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## AeroMarine Products White Urethane Casting Resin

AeroMarine Products White Urethane Casting Resin is a thin, fast setting polymer used for casting parts for many applications. It features a simple “one to one” mix ratio. It contains no fillers, has low odor, and cures to a white color. Urethane Colorants are available for this casting resin. Our White Casting Resin is easily painted with oil-based paints. Once cured, this resin can be drilled, machined or sanded.

NOTE: Make sure that the casting resin, tools, containers and ambient temperature are all at 70F before you begin pouring the casting resin. If you do not have everything at 70F, the casting resin will take longer to cure. At temperatures higher than 70F, the casting resin will cure more quickly.

\*\*Always wear a respirator or self-contained breathing apparatus when working with urethanes.\*\*

Do NOT spray. Our urethanes are only for pouring applications.

**Urethanes are moisture-sensitive. Do not use paper, wax or wood mixing tools. Always re-cap container immediately!**

### Features:

- Low Viscosity
- Low odor
- Low shrinkage
- Good chemical resistance
- Easily paintable

### Uses include:

- Casting figurines
- Casting fishing lures
- Rotocasting
- Taxidermy applications
- Casting industrial parts
- Cold Cast Bronze, when mixed with bronze powder

### Specifications:

Mix Ratio:	1:1 by volume
Solids By Weight:	100%
Shrinkage:	Unfilled: 0.01 Filled: 0.001
Mixed viscosity:	75 cps (Almost water thin)
Color:	White
Work life:	3 minutes@70F
Demold time:	15 - 30 Minutes@70F
Hardness:	70 Shore D (Very hard)
Tensile Strength:	2390psi
Compressive Strength:	7990psi
Specific Gravity:	1.11
Temperature restrictions:	140F



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## For industrial or professional use only

### Directions for use:

**Do not use on rainy or humid days. Do not use with paper or wood mixing containers or stir sticks. Urethanes are very moisture sensitive and moisture contamination will give your casting resin bubbles.** Both Part A and B should be at room temperature; 70F, before use. Part B should be shaken prior to use. Mix equal parts by volume. Measure in 2 separate clean plastic cups and pour into a 3rd clean plastic cup. Stir immediately for 20-30 seconds, taking care to scrape the sides and bottom of the mixing container. To avoid excessive exotherm, mix small batches until you are familiar with using this material. Since all urethanes are moisture sensitive, any filler used must be moisture free. This product is not UV resistant when cured. If the finished piece is going to be exposed to direct sunlight, it needs to be painted or sealed with a UV resistant urethane, like Kylon's Make-It-Last. Do not disturb the mold until the part is ready to be demolded. Prematurely demolding parts can cause deformation, especially in thin areas. Work life and cure time can be significantly affected by several variables, including size of mix, part shape, ambient temperature, temperature of the mold, filler content and age of material.

For enhanced characteristics, you can post cure this resin at 125F for 2 to 4 hours. Thin or detailed parts should be cured in their silicone molds or supported by other means.

### Best practices when using urethane casting resin

**Never mix less than about 3 ounces of product.** When manufacturers design and test their resins, they normally write the specifications for 100 gram batches, which is about 3 ounces. There are two things that can go wrong when mixing a smaller batch. It is much more difficult to get the correct mix ratio when working with very small amounts. Also, these mixtures are exothermic, meaning they generate heat in order to cure. A mixture of less than three ounces does not generate much heat and can take significantly longer to cure.

**Avoid mixing with drill motors.** Because of the friction they generate, mixing with electric drills can start the exothermic cure process and cause the product to cure in the mixing container. They can also whip air into the resin causing air bubbles. It is always best to mix the material by hand, with a plastic mixing utensil.

**If you use an aerosol mold release, let it dry first.** A spray can of mold release contains a lot of solvents and propellants. These compounds need to evaporate off the surface so they don't cause bubbles. Check the dry time of the mold release from the directions on the label. Once your casting resin is cured, you may want to wash it with a grease dissolving soap, like Dawn dish soap. This will help clean the surface of the resin for better paint adhesion.

**Don't vary the mix ratio.** Unlike some polyester resins, altering the mix ratio to vary the cure cycle will not work with urethanes.



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**We have urethane colorants.** We have a variety of urethane colorants. Follow instructions on the bottle for application. *NOTE: You will NOT get black with our white casting resin. For black, use our jet black casting resin.*

**Mix in clean plastic containers.** Paper cups and wooden mixing utensils may contain moisture which can adversely affect the urethane casting resin. Avoid waxed paper cups because the wax may melt and contaminate the resin.

**How to avoid air bubbles-** Air bubbles in urethanes are almost always caused by moisture. Do everything possible to avoid moisture getting into the mix. Replace the lids onto the containers promptly after use. Do not use the urethane resin during rainy days or times of high humidity. Avoid pouring against an unsealed water based product such as plaster or hydrocal. Seal plaster or hydrocal with a product like Krylon Clear Acrylic.

**Shelf life-** When stored in the original, unopened containers in a cool, dry environment, out of direct sunlight, the shelf life is six months. Once opened, shelf life can be preserved with the use of "Extend-It" aerosol nitrogen blanket.

**Avoid mixing a large batch-** The larger the batch, the more exotherm or heat is generated in the cure cycle. If you are casting a large part, mix small batches to make the process more manageable.

**Shake or stir well before use-** The liquid components may settle in the containers during storage. Shake or stir the components separately and thoroughly before mixing. Let it sit a few minutes to let any bubbles rise to the surface after shaking the container.

**Test-** Consider the first piece you pour to be a test cast. The first pour will tell you about the cure time, demold time and other aspects of your project.

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