



<b>DESCRIPTION</b>	TrueCast XL 9500 is a low viscosity rapid setting urethane compound polymer with high strength and durometer. The rapid cure properties of TrueCast XL 9500 allows rapid demold. Low viscosity and 1:1 by volume ratio makes for easy hand mixing and application. TrueCast XL 9500 will fully cure at room temperature (72° F) does not require heating for processing or post curing.																																																																												
<b>PHYSICAL PROPERTIES</b>	<table border="0"> <tr> <td>Mix Ratio By weight</td> <td></td> <td>100 parts A/ 93.02 part B</td> </tr> <tr> <td>Mix Ratio By volume</td> <td></td> <td>100 parts A/ 100 parts B</td> </tr> <tr> <td>Viscosity @ 72°F (A Side)</td> <td></td> <td>2,300-2,600 CPS</td> </tr> <tr> <td>Viscosity @ 72°F (B Side)</td> <td></td> <td>750-850 CPS</td> </tr> <tr> <td>Viscosity @ 72°F (Mixed)</td> <td></td> <td>950-1,100 CPS</td> </tr> <tr> <td>Color</td> <td>Part A:</td> <td>Clear Amber</td> </tr> <tr> <td>Color</td> <td>Part B:</td> <td>Black ( special colors on request)</td> </tr> <tr> <td>Color</td> <td>Mixed:</td> <td>Black</td> </tr> <tr> <td>Working Life @ 72°F</td> <td></td> <td>2 - 2 1/2 minutes</td> </tr> <tr> <td>Demold Time* @ 72°F</td> <td></td> <td>20-30 minutes</td> </tr> <tr> <td>Complete Cure @ 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>1.12</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>1.08</td> </tr> <tr> <td>Weight/Gallon Part A</td> <td></td> <td>9.34 lbs.</td> </tr> <tr> <td>Weight/Gallon Part B</td> <td></td> <td>8.69 lbs.</td> </tr> <tr> <td>Weight/Gallon Mixed</td> <td></td> <td>9.02 lbs.</td> </tr> <tr> <td>Cubic inch per lb. of product</td> <td></td> <td>25.64 in<sup>3</sup>/lb.</td> </tr> <tr> <td>Hardness @ 72° F</td> <td>ASTM 2240-85</td> <td>85-95 Shore A</td> </tr> <tr> <td>Tensile Strength</td> <td>ASTM D-412 die C</td> <td>5,500-6,300 psi</td> </tr> <tr> <td>Tear Strength</td> <td>ASTM D-624</td> <td>1,249 (lb./in.)</td> </tr> <tr> <td>Linear Shrinkage</td> <td>*ASTM-D 2566 modified</td> <td>0.72%</td> </tr> <tr> <td colspan="3">*Actual shrinkage is dependent on mass of polymer used.</td> </tr> <tr> <td>Elongation</td> <td>ASTM D-412 die C</td> <td>432 %</td> </tr> </table>		Mix Ratio By weight		100 parts A/ 93.02 part B	Mix Ratio By volume		100 parts A/ 100 parts B	Viscosity @ 72°F (A Side)		2,300-2,600 CPS	Viscosity @ 72°F (B Side)		750-850 CPS	Viscosity @ 72°F (Mixed)		950-1,100 CPS	Color	Part A:	Clear Amber	Color	Part B:	Black ( special colors on request)	Color	Mixed:	Black	Working Life @ 72°F		2 - 2 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.			Specific Gravity: (Part A)		1.12	Specific Gravity: (Part B)		1.04	Specific Gravity: (Mixed)		1.08	Weight/Gallon Part A		9.34 lbs.	Weight/Gallon Part B		8.69 lbs.	Weight/Gallon Mixed		9.02 lbs.	Cubic inch per lb. of product		25.64 in <sup>3</sup> /lb.	Hardness @ 72° F	ASTM 2240-85	85-95 Shore A	Tensile Strength	ASTM D-412 die C	5,500-6,300 psi	Tear Strength	ASTM D-624	1,249 (lb./in.)	Linear Shrinkage	*ASTM-D 2566 modified	0.72%	*Actual shrinkage is dependent on mass of polymer used.			Elongation	ASTM D-412 die C	432 %
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<b>CLEAN UP</b>	Dispose of all empty TrueCast XL 9500 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.																																																																												
<b>STORAGE AND SHELF LIFE</b>	<p>Ideal Storage Temperatures 70°F-90°F</p> <p>Temperatures above 120°F for longer than 24 hour are not recommended and could reduce the performance of the cured polymer.</p> <p>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.</p> <p>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 combining with Component B.</p> <p>If crystals are persistent, heating the material to 120°F overnight and stirring is recommended.</p> <p>Long term storage below 50°F may permanently damage the material.</p> <p>Always combine Component A &amp; B at temperature between 72°F and 90°F for best processing</p>																																																																												
<b>SHIPPING CLASS</b>	Class 55 Non-hazardous																																																																												