

# EASYCAST® Clear

## Medium Cure Clear Polyurethane Resin

### PRODUCT DESCRIPTION

EASYCAST® CLEAR is an easy to use 1-1 by volume, low viscosity, water clear polyurethane resin. It is ideal for small parts such as lenses, model windows, prototypes and clear injection moulded like parts. Easycast® Clear is widely used for resin jewellery and it can produce parts that are near bubble free without the use of vacuum degassing. Finished parts once cured properly are extremely durable. Care should be taken to use Platinum Based/Addition Cure Silicone for the moulds. Tin Cure Silicone will result in defective casts. Always support the cast piece while post-curing. EC Retarder can also be used for a slower cure, see below.

### TYPICAL APPLICATIONS

Resin Jewellery  
 Model Windows  
 Lenses  
 Intricate Prototypes  
 SFX & Theatre Props

### MIXING PROPERTIES – 100gm @ 23°C

Mix Ratio (by volume)	Part A:	100	<i>Note: Measuring polyurethane by weight is always the preferred method</i>
	Part B:	100	
Mix Ratio (by weight)	Part A:	100	
	Part B:	90	
Mixed Viscosity:	250cps		
Work Time:	9 minutes		
Gel Time:	11-12minutes		
Demould Time:	30+ minutes, dependant on cast mass		

### EC RETARDER

Extended work times may be required when casting large or intricate parts with Easycast Clear. EC Retarder is an additive used to prolong the gel times of Easycast Clear. Add and blend EC Retarder to part B prior to the addition of Part A. Increase the amount of Part A by an equal amount of EC Retarder used. Since cure time will be extended, prematurely demoulding parts before full cure will result in sagging or distorted parts. Complete cure by post curing parts for 12-14 hours @ 60°C or leave @ room temp for 7 days.

Guidelines:	0.5%	14 minutes gel	<i>Various amounts of material will heat up and gel quicker. Some R&amp;D will be required to assure final results.</i>
	1%	24 minutes gel	
	2%	38 minutes gel	
	3%	45 minutes gel	

### CURED PROPERTIES – cured 7 days @ 23°

Colour:	Water Clear	
Hardness, Shore D:	80 ±2	
Elongation, %:	6.4	
Flexural Strength, psi:	8475	
Flexural Modulus, psi:	250,980	Post cured @ 66°C for 5-12 hours
	270,450	
Heat Deflection Temp, °C :	57	
	82	Post cured @ 66°C for 5-12 hours

Revision No: 2

Issue Date: 29<sup>th</sup> March 2007

Supersedes: Revision 1 – 30<sup>th</sup> January 2007

The data presented in this leaflet are in accordance with the present state of our knowledge, and does not absolve the user from carefully checking all supplies immediately on receipt. We reserve the right to alter product constants within the scope of technical progress or new developments. The recommendations made in this leaflet should be checked by preliminary trials because of conditions during processing over which we have no control, especially where other companies' raw materials are also being used. Recommendations for use do not constitute a warranty, either expressed or implied, of the fitness or suitability of the product for a particular purpose.

**Head Office**  
 6 Homedale Road  
 Bankstown NSW 2200  
 Australia  
 T: (612) 9793 7555  
 F: (612) 9793 7091

**Retail Showrooms**  
 53 King Street  
 Newtown NSW 2042  
 T: (02) 9557 9056  
 F: (02) 9557 9246

40-42 Swan Street  
 Richmond VIC 3121  
 T: (03) 9428 5511  
 F: (03) 9428 5533