

## TECHNICAL DATA SHEET

Product Name: MoldCast™

**Product Description:**

MoldCast™ is specifically formulated casting resin to produce very durable dimensionally stable molds. This 2-component 100% solids material may also be RIM injected or cartridge gun dispensed to create production molds, master plugs, secondary holding fixtures or even final component parts. Once cured these materials are extremely tough and exhibit excellent durability against abrasion, exothermic part cycling and cleaning chemicals. The chemical system delivers a customizable 10-20 minute reaction time to provide quick mold builds and/or parts. Standard mold release materials may be used on its slick to the touch surface. For multi-layer casts material may be continuously added to achieve desired thickness. This material may be color tinted using powder or liquid dye pigments. Mold surface repair must be done using proper procedure.

- Extremely durable and tough casting resin system for demanding operations.
- Excellent chemical, abrasion and impact resistant.
- Available in Neat see-through amber color or opaque Nano-Filled to control shrinkage.

**Material Property Values and Application Requirements Table**

Property	*Values relative to density	Test Method
Tensile Strength	2200 psi	ASTM D412
Flex Modulus	70k psi	ASTM D790
Abrasion Resistance	50 mg loss /1000 cycles	ASTM D4060 (CS-17)
Hardness Shore D	55-60	ASTM D785
Elongation	150 %	ASTM D412
Application: 90 psi low pressure 2K gear pump machine with static mixer dispense tube, 2k hand-held pneumatic cartridge gun mixing, hand batch mixing and pour cast.		
Typical Mixing Ratio 1A:1B pbv, For Slower and Flexible version 1A:2B. Power mix stir B-Side slowly until uniform color and viscosity prior to use, DO NOT INDUCE AIR into mixture.		
Surface Preparation: clean and dry, no residual cleaner or other contaminates, approved surface type, primer is usually required, installation ambient temp. 46F(8°C)- 104F(40°C), surface temp. 46F(8°C)- 32F(90°C).		
Tack Free Gel Time = 10-20 min. depending on reactivity version desired		
Functional operation temperature: -40F(-40°C)- 120F(48°C), Zero VOC.		
100% Solids Coverage, Continuous casting is allowed.		
See SDS for material safety data. Must wear eye goggles, respiratory protection, gloves, etc.		
KEEP MATERIAL FROM FREEZING, moisture-free temperature controlled storage 12°C- 32°C, 12 month shelf life if never opened. After opening reseal with Nitrogen blanket.		
Packaging: Tote set 550 gal (4900 lbs), 100 gal Drum set (900 lbs), 10 gal Pail set (90 lbs)		

Please contact our Engineering and/or Technical Support Groups with any questions.

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