Precision Converting

PRETHANE

URETHANE SYSTEMS

MIXING AND CURING

• INSTRUCTIONS •

For best results, store the material at room temperature (70-80 degree F). It is very important to have the material at room temperature at mixing time.

Have all of the necessary mixing supplies clean and ready for use. Once you have catalyzed your material, time is critical in producing the best possible mold or cast.

Stir part "B" side of the urethane for 3 to 5 minutes prior to mixing with part "A" to obtain a proper cure.

It is important to accurately weigh or measure all of the materials. Urethanes are ratio sensitive. Please refer to the technical data sheets for the proper mix ratios.

After weighing out the necessary amount of materials, close the original container. Urethanes will pull moisture from the atmosphere and this can seriously affect the shelf life. If possible, put a Pre-Dry (See accessories section) blanket over the material before resealing. This will help maximize the shelf life of uncured material.

Once the material is catalyzed, time is critical in producing the best possible molds or casts. Please refer to the technical data sheets for the pot life. Remember the times stated on the data sheets are an average taken in lab conditions (72 degree F at 50% relative humidity). The sooner the material is in place, the better chance of making the perfect mold. Do not get in a hurry.

A good mix of part "A" and part "B" is important for the perfect mold. Scrape the sides and bottom of the mixing container with a spatula while mixing the urethane. For large pours, over 25 pounds use a Jiffy Mixer (see accessories section) with a electric drill. Be careful not to introduce any unwanted air into the mix.

After pouring the material out of the mixing container, do not scrape the sides again or pour the last small amount of urethane in the mold or cast. Often, this is either Part A or Part B rich. For best results, empty the mixed urethane into a new clean container, stir briefly, and then pour into the mold box or mold.

Choose the correct material for the application. Samples are available for preliminary testing. Call Precision Converting for recommendations and technical assistance.

•POTENTIAL PROBLEMS•

Not stirring the B side 3-5 minutes before catalyzing. This can inhibit the cure or cause unwanted bubbles in the mold.

Not having all of the mixing supplies ready before catalyzing the material. Once the urethane reaches its gel state, it must be in position.

Not having the proper mix ratio. Urethanes are ratio sensitive and must be weighed or measured properly.

Not using the best mold release for the job. Please refer to the mold release comparison chart in this section.

Not having the material at room temperature before mixing. Hot weather will shorten the cure time, while in cold weather will lengthen the cure time.

Not properly storing the material. Always keep containers at room temperature and tightly sealed. Moisture from the atmosphere will contaminate the material.