Industrial Polymers Corporation

TrueCast 70

Technical Data

Revision date: 11/14

DESCRIPTION	TrueCast 70 is a versatile, two component liquid castable polyurethane elastomer. TrueCast 70 combines high strength and durability with easy processing at room temperature. TrueCast 70 can be used for casting urethane parts or flexible molds. Some features for TrueCast 70 include good grease and oil resistance, good dimensional stability, rapid room temperature cure as well as rapid set and demold. It is tough, with high tear strength and elongation, is insensitive to inhibition and insensitive to 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. TrueCast 70 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/ 50 part B
	Mix Ratio By volume		100 parts A/ 53 parts B
	Viscosity @ 72°F (A Side)		2700 CPS
	Viscosity @ 72°F (B Side)		2200 CPS
	Viscosity @ 72°F (Mixed)		2400 CPS
	Color	Part A:	Clear
	Color	Part B:	Medium Blue
	Color	Mixed:	Medium Blue
	Working Life @ 72°F		4-5 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)		1.08
	Specific Gravity: (Part B)		1.04
	Specific Gravity: (Mixed)		1.07
	Weight/Gallon Part A		9.05 lbs.
	Weight/Gallon Part B		8.64 lbs.
	Weight/Gallon Mixed		8.91 lbs.
	Cubic inch per lb. of product		
	Hardness @ 72° F	ASTM 2240-85	65-75 Shore A
	Tear Strength	ASTM D-624	175 lb./in.
	Tensile Strength	ASTM D-412 die C	2300 psi
	Elongation	ASTM D-412 die C	450%
	Shrinkage, inches	ASTM D-2566	0.015
CLEAN UP	Dispose of all empty TrueCast 70 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 70 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		