



<b>DESCRIPTION</b>	InstaGel Spray 65 is a unique two component, flexible, 100% solids polyurethane elastomeric compound. InstaGel Spray 65, when fully cured, provides for a tough, flexible stand-alone mold that does not require containment boxes. InstaGel Spray 65 is applied using a simple, inexpensive hand held Hopper gun, replacing the need for expensive high pressure application equipment. InstaGel Spray 65 is recommended for architectural, fine art or natural texture reproduction.																																																																				
<b>WORKING PROPERTIES</b>	<table border="0"> <tr> <td>Mix Ratio By weight</td> <td></td> <td>100 parts A/ 98.17 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>2700 CPS</td> </tr> <tr> <td>Viscosity @ 72°F (B Side)</td> <td></td> <td>2000 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 Beige</td> </tr> <tr> <td>Color</td> <td>Mixed:</td> <td>Light Beige</td> </tr> <tr> <td>Working Life @ 72°F</td> <td></td> <td>12 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>1.05</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>1.04</td> </tr> <tr> <td>Weight/Gallon Part A</td> <td></td> <td>8.73 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>8.65 lbs.</td> </tr> <tr> <td>Cubic inch per lb. of product</td> <td></td> <td>26.19 in<sup>3</sup>/lb.</td> </tr> <tr> <td>Hardness @ 72° F</td> <td>ASTM 2240-85</td> <td>55-65 Shore A</td> </tr> <tr> <td>Tear Strength</td> <td>ASTM D-624</td> <td>375 lb./in.</td> </tr> <tr> <td>Tensile Strength</td> <td>ASTM D-412 die C</td> <td>1700 psi</td> </tr> <tr> <td>Elongation</td> <td>ASTM D-412 die C</td> <td>480%</td> </tr> </table>			Mix Ratio By weight		100 parts A/ 98.17 part B	Mix Ratio By volume		100 parts A/ 100 parts B	Viscosity @ 72°F (A Side)		2700 CPS	Viscosity @ 72°F (B Side)		2000 CPS	Viscosity @ 72°F (Mixed)		500000 CPS	Color	Part A:	Clear	Color	Part B:	Light Beige	Color	Mixed:	Light Beige	Working Life @ 72°F		12 minutes	Set Time* @ 72°F		24 hours	* Set time and Demold time depends on temperature and relative humidity.			Specific Gravity: (Part A)		1.05	Specific Gravity: (Part B)		1.03	Specific Gravity: (Mixed)		1.04	Weight/Gallon Part A		8.73 lbs.	Weight/Gallon Part B		8.57 lbs.	Weight/Gallon Mixed		8.65 lbs.	Cubic inch per lb. of product		26.19 in <sup>3</sup> /lb.	Hardness @ 72° F	ASTM 2240-85	55-65 Shore A	Tear Strength	ASTM D-624	375 lb./in.	Tensile Strength	ASTM D-412 die C	1700 psi	Elongation	ASTM D-412 die C	480%
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<b>PHYSICAL PROPERTIES</b>																																																																					
<b>CLEAN UP</b>	Dispose of all empty InstaGel 65 Spray 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 Spray 65 liquids should be stored in the original, unopened containers in temperatures between 75°F and 85°F (24°C - 29°C). Shelf life of materials, when kept in unopened sealed containers, at the recommended storage temperature is six (6) months. Containers should not be opened until ready for immediate use. When resealing opened containers, purge with dry gas, Poly-Dry (available from Industrial Polymers). To avoid air entrapment, undue agitation of containers should be avoided.																																																																				
<b>SHIPPING CLASS</b>	Class 55 Non-hazardous																																																																				



**APPLICATION  
AND  
MIX RATIO**

Liquids should be maintained at 72°F for best results. Warmer temperatures will decrease working life, cooler temperatures will increase application time.

**Mold surface preparation:**

All surfaces should be dry and free of visible dirt and debris.

Clay Surfaces: Non-drying oil based clay masters should be coated with a liberal application of urethane mold release (available from Industrial Polymers) and allow to dry for 15 to 20 minutes before applying InstaGel Spray 65.

Wood Surfaces: Wood possess a special problem due to surface porosity and moisture content. Sealing surfaces with several coats of shellac or wax will prevent any unwanted adhesion. After sealing, apply a liberal coat of Urethane mold release agent to sealed surfaces and allow to dry 45 minutes to 1 hour before applying InstaGel Spray 65.

Concrete or Stone Surfaces: Surfaces should be clean and dry. Seal surfaces with petroleum jelly or wax. If the Stone surface is smooth enough, a liberal coat of Urethane mold release alone will be sufficient for release. Allow the Urethane mold release to completely dry (1 hour) before applying InstaGel Spray 65.

Metal: Surfaces should be clean and dry. A liberal coat of Urethane mold release on smooth molding surfaces and/or with wax on rough surfaces will easily release.

Choose a work area that is free from visible moisture and capable of maintaining a temperature range of 70°F to 90°F. Gloves, eye protection and respirators must be worn during spray application (see Industrial Polymers Safety Data Sheet for more details).

All surfaces should be clean, free of dirt and visible moisture before and during application. After temperature stabilizing the liquid of Component A (blue) and Component B (red) to 70°F to 80°F, remove the lids of each container and stir Component B thoroughly using a "jiffy" mixer and electric drill, take care not to whip air into the mixture. Component A does not require pre-mixing.

**Mix ratio is 1 part of Component A to 1 part of Component B by volume**

Once started, continue the application until complete. When finished clean the equipment with M.E.K. (methyl ethyl ketone) or mineral spirits and apply a light coat of petroleum jelly to gun parts. Do not allow InstaGel Spray 65 to cure in the spray gun or reservoirs.

Apply 3/8" to 1/2" thickness for best results. InstaGel Spray 65 can be applied as thick as desired with no curing problems. Depending on relative humidity and temperature, parts can be handled in twelve (12) to sixteen (16) hours. Full cure is attained in 24 hours at 72°F. Cheese cloth or open weave fiberglass cloth can be used in between sprayed on layer of the InstaGel Spray 65 to increase tear resistance of the cured rubber.

**Recoating:**

If within six (6) to eight (8) hours from the initial application, InstaGel Spray 65 can be applied with no special surface preparation, although surfaces should be clean and dry. After this period, Primer 450 adhesion promoter should be used before recoating (available from Industrial Polymers).