



"Dedicated to *QUALITY, SERVICE, SAFETY and INNOVATION*"

ALIPHATIC & WATER CLEAR URETHANES

WC-755 A/B WATER CLEAR 55 SHORE D URETHANE CASTING SYSTEM

PRODUCT DESCRIPTION:

WC-755 A/B produces a 55 Shore D material that is commonly used to make clear or tinted castings of all kinds. When used at room temperature, castings 1/8" thick or larger can be readily cast. Castings that are less than 1/8" thick generally require a mild post-cure. WC-755 is easily colored using opaque pigments or translucent tints and will retain its color during exterior exposure.

PRODUCT USES:

- Prototype computer parts
- Models of all kinds
- Artwork components
- Architectural models
- Gears, wheels, fans
- Transportation cases
- Miniatures and movie props

PHYSICAL PROPERTIES:

Hardness, Shore D.....	55 ± 5
Specific Gravity, (gm/cc) cured.....	1.08
Displacement, (cu.in./lb.).....	26.4
Color.....	Water clear/colorless
Tensile Strength, (psi) ASTM D-638.....	2,780
Tensile Modulus, (psi) ASTM D-638.....	1.4 x 10 ⁴
Tear Strength, (psi).....	300
Flexural Strength, (psi).....	290
Elongation, (%) ASTM D-638.....	205
Izod Impact, (Notched, Ft.-lb./in. avg.) ASTM D-2566.....	8.6
Shrinkage, (in.lin.) ASTM D- 2566.....	0.0036

HANDLING PROPERTIES:

Mix Ratio (by weight):

Part A.....	65 parts by weight
Part B.....	100 parts by weight

Mix Ratio (by volume)

Part A.....	62 parts by volume
Part B.....	100 parts by volume

Specific Gravity (gm/cc):

Part A.....	1.08
Part B.....	1.03
Mixed.....	1.05

Viscosity, Centipoise (cps) @ 77°P (25°C):

Part A.....	600 ± 50
Part B.....	740
Mixed.....	700 ± 50

Work Life @ 77°F (25°C) (100 gm mass)..... 20 minutes

Gel Time @ 77°F (25°C) (100 gm mass)..... 35 minutes

Demold Time @ 77°P (25°C)..... 16 - 24 hours

Cure Schedule..... 5 - 7 days at R.T., or 16 hours at 150° - 180° F(66° - 82°C).

Product is sufficiently cured after one day, ambient, for general handling.