SILPAK, Inc

470 E. BONITA AVE. POMONA, CA 91767
PH (909) 625-0056 WWW.SILPAK.COM FX (909) 625-0082

Self Thickening Plastic
TROWEL-ON 60 A/B
Product Data Sheet

Description
TROWEL-ON 60 is a plastic brush-on, two-component, liquid urethane system with thixotropicy for vertical hand lay-ups with good impact resistance. Great substitute for creating non-fiberglass mother-mold shells, light-weight hollow shelled parts, or used as a good fillet material. Trowel-On 60's easy 1 to1 mix ratio and long Gel Time 8-10 minutes, allows for easy processing and application. Parts are extremely hard and durable, even in thin cross sections—3/8" thickness. Also works well for filling and patching applications on plastic parts. Once cured, parts are easily paintable and can be machined, sanded and drilled.

Available Sizes: Pint Kit (2 lb) & Qrt Kit (4 lb) Gal Kit (16 lb) & 5 Gal Kit (80 lbs) 55 Gallon Drum Kit (900 lbs)

Application
Fiberglass substitute for mother mold shells, light weight/ hollow shelled parts, as an adhesive, patching and filling

TYPICAL PROPERTIES REACTIVITY DATA*

Property	Test Method	Results
Solids By Weight (%):		100%
Shrinkage:	ASTM D-1353	.001
Viscosity @ 74F (CPS):	ASTM D-2196	1000 A / 400 B

Mixing Ratio:	By Weight:	50 A / 50 B
	By Volume:	47 % ISO / 53 % POLY

Gel Time:	8-10 min (3/8" thick)
De-mold Time:	60-90 min

CURED MATERIAL PHYSICAL PROPERITES (Typical)

Property	Test Method	Results
Color:	Visual	Off-White
Hardness, Shore D :		80
Density (lbs/ft^2):	ASTM D-1622	67
Tensile Strength (psi):	ASTM D-2370	2389
Elongation (% at yield):	ASTM D-2370	20%

*Reactivity times are influenced by many equipment variables, including size of pour -shape, ambient temperature and humidity.

Processing Instructions:
Parts A and B should be at room temperature—above 75F—prior to use. Use appropriate plastic mixing containers and spatulas (tongue depressors and paint sticks are acceptable) that are clean and moisture free. ***Part B should be well mixed prior to use.*** Weigh or measure appropriate amounts of A and B in container. Combine components and immediately mix, thoroughly scraping sides and bottom for 20-30 seconds before pouring into silicone mold. Material will shortly begin to thicken to paste form. Pour into mold cavity or over mold rubber and immediately spread around in the mold with a spatula, ensuring the 1st coat is worked into surface of mold if it is highly detailed to minimize air bubble entrapment. May need add 2-3 coats to build up part strength, always applying successive coats before material fully cures. Build thickness to 3/8 inch thick for tougher part. Try to work in small mix batches of pint or quart sizes. This material will bond to any surface other than silicone, therefore a good mold release is required—*MR 515* Silicone based release. *Off ratio can cause oily surfaces, which will limit paint adhesion.

Curing:
Do not disturb the mold until part is ready to be de-molded. Prematurely demolding parts may cause deformation, especially in thin areas. Heating part's surface—100F—will expedite cure. Low temperatures will slow curing time and extend the demold time.

*Curing & Gel Times are influenced by many variables, including size of mix, part shape, filler content, ambient temperature and age of material.

Finishing:

Unfinished castings are subject to discoloration, yellowing, and chalking when exposed to direct or indirect sunlight and should be painted, coated or sealed. Oil based paints work well. Using an oil based primer will improve paint adhesion. If release was used, wash the surface with grease dissolving soap or mineral spirits before painting. It is best to perform any finishing when parts are fully cured—24 to 72 hours @ 75F. An expedited post cure @ 100F for several hours can speed up cycle after 24 hour room temperature cure.

Storage/Shelf Life:

A and B components must be stored in their original, unopened containers at temperatures between 75F and 85F. Shelf life of materials when kept in unopened sealed containers, at the recommended storage conditions, is 6 months. Containers should not be opened until ready for use. Once opened, storage life can be extended with the use of a purging gas—Nitrogen.