



<b>DESCRIPTION</b>	TrueCast 90 is a versatile, two component liquid castable polyurethane elastomer. TrueCast 90 combines high strength and elongation with excellent chemical resistance to create durable flexible molds or parts. TrueCast 90 is insensitive to typical environmental moisture and sets rapidly. Some features of TrueCast 90 include good grease and oil resistance, good flow into fine detail, good dimensional stability and good adhesion between pours. It is tough, with high tear strength and is insensitive to inhibition																																																																		
<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 Four (4) part of Component A to One (1) part 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 90 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>	<table border="0"> <tr> <td>Mix Ratio By weight</td> <td></td> <td>4 parts A/ 1 part B</td> </tr> <tr> <td>Mix Ratio By volume</td> <td></td> <td>100 parts A/ 24.51 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>2300 CPS</td> </tr> <tr> <td>Color</td> <td>Part A:</td> <td>Clear</td> </tr> <tr> <td>Color</td> <td>Part B:</td> <td>Black</td> </tr> <tr> <td>Color</td> <td>Mixed:</td> <td>Black</td> </tr> <tr> <td>Working Life @ 72°F</td> <td></td> <td>10-17 minutes</td> </tr> <tr> <td>Full Cure 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>1.03</td> </tr> <tr> <td>Specific Gravity: (Part B)</td> <td></td> <td>1.10</td> </tr> <tr> <td>Specific Gravity: (Mixed)</td> <td></td> <td>1.05</td> </tr> <tr> <td>Weight/Gallon Part A</td> <td></td> <td>8.62 lbs.</td> </tr> <tr> <td>Weight/Gallon Part B</td> <td></td> <td>9.22 lbs.</td> </tr> <tr> <td>Weight/Gallon Mixed</td> <td></td> <td>8.74 lbs.</td> </tr> <tr> <td>Cubic inch per lb. of product</td> <td></td> <td>25.44 in<sup>3</sup>/lb.</td> </tr> <tr> <td>Hardness @ 72° F</td> <td>ASTM 2240-85</td> <td>80-85 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>2500 psi</td> </tr> <tr> <td>Elongation</td> <td>ASTM D-412 die C</td> <td>350%</td> </tr> </table>	Mix Ratio By weight		4 parts A/ 1 part B	Mix Ratio By volume		100 parts A/ 24.51 parts B	Viscosity @ 72°F (A Side)		2700 CPS	Viscosity @ 72°F (B Side)		2000 CPS	Viscosity @ 72°F (Mixed)		2300 CPS	Color	Part A:	Clear	Color	Part B:	Black	Color	Mixed:	Black	Working Life @ 72°F		10-17 minutes	Full Cure Time* @ 72°F		24 hours	* Set time and Demold time depends on temperature and relative humidity.			Specific Gravity: (Part A)		1.03	Specific Gravity: (Part B)		1.10	Specific Gravity: (Mixed)		1.05	Weight/Gallon Part A		8.62 lbs.	Weight/Gallon Part B		9.22 lbs.	Weight/Gallon Mixed		8.74 lbs.	Cubic inch per lb. of product		25.44 in <sup>3</sup> /lb.	Hardness @ 72° F	ASTM 2240-85	80-85 Shore A	Tear Strength	ASTM D-624	375 lb./in.	Tensile Strength	ASTM D-412 die C	2500 psi	Elongation	ASTM D-412 die C	350%
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<b>CLEAN UP</b>	Dispose of all empty TrueCast 90 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 90 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																																																																		