

Polytek

POLY 75 SERIES RTV LIQUID RUBBERS

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DESCRIPTION: Poly 75 Series rubbers consist of liquid Part A and Part B which after mixing, cure at room temperature to economical flexible mould rubbers. These products may be considered for casting plasters, cement and waxes. Resins may also be cast with proper release agents. The Poly 75 Series has been formulated for good economy with high performance.

<u>PHYSICAL PROPERTIES</u>	<u>POLY 75-59</u>	<u>POLY 75-60</u>	<u>POLY 75-70</u>	<u>POLY 75-75</u>	<u>POLY 75-80</u>
Mix ratio by weight	1A to 1B	1A to 1B	1A to 1B	2A to 1B	2A to 1B
Shore A hardness	60	60	70	75	80
Pot Life (Pour Time)	10 minutes	10 minutes	40 minutes	20 minutes	45 minutes
Colour	Amber	Amber	Grey	Amber	Yellow/Amber
Viscosity mixed	2,500 cps.	1,200 cps	3,000 cps	4,000 cps	5,000 cps
Cubic inches/pounds	27	27	27	26	26

MODEL PREPARATION: Porous models such as wood or plaster must be sealed (MacWax Release Agent can be used for this) then coated with a release like Macsil Polyurethane Release Agent (or similar). Lacquer, paint, PVA, and potters soap on damp plaster work well as sealers. If shellac is used as the sealer, it must be thoroughly coated with release agent as Poly 75 Series rubbers bond tenaciously to Shellac. The sealed or non-porous model should then be coated with Pol-Ease 2300 release agent which should be allowed to dry. In every case where there is any question about the compatibility between the rubber and the prepared model surface, a test cure should be made on an identical surface. Porous models must be vented from beneath to prevent trapped air from forming bubbles in the rubber.

MIXING AND CURING: Both Parts A and B tend to absorb atmospheric moisture which spoils the material, so containers should be used up as soon as possible after opening. Part A should be weighed into a clean metal or plastic container, then the appropriate amount of Part B may be weighed into the same container. Mix thoroughly. We recommend hand mixing with a Poly Paddle to avoid mixing air into the rubber. While mixing, scrape the sides and bottom several times to ensure thorough mixing of both components. Pour the rubber as soon as it is thoroughly mixed to obtain best flow and air bubble release. Ultimate properties are reached in about seven days but moulds may be used with care after 48 hours curing. Curing in a warm location accelerates the cure while low temperatures retard the cure. Avoid curing in areas where the temperature is below 60 degrees F. Tools may be cleaned with denatured alcohol before the rubber cures.

USING THE MOULD: Usually no release agent is necessary when casting plaster or molten wax in Poly moulds. Sponging, dipping or spraying the mould with 1% detergent solution in water and pouring plaster on the wet mould reduces air bubbles in the plaster and aids release. Pol-Ease 2300 (Ambersil Polyurethane Release Agent) is an excellent release agent for most resins. Water-based form releases are preferred for concrete. Mineral oil based release agents should not be used. Exposure to solvent type form releases should be kept to a minimum. Poly 75 Series moulds will last many years if stored undistorted on a flat surface in a cool, dry location out of direct sunlight.

WARNING: Uncured Poly compounds may cause skin or respiratory irritation or sensitization if improperly handled. Avoid skin and eye contact with the uncured material. If skin contact occurs, remove with waterless hand cleaner or alcohol then soap and water. In case of eye contamination, flood with water and call physician. Use only with adequate ventilation. If there is any doubt about adequacy of ventilation, a mask with air purifying cartridge for organic vapours should be worn when using Part A. Poly elatomers are not to be used where food or prolonged body contact may occur. Read MSDS and container labels prior to use.

DISCLAIMER: The information contained in this bulletin is considered accurate. However, no warranty is expressed or implied regarding the accuracy of the data, the results to be obtained by the use thereof, or that any such use will not infringe any patent. Before using, user shall determine the suitability of the product for the intended use and user assumes all risk and liability whatsoever in connection therewith.

Supplied By:

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