

Rapid Cast / Rigid / Black

Tough, impact resistant elastomer

Key Properties

- Excellent physical properties after RT cure
- Free of mercury, MOCA or TDI

Applications

- Formulated for room temperature meter-mix dispensing systems and short mold cycle times

Processing Properties

			Resin (Isocyanate)	Hardener (Polyol)
Mix ratio		pbw	100	84
		pbv	100	100
Density	ASTM D-792	g/cm ³	ca. 1.26	ca. 1.05
Viscosity at 77°F (25°C)	ASTM D-2393	cP	ca. 150	ca. 1,700

			Mixture
Mix viscosity at 77°F (25°C)	ASTM D-2393	cP	NA
Gel time at 77°F (25°C)		sec	50-70
Demold time at 77°F (25°C)		min	20-30

Cured / Mechanical Properties (approximate values)

			Cure 1	Cure 2
Cure 1: 24 hours at 77°F				
Cure 2: 7 days at 77°F				
Aspect	visual		Black	Black
Density	ASTM D-792	g/cm ³	1.05	1.05
Shore hardness D	ASTM D-2240		70-80	75-85
Deflection temperature, HDT (66psi)	ASTM D-648	°F (°C)	184 (84)	194 (90)
Tensile strength	ASTM D-638	psi	7,000	8,000
Tensile modulus	ASTM D-638	psi	195,000	230,000
Elongation at Break	ASTM D-638	%	19	10
Flexural strength	ASTM D-790	psi	11,000	13,000
Flexural modulus	ASTM D-790	psi	260,000	300,000
Notched Izod	ASTM D-256	ft·lbf/in	1.0	1.0
Linear shrinkage	ASTM D-2566	in/in	0.001-0.005	0.001-0.005

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The processing and material temperature should be between 68-77°F (20-25°C).

This product will separate upon storage.

Agitate the hardener and resin before use to ensure that the formula is homogeneous.

Packaging

RC-0255 Quart Kit	3.68 lbs.
RC-0255 1 Gal. Kit	14.72 lbs.
RC-0255 Gal. Kit	73.60 lbs.
RC-0255 Drum Kit	828 lbs.

Storage

Original containers should be kept tightly sealed and stored at ambient temperatures 59-86°F (15°C to 30°C). If properly stored the products have the shelf-life indicated on the product label.

Partly used containers should always be sealed appropriately and used up as soon as possible.

Handling Precautions

Good workplace ventilation is to be ensured during processing. At the same time, the employer's liability insurance association's industrial hygiene safety regulations regarding the handling of reaction resins and their hardeners are to be observed. Please take heed of the appropriate safety data sheets.
