



Plasti-Cast™

Castable Fiber Filled Resin

PRODUCT OVERVIEW

Plasti-Cast™ is a new two component castable fiber-filled resin that cures to a lightweight durable plastic. Part A is a liquid and Part B is a paste. Mix ratio is 1A : 2B by volume (84A:100B by weight). It has no odor and pot life is 7 minutes depending on mass. Demold time is about 60 minutes depending on mass.

Plasti-Cast™ is meant to be cast in thicknesses of ½” (1.27 cm) or more and will cure to a strong, durable and lightweight plastic. It is suitable as a pourable mother mold material (reinforces shape of rubber mold during casting) or lightweight casting plastic. For making trowelable mother molds, use Plasti-Paste™.

TECHNICAL OVERVIEW

Key Values: ~Mixing Ratio: One A to Two B by volume (84 A : 100 B by weight) ~Color: Off-White
~Durometer: Shore 58D ~Shrinkage: 0.0018”/inch ~Pot Life: 7 minutes ~Demold Time: 60 minutes (depending on mass).

Description: Plasti-Cast™ consists of two liquid components, Part A (Yellow Label) and Part B (Blue Label). When combined in a mixing ratio of 1A : 2 by volume (84A:100B by weight), Plasti-Cast™ cures in about 60 minutes to a durable plastic.

Applying A Release Agent

Measuring

Mixing

Preparation . . . Materials should be stored and used in a warm environment (72° F / 23° C). Mixing should be done in a well-ventilated area. Wearing eye protection, latex gloves and long sleeve garments to minimize skin contact is strongly recommended.

Applying A Release Agent . . . A release agent is necessary to facilitate demolding when applying as a mother mold over a cured mold rubber. Use a release agent made specifically for mold making (Universal Mold Release or Ease Release 6577 available from TCS, Inc). A liberal coat of release agent should be applied onto all surfaces that will contact the plastic. ~IMPORTANT: apply light mist coating, brush the release agent with a soft brush over all surfaces. Follow with a light mist coating and let the release agent dry for 30 minutes.

PRE-MIX Part B Before You Start . . . Part B is a thick paste that needs to be pre-mixed before being dispensed into measuring container. This will redisperse components that may have settled.

Measuring the components of Plasti-Cast™ requires two containers. The first will be used for measuring out amounts of Part A and Part B. The second should be large enough to contain both components and allow thorough mixing. **IMPORTANT:** Shelf life of Part A (Yellow Container) is drastically reduced after opening. Remaining product should be used as soon as possible. Immediately replacing the lids on both containers after dispensing product will prolong the shelf life of the unused product. **XTEND-IT Dry Gas Blanket** (available from TCS, Inc) will significantly prolong the shelf life of unused liquid urethane products.

Mixing . . . Mix Ratio is 1A:2B (84A:100B by weight) by volume. **(Step 1)** Fill measuring container to the top with Part B paste, making sure to eliminate any large voids. Level off the top of the container and remove any excess material. The paste should then be thoroughly emptied into a larger container that will act as your mixing container. Repeat As Necessary. **(Step 2)** Fill the measuring container to the top with Part A liquid and empty into mixing container. **Mix thoroughly for 1 -2 minutes** making sure that you **scrape the sides and bottom of the mixing container several times.**

Applying

Curing

Storage

Pouring . . . Do not delay between mixing and pouring. Pour mixture at the lowest point of containment field. Let mixture rise up and over mold. This will help minimize entrapped air.

Curing . . . Plasti-Cast™ will develop handling strength and can be removed from rubber surface in about 60 minutes. Full strength will develop in 24 hours.

Safety First!

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The material safety data sheet (MSDS) for this or any other product should be read before using and is available at www.SCULPT.com. All Smooth-On products are safe to use if directions are read and followed carefully.

Be careful. Part A (Yellow Label) contains methylene diphenyldiisocyanate. Vapors, which can be significant if prepolymer is heated or sprayed, may cause lung damage and sensitization. Use only with adequate ventilation. Contact with skin and eyes may cause severe irritation. Flush eyes with water for 15 minutes and get immediate medical attention. Remove from skin with soap and water. Part B (Blue Label) is irritating to the eyes and skin. Avoid prolonged or repeated skin contact. If contaminated, flush eyes with water for 15 minutes and get immediate medical attention. Remove from skin with soap and water. When mixing with Part A, follow precautions for handling isocyanates. If machining, wear dust mask or other apparatus to prevent inhalation of residual particles.

Important - The information contained in this bulletin is considered accurate. However, no warranty is expressed or implied regarding the accuracy of the data, the results to be obtained from the use thereof, or that any such use will not infringe a copyright or patent. User shall determine suitability of the product for the intended application and assume all associated risks and liability.

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