Industrial Polymers Corporation

TrueCast 30

Technical Data

Revision date: 11/14

DESCRIPTION	TrueCast 30 is a versatile, two component, low viscosity liquid castable polyurethane elastomer. TrueCast 30 combines high strength, low durometer and elongation with excellent chemical resistance to create durable flexible molds or parts.
FEATURES	Insensitive to typical environmental moisture Low residual surface tack Tough, with high tear strength Good grease and oil resistance Good flow into fine detail Good dimensional stability Good adhesion between pours
APPLICATION AND MIX RATIO	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 weigh out equal portions of component A and component B. Mix together for 1 to 2 minutes by hand using a spatula for small batches (1/2 gallon or less), or electric drill and jiffy mixer for larger batches. Use silicone mold release, even when using a silicone mold to avoid residual tack. Molds may be dusted with talc powder before pouring in liquid to produce a tack free permanent surface on cured parts. TrueCast 30 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. Curing can be heat accelerated (150°F/ 8 hours) to speed up processing. Use methyl ethyl ketone (MEK), acetone or mineral spirits for clean-up.
WORKING PROPERTIES	Mix Ratio By weight — 100 parts A/ 100 part B Mix Ratio By volume — 96 parts A/ 100 parts B Viscosity @ 72°F (Mixed) — 1100 CPS Color — Part A: — Clear Color — Part B: — Light Green Color — Mixed: — Light Green Working Life @ 72°F — 30-45 minutes Full Cure Time* @ 72°F — 24 hours * Set time and Demold time depends on temperature and relative humidity.
PHYSICAL PROPERTIES	Specific Gravity: (Part A) — 1.09 Specific Gravity: (Part B) — 1.05 Specific Gravity: (Mixed) — 1.07 Weight/Gallon Part A — 9.13 lbs. Weight/Gallon Part B — 8.76 lbs. Weight/Gallon Mixed — 8.94 lbs. Cubic inch per lb. of product — 25.84 in^3/lb. Hardness @ 72° F — ASTM 2240-85 — 25-35 Shore A Tear Strength — ASTM D-624 — 144 lb./in. Tensile Strength — ASTM D-412 die C — 621 psi Elongation — ASTM D-412 die C — 786%
CLEAN UP	Dispose of all empty TrueCast 30 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.
STORAGE AND SHELF LIFE	TrueCast 30 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.
SHIPPING CLASS	Class 55 Non-hazardous