



<b>DESCRIPTION</b>	TrueCast 85F is a versatile, two component liquid castable polyurethane elastomer. TrueCast 85F combines high strength and durability with easy processing at room temperature. TrueCast 85F can be used for casting urethane parts or flexible molds. Some features of TrueCast 85F 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.		
<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 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 85F 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>	Mix Ratio By weight Mix Ratio By volume Viscosity @ 72°F (A Side) Viscosity @ 72°F (B Side) Viscosity @ 72°F (Mixed) Color Color Color Working Life @ 72°F Full Cure Time* @ 72°F * Set time and Demold time depends on temperature and relative humidity.	100 parts A/ 50 part B 100 parts A/ 52 parts B 2700 CPS 2200 CPS 2300 CPS Part A: Part B: Mixed: 5-8 minutes 24 hours	Clear Milky White Milky White
<b>PHYSICAL PROPERTIES</b>	Specific Gravity: (Part A) Specific Gravity: (Part B) Specific Gravity: (Mixed) Weight/Gallon Part A Weight/Gallon Part B Weight/Gallon Mixed Cubic inch per lb. of product Hardness @ 72° F Tear Strength Tensile Strength Elongation Shrinkage, inches	1.08 1.04 1.07 9.05 lbs. 8.66 lbs. 8.92 lbs. ASTM 2240-85 ASTM D-624 ASTM D-412 die C ASTM D-412 die C ASTM D-2566	78-85 Shore A 175 lb./in. 870 psi 450% 0.015
<b>CLEAN UP</b>	Dispose of all empty TrueCast 85F 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 85F 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		