72° F	ASTM 2240-85	45-55 Shore A	Tear Strength	ASTM D-624	300 lb./in.	Tensile Strength	ASTM D-412 die C	1500 psi	Elongation	ASTM D-412 die C	375%	Modulus (100%)	ASTM D-412 die C	385 psi	Modulus (200%)	ASTM D-412 die C	576 psi	Modulus (300%)	ASTM D-412 die C	822 psi
Mix Ratio By weight		100 parts A/ 94 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)		500000 CPS																																																																										
Color	Part A:	Clear																																																																										
Color	Part B:	Light Blue																																																																										
Color	Mixed:	Light Blue																																																																										
Working Life @ 72°F		10-15 minutes																																																																										
Set Time* @ 72°F		24 hours																																																																										
* Set time and Demold time depends on temperature and relative humidity.																																																																												
Specific Gravity: (Part A)		1.10																																																																										
Specific Gravity: (Part B)		1.03																																																																										
Specific Gravity: (Mixed)		1.06																																																																										
Weight/Gallon Part A		9.15 lbs.																																																																										
Weight/Gallon Part B		8.57 lbs.																																																																										
Weight/Gallon Mixed		8.86 lbs.																																																																										
Cubic inch per lb. of product		25.70																																																																										
Hardness @ 72° F	ASTM 2240-85	45-55 Shore A																																																																										
Tear Strength	ASTM D-624	300 lb./in.																																																																										
Tensile Strength	ASTM D-412 die C	1500 psi																																																																										
Elongation	ASTM D-412 die C	375%																																																																										
Modulus (100%)	ASTM D-412 die C	385 psi																																																																										
Modulus (200%)	ASTM D-412 die C	576 psi																																																																										
Modulus (300%)	ASTM D-412 die C	822 psi																																																																										
<b>PHYSICAL PROPERTIES</b>																																																																												
<b>CLEAN UP</b>	Dispose of all empty InstaGel 50 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 50 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																																																																											