THERMOSET
TSD 771

Product Highlights

- Low viscosity for detailed molds
- Easy to use 1:1 mix ratio by volume for meter mixing or cartridge gun applications
- High impact strength
- Mid-range gel time with great demold time

Mixing Properties:	Part A (Isocyanate)	Part B (Polyol)
Mix Ratio (Parts by Weight)	100	90
Mix Ratio (Parts by Volume)	100	100
Color	Clear Amber	Clear
Viscosity @ 77F	40	175
Mixed Viscosity @ 77F	90	
Specific Gravity @ 77F (mixed)	1.07	
Gel Time (Minutes) @77F	7 minutes +/- 1	
Demold Time (varies w/ mass)	60 min +/- 10 min (varies based on mass)	
Visual color of cured parts	TRANSLUCENT	

Physical Properties:	ASTM Method	Cure 1
Hardness, Shore D	D-2240	70 +/- 5
Flexural Modulus (PSI)	D-790	195,000
Tensile Strength (PSI)	D-638	2300
Elongation (%)	D-638	50%
IZOD Impact Notched (ft-lb/in)	D-256	2.0
Shrinkage (in/in) (5" sample)	D-2566	.003
Color	VISUAL	TRANSLUCENT

Cure 1: Physical properties obtained using ambient room temperature (77°F). Tested after 7 days

Other related products offered

- Silicone rubber
- Mold release agents
- Mix tubes
- Additional products available. Inquire directly for products not listed.

Processing suggestions:

- Thoroughly agitate polyol (hardener) component to be sure the liquid is homogeneous.
- Properly weigh out the appropriate amounts of resin and hardener.
    - Mix thoroughly for two minutes being sure to scrape sides and bottom of container.
    - For best results, de-air the product before pouring into mold.
    - Pressurize mold in a pressure pot at 60psi until cured.
    - A heated post cure is recommended to achieve maximum properties and heat resistance. Depending on geometry, the part may need to remain in the mold or fixtured to maintain part tolerances.

Kit Sizes and Weights:

• Quart Kit	(0.43 gal)	3.8 lbs.
• Gallon Kit	(1.7 gal)	15.2 lbs.
• Five Gallon Kit	(8.6 gal)	76.0 lbs.
• Drum Kit	(94.1 gal)	836.0 lbs.

Safety Precautions:

The safety data sheet (SDS) for this or any Thermoset Solutions, LLC product should be read prior to use and is available upon request from Thermoset Solutions, LLC.
Use in a ventilated area. 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.

If Contact Occurs:

- Eyes: Immediately flush with water for at least 15 minutes. Call a physician
- Skin: Immediately wash with soap and water. Remove contaminated clothing. Do not use solvents to wash skin. Seek medical attention if allergic reaction occurs.
- Ingestion: If swallowed, call a physician immediately. Remove stomach contents by gastric suction or induce vomiting only as directed by medical personnel.

Notice:

The information contained in this tech data sheet is considered accurate. However, no warranty is expressed or implied regarding the accuracy of the data, the results to be obtained from the use thereof, or that any such use will not infringe upon a patent. User shall determine the suitability of the product for the intended application and assume all risk and liability whatsoever in connection therewith.