



ALIPHATIC & WATER CLEAR URETHANES

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

**WC-765 A/B
WATER CLEAR 65 SHORE D URETHANE CASTING SYSTEM**

PRODUCT DESCRIPTION:

WC-765 A/B is a two part, clear, colorless 65 Shore D urethane castable product that is commonly used to make clear or tinted parts 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. This product may exhibit a slight yellowing or color change when exposed to direct UV light.

PRODUCT HIGHLIGHTS:

- Exceptional clarity
- Tough and impact resistant
- 15-20 minute working time
- No odor, solvents or exudates
- Good weatherability

PHYSICAL PROPERTIES:

| | |
|--|-----------------------|
| Hardness, Shore D ASTM D2240 | 65 ± 5 |
| Density, (g/cc) ASTM D792..... | 1.08 |
| Cubic Inches per Pound..... | 26.4 |
| Color/Appearance..... | Waterclear/colorless |
| Tensile Strength, (psi) ASTM D638..... | 4,600 |
| Tensile Modulus, (psi) ASTM D638 | 3.1 x 10 ⁴ |
| Elongation, (%) ASTM D638 | 225 |
| Flexural Strength, (psi) ASTM D790 | 315 |
| Flexural Modulus, (psi) ASTM D790..... | 2.9 x 10 ⁴ |
| Tear Strength (pli) ASTM D624..... | 460 |
| Shrinkage (in/in) linear ASTM D2566 | 0.004 |
| Izod Impact, notched (ft-lb/in) ASTM D256..... | 8.9 |

HANDLING PROPERTIES:

Mix Ratio (by weight):

| | |
|--------------|---------------------|
| Part A | 75 parts by weight |
| Part B | 100 parts by weight |

Mix Ratio (by volume):

| | |
|--------------|---------------------|
| Part A | 72 parts by volume |
| Part B | 100 parts by volume |

Specific Gravity:

| | |
|--------------|------|
| Part A | 1.08 |
| Part B | 1.03 |

Viscosity, (cps) @ 77°F (25°C) Brookfield:

| | |
|--------------|----------|
| Part A | 650 |
| Part B | 550 |
| Mixed..... | 650 ± 50 |

HANDLING PROPERTIES (continued):

| | |
|--|------------|
| Work Time, 100g mass @ 77°F (25°C) | 15 minutes |
| Gel Time | 20 minutes |
| Demold Time @ 77°F (25°C)..... | 6-8 hours |

CURE SCHEDULE/HEAT CURING:

Most of the physical properties can be achieved in 5-7 days at ambient temperature, 77°F (25°C). In order to achieve maximum physical properties, a post cure with heat is required. BJB recommends 24 hours at ambient temperature, 77°F (25°C), followed by 16 hours at 180°F (82°C). Support of the part may be required to prevent part deformation during the heat curing process.

NOTE:

The cure will be inhibited if cast against a tin catalyzed silicone RTV.

STORAGE AND HANDLING:

Store in a cool dry place. Unopened containers will have a shelf life of 6 months from date of shipment when properly stored at room temperatures. Purge opened containers with dry nitrogen before re-sealing.

PACKAGING:

| | |
|--------------------------|------------------------|
| Gallon Kits..... | 6 lbs. A, 8 lbs. B |
| 5-Gallon Kits | 30 lbs. A, 40 lbs. B |
| 55-Gallon Drum Kits..... | 300 lbs. A, 400 lbs. B |

SAFETY PRECAUTIONS:

Avoid contact with skin using protective gloves and protective clothing. Repeated or prolonged contact on the skin may cause an allergic reaction. Eye protection is extremely important. Always use approved safety glasses or goggles when handling this product. Use in well-ventilated areas. Avoid breathing vapors. If exposures cannot be kept at a minimum, a respirator may be necessary in addition to ventilation. The use of a positive pressure air supplied respirator is mandatory when airborne isocyanate concentrations are "not known" or exceeds OSHA'S TWA of 0.005 ppm. Air purifying, organic cartridge type respirators are not generally recommended to use when handling this material without implementation of an end of life service program. Observe OSHA regulations for respirator use (29 CFR 1910.134). Employers are responsible for selecting the correct respirator for each situation.

IF CONTACT OCCURS:

Skin: Immediately wash with soap and water twice. Remove contaminated clothing and launder before reuse. It is *not* recommended to remove resin from skin with solvents. Solvents only increase contact and dry skin. Seek qualified medical attention if allergic reactions occur.

Eyes: Immediately flush with water for at least 15 minutes. Call a physician.

Ingestion: If swallowed, call a physician immediately. Remove stomach contents by gastric suction or induce vomiting only as directed by medical personnel. Never give anything by mouth to an unconscious person.

Refer to the Material Safety Data Sheet before using this product.