

## 30A Water Clear

Water clear, semi-flexible polyurethane elastomer

### Key Properties

- Excellent physical properties after RT cure
- Free of mercury, MOCA or TDI
- Low viscosity and uses materials that have excellent U.V. resistant qualities

### Applications

- For hand-batch or vacuum assisted processing

### Processing Properties

			Resin (Isocyanate)	Hardener (Polyol)
Mix ratio		pbw	32	100
		pbv	32	100
Density	ASTM D-792	g/cm <sup>3</sup>	ca. 1.07	ca. 1.07
Viscosity at 77°F (25°C)	ASTM D-2393	cP	ca. 1,200	ca. 690

			Mixture
Mix viscosity at 77°F (25°C)	ASTM D-2393	cP	ca. 790
Gel time at 77°F (25°C)		min	15-25
Demold time at 77°F (25°C)		h	4-8

### Cured / Mechanical Properties (approximate values)

Cure 1: 24 hours at 77°F + 16 hours at 150°F Cure 2: 7 days at 77°F			Cure 1	Cure 2
Aspect	visual		Clear	Clear
Density	ASTM D-792	g/cm <sup>3</sup>	1.07	1.07
Shore hardness A	ASTM D-2240		25-35	25-35
Tensile strength	ASTM D-638	psi	250	250
Elongation at Break	ASTM D-638	%	250	250
Tear strength	ASTM D-624	pli	40	40
Linear shrinkage	ASTM D-2566	in/in	0.001-0.005	0.001-0.005

### 30A Water Clear

Water clear, semi-flexible polyurethane elastomer

---

#### Processing

**The processing and material temperature should be between 68-77°F (20-25°C).**

Certain silicone rubbers, including platinum silicones, will inhibit the OC-5000 series. Tin based silicones will yield the most favorable results. It is recommended that a test plaque be cast on the outside of the silicone tool to test for compatibility. Contact your RAMPF Group Inc. representative for more information. For best results, de-air the material prior to casting, then pressurize to 60 psi until cured. If pigment has been added to the hardener component, it will separate during storage.

**Agitate hardener before mixing to ensure that the formula is homogeneous.**

---

---

#### Packaging

OC-5030 Quart Kit	2.64 lbs.
OC-5030 1 Gal. Kit	10.56 lbs.
OC-5030 5 Gal. Kit	52.8 lbs.
OC-5030 Drum Kit	594 lbs.

---

---

#### Storage

Original containers should be kept tightly sealed and stored at ambient temperatures 59-86°F (15°C to 30°C). If properly stored the products have the shelf-life indicated on the product label.

Partly used containers should always be sealed appropriately and used up as soon as possible.

---

---

#### Handling Precautions

Good workplace ventilation is to be ensured during processing. At the same time, the employer's liability insurance association's industrial hygiene safety regulations regarding the handling of reaction resins and their hardeners are to be observed. Please take heed of the appropriate safety data sheets.

---