



<b>DESCRIPTION</b>	TrueCast 20 is a versatile, two component, low viscosity liquid castable polyurethane elastomer. TrueCast 20 combines high strength and elongation with excellent chemical resistance to create durable flexible molds or parts.	
<b>FEATURES</b>	<p>Tough, with high tear strength</p> <p>Good grease and oil resistance</p> <p>Good flow into fine detail</p> <p>Good dimensional stability</p> <p>Good adhesion between pours</p> <p>Insensitive to typical environmental moisture</p>	
<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 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 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. 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.	
<b>WORKING PROPERTIES</b>	Mix Ratio By weight	100 parts A/ 100 part B
	Mix Ratio By volume	96 parts A/ 100 parts B
<b>PHYSICAL PROPERTIES</b>	Viscosity @ 72°F (A Side)	2100 CPS
	Viscosity @ 72°F (B Side)	1150 CPS
<b>WORKING PROPERTIES</b>	Viscosity @ 72°F (Mixed)	1550 CPS
	Color	Part A: Clear
<b>PHYSICAL PROPERTIES</b>	Color	Part B: Light Pink
	Color	Mixed: Light Pink
<b>WORKING PROPERTIES</b>	Working Life @ 72°F	45-55 minutes
	Full Cure Time* @ 72°F	24 hours
<b>PHYSICAL PROPERTIES</b>	* Set time and Demold time depends on temperature and relative humidity.	
	Specific Gravity: (Part A)	1.10
<b>PHYSICAL PROPERTIES</b>	Specific Gravity: (Part B)	1.05
	Specific Gravity: (Mixed)	1.07
<b>PHYSICAL PROPERTIES</b>	Weight/Gallon Part A	9.15 lbs.
	Weight/Gallon Part B	8.78 lbs.
<b>PHYSICAL PROPERTIES</b>	Weight/Gallon Mixed	8.96 lbs.
	Cubic inch per lb. of product	25.78 in <sup>3</sup> /lb.
<b>PHYSICAL PROPERTIES</b>	Hardness @ 72° F	ASTM 2240-85 15-25 Shore A
	Tear Strength	ASTM D-624 125 lb./in.
<b>PHYSICAL PROPERTIES</b>	Tensile Strength	ASTM D-412 die C 549 psi
	Elongation	ASTM D-412 die C 470%
<b>CLEAN UP</b>	Dispose of all empty TrueCast 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>	TrueCast 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	