

Product Name**ROTOTHANE
Fast Cure Polyurethane Resin****Product Description**

Two-component rigid urethane casting compound that cures at room temperature and features:

- Excellent Flow
- General Shore 65D Hardness range
- Rapid setting
- Good rotational casting properties
- Compatible with a wide range of fillers
- Excellent detail reproduction because of its low viscosity
- Easy 1:1 mix ratio by volume

Typical Applications

Rotothane is commonly used for hollow rotational cast parts including such as model kits, collectibles and movie props. It is also suitable for pattern and foundry tooling, architectural models, mirror and picture frames, masters and prototypes and most other decorative components.

Physical Properties

Hardness		Shore D	65±2
Specific Gravity, cured		[g/cc]	1.03
Colour			White
Ultimate Tensile		[psi] mPa	[5395] 37.2
Flexural Strength		[psi] mPa	[5728] 39.5
Flexural Modulus		[psi] mPa	[142 940] 985
Elongation		[%]	7.9
Heat Deflection		°C	71
Shrinkage, linear	Unfilled	[in/in]	0.0169

Handling Properties

Mix Ratio	By Weight	Part A	100 pbw
		Part B	90 pbw
	By Volume	Part A	100 pbv
		Part B	100 pbv
Viscosity	cps @ 25°C	Mixed	120
Work Time	100g mass @ 25°C		2 minutes
Gel Time	100g mass @ 25°C		2.5-3 minutes
Demould Time	@ 25°C		15-30 minutes (note 1)
Cure Schedule	7 days ambient; or post cure of 16 hours @ 70°C is recommended to promote maximum physical properties		

Storage

Store at room temperature in a dry area.

Note 1

Rotothane generally cures to a demouldable state in about 15-30 minutes, however, thin sections or certain part configurations may require more in-mould cure time. Sections that are less than 3mm may require more time before demould.

Note 2

Both components should be mixed before each use to ensure uniformity of the materials. Opened containers of material should be purged with F720 Dry Air Blanket prior to replacing lids or caps, to prevent moisture contamination from humid air.

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Revision Number

1

Disclaimer

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