



DESCRIPTION	TrueCast 85F-Slow is a versatile, two component liquid castable polyurethane elastomer. TrueCast 85F-Slow combines high strength and durability with easy processing at room temperature. TrueCast 85F-Slow can be used for casting urethane parts or flexible molds. Some features of TrueCast 85F-Slow include good grease and oil resistance, good flow into fine detail and good dimensional stability. It is tough, with high tear strength and elongation. It has rapid room temperature cure, set and demold and is insensitive to inhibition and typical environmental moisture.																																																																		
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 One-Hundred (100) parts of Component A to Fifty (50) parts 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 85F-Slow 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	<table border="0"> <tr> <td>Mix Ratio By weight</td> <td></td> <td>100 parts A/ 50 part B</td> </tr> <tr> <td>Mix Ratio By volume</td> <td></td> <td>100 parts A/ 52 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>2500 CPS</td> </tr> <tr> <td>Viscosity @ 72°F (Mixed)</td> <td></td> <td>2600 CPS</td> </tr> <tr> <td>Color</td> <td>Part A:</td> <td>Clear</td> </tr> <tr> <td>Color</td> <td>Part B:</td> <td>Milky White</td> </tr> <tr> <td>Color</td> <td>Mixed:</td> <td>Milky White</td> </tr> <tr> <td>Working Life @ 72°F</td> <td></td> <td>8-14 minutes</td> </tr> <tr> <td>Full Cure Time* @ 72°F</td> <td></td> <td>72 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>1.07</td> </tr> <tr> <td>Specific Gravity: (Part B)</td> <td></td> <td>1.04</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>8.94 lbs.</td> </tr> <tr> <td>Weight/Gallon Part B</td> <td></td> <td>8.66 lbs.</td> </tr> <tr> <td>Weight/Gallon Mixed</td> <td></td> <td>8.85 lbs.</td> </tr> <tr> <td>Hardness @ 72° F</td> <td>ASTM 2240-85</td> <td>78-85 Shore A</td> </tr> <tr> <td>Tear Strength</td> <td>ASTM D-624</td> <td>250 lb./in.</td> </tr> <tr> <td>Tensile Strength</td> <td>ASTM D-412 die C</td> <td>870 psi</td> </tr> <tr> <td>Elongation</td> <td>ASTM D-412 die C</td> <td>350 %</td> </tr> <tr> <td>Shrinkage, inches</td> <td>ASTM D-2566</td> <td>0.015</td> </tr> </table>	Mix Ratio By weight		100 parts A/ 50 part B	Mix Ratio By volume		100 parts A/ 52 parts B	Viscosity @ 72°F (A Side)		2700 CPS	Viscosity @ 72°F (B Side)		2500 CPS	Viscosity @ 72°F (Mixed)		2600 CPS	Color	Part A:	Clear	Color	Part B:	Milky White	Color	Mixed:	Milky White	Working Life @ 72°F		8-14 minutes	Full Cure Time* @ 72°F		72 hours	* Set time and Demold time depends on temperature and relative humidity.			Specific Gravity: (Part A)		1.07	Specific Gravity: (Part B)		1.04	Specific Gravity: (Mixed)		1.06	Weight/Gallon Part A		8.94 lbs.	Weight/Gallon Part B		8.66 lbs.	Weight/Gallon Mixed		8.85 lbs.	Hardness @ 72° F	ASTM 2240-85	78-85 Shore A	Tear Strength	ASTM D-624	250 lb./in.	Tensile Strength	ASTM D-412 die C	870 psi	Elongation	ASTM D-412 die C	350 %	Shrinkage, inches	ASTM D-2566	0.015
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CLEAN UP	Dispose of all empty TrueCast 85F-Slow 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 85F-Slow 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.																																																																		
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