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MOLD-QUICK MEDIUM POLYURETHANE MOLD MAKING SYSTEM

Product Data Sheet

PRODUCT DESCRIPTION AND APPLICATIONS

MOLD-QUIK A/B is a two-component, 100% solids Urethane Elastomer RTV that is easily processed. This system provides semi-flexible, abrasion resistant rubber compound with good elongation for easier demolding. Use for creating molds and rubber parts, especially large molds where dimensional stability is required to avert distortion. Molds are used to cast cement, wax, and plaster parts.

UNIQUE CHARACTERISTICS

- 100% Solid Urethane
- Easy to Process
- Rapid Mold Cycle

TYPICAL PHYSICAL PROPERTIES

(For Components)

	Component A	Component B
Viscosity (cps):	5000	1000
Mix Ratio, By Weight:	100	100
Color:	Yellow/Clear	Green

(fFor Cured Material)

	Test Method	Results
Shore A Hardness:		45
Tensile Strength (psi):	ASTM D-638	425
Elongation %:	ASTM D-638	850
Tear Resistance (psi):	ASTM D-624	103
Specific Gravity:		1.03
Coverage:		27 CU/IN/LB

REACTIVITY DATA

Gel Time:	30 minutes
De-Mold Time:	12-16 Hrs

PREPARATION OF MASTER:

Urethane elastomers will adhere to most surfaces. A proper mold release must be used on all surfaces—*ARTLUBE-100* is recommended. Wood, plaster, stone, pottery, masonry, or any porous surface must be sealed with lacquer or clear shellac prior to applying release. *TR#4* or shellac is suitable for sulfur & water based clays. Allow 24 hours to dry before preparing master with mold release. Plaster masters can release air when pouring larger molds due to some heat generated. Venting the base of your master by (drilling several ¼" holes) will release the air

downward to avoid air release into mold cavity. Urethane RTV cures to a flexible rubber in above cure times. These products are safe to use as directed, check MSDS for safety information.

MIXING AND CURING

Before adding A to B, urethane B should be stirred or shaken for 1 minute to assure that any separated material is remixed. Select a clean, dry container for mixing. Avoid using wood or paper products, which could cause cure problems. Weigh the proper ratio A to B and mix well. Two containers may be used to assure that all materials are well mixed.

Pour mixture over master slowly allowing material to fill void and push air out of cavity. A vacuum chamber can be used to remove excess air bubbles before pouring. After mixture is poured a light mist of **ARTLUBE-100** can be sprayed on top of the surface to break tension bubbles. Urethane RTV will cure to solid rubber at above cure time. Urethane rubber that is colder than 75°F will cure slower. During colder weather material may be heated in a hot water bath (place container in plastic bags first) and the master model should be warmed. Accelerated cures can be reached by heating the mold and material at 100-150°F for pre-determined time. Cold weather or off-ratio material can result in unacceptable rubber results.

BRUSH ON MOLDS:

A material with low sag may be obtained by mixing a powder- **EnvironMolds Fibers**. Various ratios of 5% to 10% can be used to achieve different thickness and flow control. A mold can be made with only four coats applied within an hour, which can be brushed or toweled onto surface. A mold release should be used to separate the mother mold from rubber mold.

STORAGE:

Material should be stored in warm, dry area with lids secured tightly. Once containers are opened, material should be used in a short time period. Component A can react with moisture and turn solid over period of time. Pre-test any aged material before using.

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