

PANOCAST™ CASTING EXPANDER

An Expanding Casting Material to Grow Your Castings

Increase casting sizes up to 160-200%

DESCRIPTION: Panocast is a two component 100% solids urethane rubber that cures to exact size of the part, then, when soaked in water for a few days, can expand up to 100% in size. Applications include enlarging size of:

- original art pieces
- models
- movie props
- toy masters

Panocast is unable to various sizes, but only one true enlarged size after soaking.

MODEL PREPARATION: Seal porous surfaces with shellac. Often no other release is needed. Avoid oils, petroleum jelly or oil clays as they will adversely affect your mold. Avoid application directly on metals. Test coat a small area to check for good release.

RELEASE AGENTS: Do not use petroleum-based release agents. Petroleum based release agents will react with the latex and destroy your mold. Often no release agents are needed if you model is properly sealed.

DIRECTIONS FOR USE: Mix A & B materials by proper weight or volume, taking care not to whip excess air into mixture. A quick vacuum, opening and closing exhaust valve, will press out some air. Pour material into Silicone RTV mold and de-mold the casting in 24hrs. If using a non-silicone RTV mold, use a release agent and apply material to surface capturing the detail. Multiple pours may be helpful in reducing entrapped air in mixture.

Mix only the amount of material needed over a 10-minute application. Once cured, allow piece to fully cure an additional 2 days before soaking--prematurely soaking part too soon will result in part dissolving and deteriorating during enlarging process. Panocast can be soaked in a container of water to begin the growing process. Dimensional distortion may occur during the process, but allow the material casting 72 hours or more to expand to proper stable shape. Once enlarged, wipe with dry towel and dust with a talc.

The model is now ready to be molded in a Tin based RTV rubber mold such as ArtMolds' MoldRite25. De-mold part immediately after mold has cured. Water expanded rubber will shrink back to original size so a mold should be made as soon as possible.

SAFETY:

EYE CONTACT with liquid or sprayed components can result in corneal burns or abrasions. Upon exposure, flush with water for an extensive period and **SUMMON "EMERGENCY TRAINED" MEDICAL ATTENTION IMMEDIATELY.**

SKIN CONTACT can result in a rash or other irritation. Wipe

TECHNICAL DATA

	Part A	Part B
Viscosity (cps)	2550	1200
Mixed A/B	1900	
Mix Ratio, by weight	100	100
Color	Amber/Clear	Clear
(For cured material)		
Shore A hardness		0
Tensile strength (psi)	ASTM D-638	1076
Elongation %	ASTM D-638	300
Reactivity Data		
Gel time	12 – 15 minutes	
De-mold time	16 – 24 hours	

residual liquid from the skin with a clean cloth, and then follow by washing with soap and water. Remove contaminated clothing and wash before reuse. If a rash or other irritation develops, SEE A PHYSICIAN.

VAPOR INHALATION problems are characterized by coughing, shortness of breath, tightness of the chest, headaches, dizziness or nausea. Anyone exhibiting these symptoms should be immediately removed from the workplace and administered oxygen or fresh air. If the condition is prolonged or extreme, **SUMMON "EMERGENCY TRAINED" MEDICAL ATTENTION IMMEDIATELY.**

STORAGE: Polyurethane products manufactured or produced from these chemicals may present a serious fire hazard if improperly used or allowed to remain exposed or unprotected. Each person, firm, or corporation engaged in the manufacture, production, application, installation or use of any polyurethane materials should carefully determine whether there is a potential fire hazard associated with such product in a specified usage, and utilize all appropriate precautionary and safety measures as outlined in local, state, and Federal regulations governing the manufacture of products, waste disposal, and/or the construction and/or renovation of commercial or residential structures.

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