



POLYMERES
technologies

TECHNO CAST 3499M

Filled fast cast urethane
Medium Pot-life 10-12 minutes

DESCRIPTION

The properties of TECHNO CAST 3499 M include a pot-life of 10-12 minutes, and a curing time as short as 40 minutes. These properties make it ideal for casting medium scale series molds giving enough time to fill a mold completely, with virtually no shrinkage on medium sized parts. It is ideal for dimensional checking fixture and positioning assemblies. It will pick up fine details making it a good choice for casting medium sized prototype parts.

CHARACTERISTICS

- Easy to mix one to one mix ratio
- Rapid demold time
- Easy to use
- Good temperature resistance after thermal treatment
- Extremely low shrinkage

APPLICATION

Mix each component separately until a homogenous mixture is obtained.
Next carefully mix the components together according to indicated ratios.

Please consult **POLYMERES TECHNOLOGIES** for more details based on your application.

TYPICAL PROPERTIES (at 22°C)

		PART A	PART B	MIXED
Mix Ratio	1. By weight	100	100	100/100
	2. By volume	1	1	1/1
Characteristic		Liquid	Liquid	Liquid
Color		Blue	Beige	Blue
Viscosity	Brookfield RVT cps	2 450	2 950	2 550
Density	g/cm ³	1.68	1.68	1.68
Pot Life on 200 gr		10 - 12 minutes		
Demolding time		40 minutes		

MECHANICAL AND HEAT RESISTANCE PROPERTIES (solid state) 7 days after cure at 22°C

TEST	METHOD	RESULTS	
Final Hardness	ASTM D 2240	Shore D	80
Shrinkage at room temperature cure		%	0.25%
Tg (TMA) at 22°C	ASTM E 1545-95A	°F/°C	112 / 45
Flexural Modulus of Elasticity	ASTM D 790	psi/MPa	2 690
Flexural Strength	ASTM D 790	psi/MPa	23
Compressive Strength	ASTM D 695	psi/MPa	51
Tensile Strength	ASTM D 638	psi/MPa	18

PRECAUTIONS

- Consult Material Safety Data Sheet prior to use.
- Normal health and safety precautions should be observed when handling this product :
 - Ensure proper ventilation.
 - Wear gloves and safety glasses
- **RESEALING:** Many polymers are moisture sensitive, reseal, using one of the following two (2) methods: blanket with nitrogen or use a hair dryer for 30 seconds to cover with dry air **TECHNO DRY 7477**.
- After each application, tightly close each can to retain the properties of the product. To be used immediately after opening.
- The shelf life of both parts is **one (1) year** in a dry place and in the original unopened containers at a room temperature of 59°-77°F/15°-25°C.
- It is recommended to follow Provincial and Federal safety regulations. In case of eye contact, rinse well with water, in case of skin contact, rinse with soap and water. Keep away from children.

GUARANTEE

Having no control on the use and applications of this product, the manufacturer and/or distributor cannot guarantee the results achieved. The warranty is therefore limited to the replacement of a product whose user can demonstrate, in a way that is satisfactory to both manufacturer and distributor, that it is in fact defective. Before using this product, the user must ensure that it is appropriate for the chosen purpose. The user assumes all risks related to this use. The user must ensure that the product meets his or her needs by testing it at the short, medium, and long-term to validate the results in the intended operating conditions and following the prepared instructions. This limited warranty disclaims any liability for indirect, accidental, or special damages. Except for the warranty described above, the user expressly recognizes and accepts that, upon purchase of this product, the manufacturer and/or distributor disclaim any other responsibility and that any other warranties, express or implied, related to a warranty of merchantability and to an implicit warranty related to the quality of materials are expressly excluded.