

# SILPAK SILPLASTIC

## 100% Solid, Castable, Polyurethane Resin System

**SILPLASTIC A/B** is an unfilled, 100% solid castable, two-component urethane plastic system. It is an odorless, low viscosity and very low shrink plastic that exhibits low reactivity temperature (170F - 77C maximum) with good durability and impact resistance. This system offers an extended Work Time (Gel) of 5 minutes\* and fast demold time, and works well for large batch mixes, warm weather climates, rotocasting applications and for production parts. Once cured, it can be machined, sanded, and drilled. Material can either be hand or meter mixed. Fillers can be added to adjust cost, appearance, and function.

### Features

- 100% solid
- Low shrink
- Low viscosity
- Longer Working Time

### Applications

Use to create parts that where durable plastic parts are needed including the following:

- Creating Masters
- Model kits
- Production parts
- Prototypes
- Plastic parts
- Roto-casting
- Picture frames

### Physical and Handling Properties

Property	Value
Color	Tan
Mix Ratio, by weight	1A : 1B
Initial Viscosity, Part A, cP	95
Initial Viscosity, Part B, cP	150
Initial Mixed Viscosity, at 77°F, cP	125
Hardness, Shore D	65
Gel Time, min	5
Demold Time, min	15-30
Specific Gravity	1.06
Tensile Strength, psi (ASTM D-412)	5600
Compressive Strength, psi	-----
Elongation, % (ASTM D-412)	10
Izod Impact-Notched, ft- lb/in (ASTM D-256)	0.53
Flexural Modulus, psi (ASTM D-790)	155000
Flexural Strength, psi (ASTM D790)	6300
Heat Deflection Temperature, F (D-648)	140

*Values listed above are typical and not intended for use in specifications.*

## Proper Use and Safety

Read all instructions and safety data sheets prior to use. Consult safety data sheets for all recommended safety precautions.

## Mixing

Parts A and B should be at room temperature, above 75°F, prior to use. Use appropriate plastic mixing containers and spatulas (tongue depressors and paint sticks are acceptable) that are clean and moisture free. Part B should be shaken or properly stirred prior to use. Weigh or measure appropriate amounts of A and B in container. Combine components and immediately mix, thoroughly scraping sides and bottom for 20-30 seconds before pouring into silicone mold. If mold is non-silicone, use an appropriate release agent such as **Silpak ER 2300**. If using filler, ensure that filler is moisture free and premix into Part A using a high shear mix head such as an airless Jiffy Mixer Blade. It is important to note that mixing this product off ratio can cause oily surfaces, which will limit paint adhesion.

## Curing

Do not disturb the mold until part is ready to be demolded. Prematurely demolding parts may cause deformation, especially in thin areas. Preheating molds to 100°F, prior to casting, will expedite cure, especially for thin section parts. Low temperatures will slow curing time and extend the demold time. Curing & gel times are influenced by many variables, including size of mix, part's shape, filler content, ambient temperature, and age of material.

## Finishing

Unfinished castings are subject to discoloration, yellowing, and chalking when exposed to direct or indirect sunlight and should be painted, coated, or sealed. Oil-based paints work well. Using an oil-based primer will improve paint adhesion. If release was used, wash the surface with grease dissolving soap or mineral spirits before painting. It is best to perform any finishing when parts are fully cured, 24-72 hours at 75°F.

## Storage & Shelf Life

Part A and B must be stored in their original, tightly closed containers to protect from moisture and foreign materials. Storage area should be maintained at temperatures between 64-86°F. Shelf life of materials when kept in unopened, sealed containers, at the recommended storage conditions, is six months. Containers should not be opened until ready or use. Once opened, storage life can be extended with the use of purging gas, such as nitrogen.

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