



# WC-765 A/B

## WATER CLEAR 65 SHORE D URETHANE CASTING SYSTEM

### PRODUCT DESCRIPTION:

WC-765 A/B is a two part, clear, colorless 65 Shore D urethane castable product that is commonly used to make clear or tinted parts of all kinds. When used at room temperature, castings  $\frac{1}{8}$ " thick or larger can be readily cast. Castings that are less than  $\frac{1}{8}$ " thick generally require a mild post-cure. This product may exhibit a slight yellowing or color change when exposed to direct UV light.

### PRODUCT HIGHLIGHTS:

- Exceptional clarity
- Tough and impact resistant
- 15-20 minute working time
- No odor, solvents or exudates
- Good weatherability

### PHYSICAL PROPERTIES:

Hardness, Shore D ASTM D-2240.....	65 ± 5
Density, (g/cc) ASTM D-792.....	1.08
Cubic Inches Per Pound .....	26.4
Color/Appearance.....	Waterclear/colorless
Tensile Strength, (psi) ASTM D-638.....	4,600
Tensile Modulus, (psi) ASTM D-638.....	$3.1 \times 10^4$
Elongation, (%) ASTM D-638.....	225
Flexural Strength (psi).....	315
Tear Strength (pli) ASTM D-624 .....	460
Shrinkage (in./in) linear ASTM D-2566.....	0.004
Izod Impact, notched (ft-lb./in) ASTM D-256 .....	8.9

### HANDLING PROPERTIES:

Mix Ratio (by weight):

Part A .....	75 parts by weight
Part B .....	100 parts by weight

Mix Ratio (by volume):

Part A .....	72 parts by volume
Part B .....	100 parts by volume

Specific Gravity:

Part A .....	1.08
Part B .....	1.03

Viscosity, (cps) @ 77°F (25°C) Brookfield:

Part A .....	600 ± 50
Part B .....	550
Mixed.....	650 ± 50

**HANDLING PROPERTIES (continued):**

Work Time, 100g mass @ 75°F (24°C) .....15 minutes  
Gel Time .....20 minutes  
Demold Time @ 75°F (24°C).....6-8 hours  
Cure Schedule.....5-7 days at RT, or 16 hours at 150°-180°F (66°-82°C). See heat curing below.

**HEAT CURING:**

Generally, for most applications, ambient temperature curing is adequate. However, maximum physical properties are obtained by post-curing WC-765 for 16 hours at 140°-160°F (60°-71°C), or 6-8 hours at 180°F (82°C). Parts may require some support during heat cure. It is suggested that parts be allowed to cure at room temperature for a day before post-curing, as this will help minimize shrinkage.

**NOTE:**

**The cure will be inhibited if cast against a tin catalyzed silicone RTV.**

**STORAGE AND HANDLING:**

All materials should be kept in tightly closed containers out of contact with moist air. Stored under these conditions at temperatures of 60°-80°F (16°-27°C), the shelf life is 6 months from date of shipment. Part B may turn hazy or partially freeze below 65°F (18°C) storage. Warming to 80°-90°F (27°-32°C) will return product to a clear state.

**PACKAGING:**

Gallon Kits..... 6 lbs. A, 8 lbs. B  
5-Gallon Kits ..... 30 lbs. A, 40 lbs. B  
55-Gallon Drum Kits..... 300 lbs. A, 400 lbs. B

**SAFETY PRECAUTIONS:**

Avoid contact with skin using protective gloves and protective clothing. Repeated or prolonged contact on the skin may cause an allergic reaction. Eye protection is extremely important. Always use approved safety glasses or goggles when handling this product. Use in well-ventilated areas. Avoid breathing vapors. If exposures cannot be kept at a minimum, a respirator may be necessary in addition to ventilation. The use of a positive pressure air supplied respirator is mandatory when airborne isocyanate concentrations are "not known" or exceeds OSHA'S TWA of 0.005 ppm. Air purifying, organic cartridge type respirators are not generally recommended to use when handling this material without implementation of an end of life service program. Observe OSHA regulations for respirator use (29 CFR 1910.134). Employers are responsible for selecting the correct respirator for each situation.

**IF CONTACT OCCURS:**

**Skin:** Immediately wash with soap and water twice. Remove contaminated clothing and launder before reuse. It is *not* recommended to remove resin from skin with solvents. Solvents only increase contact and dry skin. Seek qualified medical attention if allergic reactions occur.

**Eyes:** Immediately flush with water for at least 15 minutes. Call a physician.

**Ingestion:** If swallowed, call a physician immediately. Remove stomach contents by gastric suction or induce vomiting only as directed by medical personnel. Never give anything by mouth to an unconscious person.

**Refer to the Material Safety Data Sheet before using this product.**