# TrueCast XL 8500

Preliminary Technical Data

Revision date: 04/17

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| **DESCRIPTION** | TrueCast XL 8500 is a low viscosity rapid setting urethane compound polymer with high strength and durometer. The rapid cure properties of TrueCast XL 8500 allows rapid demold. Low viscosity and 1:1 by volume ratio makes for easy hand mixing and application. TrueCast XL 8500 will fully cure at room temperature (72° F) does not require heating for processing or post curing. | | |
| **PHYSICAL PROPERTIES** | Mix Ratio By weight | | 100 parts A/ 92.76 part B |
| | Mix Ratio By volume | | 100 parts A/ 100 parts B |
| | Viscosity @ 72°F (A Side) | | 4,500-5,000 CPS |
| | Viscosity @ 72°F (B Side) | | 750-850 CPS |
| | Viscosity @ 72°F (Mixed) | | 1,900-2,100 CPS |
| | Color | Part A: | Clear Amber |
| | Color | Part B: | Black ( special colors on request) |
| | Color | Mixed: | Black |
| | Working Life @ 72°F | | 4 - 4 1/2 minutes |
| | Demold Time* @ 72°F | | 20-30 minutes |
| | Complete Cure @ 72°F | | 24 hours |
| | * Set time and Demold time depends on temperature and relative humidity. | | |
| **WORKING PROPERTIES** | Specific Gravity: (Part A) | | 1.10 |
| | Specific Gravity: (Part B) | | 1.02 |
| | Specific Gravity: (Mixed) | | 1.06 |
| | Weight/Gallon Part A | | 9.17 lbs. |
| | Weight/Gallon Part B | | 8.51 lbs. |
| | Weight/Gallon Mixed | | 8.84 lbs. |
| | Cubic inch per lb. of product | | 26.13 $in^3$/lb. |
| | Hardness @ 72° F | ASTM 2240-85 | 75-85 Shore A |
| | Tensile Strength | ASTM D-412 die C | 4,500-5,000 psi |
| | Tear Strength | ASTM D-624 | 700-757 (lb./in.) |
| | Linear Shrinkage | *ASTM-D 2566 modified | 0.23% |
| | *Actual shrinkage is dependent on mass of polymer used. | | |
| | Elongation | ASTM D-412 die C | 450-500% |
| **CLEAN UP** | Dispose of all empty TrueCast XL 8500 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 the solvents to evaporate. The containers will then contain non-hazardous cured urethane. | | |
| **STORAGE AND SHELF LIFE** | Ideal Storage Temperatures 70°F-90°F<br>Temperatures above 120°F for longer than 24 hour are not recommended and could reduce the performance of the cured polymer.<br>Avoid temperatures of 40°F for component A and below and 60°F below for component B for longer than 72 hrs. may cause crystallization and will cause a reduction of physical properties of the cured polymer.<br>Check for visible crystals before using. If crystallization occurs, allow the storage container to warm to room temperature (72°F) over a 24 hour period and stir before combing with Component B.<br>If crystals are persistent, heating the material to 120°F overnight and stirring is recommended.<br>Long term storage below 50°F may permanently damage the material.<br>Always combine Component A & B at temperature between 72°F and 90°F for best processing | | |
| **SHIPPING CLASS** | Class 55 Non-hazardous | | |