

DESCRIPTION: Poly-Optic® 14-Series Casting Resins are two-part, polyurethane systems formulated specifically for applications where optical clarity is required. Castings are clear like water; however, PolyColor dyes can be added to obtain clear, colored castings. Poly-Optic systems, with low viscosities and long pot-lives, provide for easy mixing, excellent detail penetration, and easy degassing, through vacuum or pressure casting techniques, for bubble-free castings.

BEFORE USE: Thoroughly read Safety Data Sheets, product labels and the "SAFETY" section in this Technical Bulletin.

Choose the Poly-Optic® product that's best for your application:

Poly-Optic® 1411 is an easy 1A:1B, by volume, system that cures quickly to a super-strong, hard plastic. 1411 develops hardness and can be demolded more quickly than 1410. It also has a higher heat deflection temperature, which is useful in certain prototyping applications.

Poly-Optic® 1420 cures to a tough, impact- and heat-resistant plastic that can be polished and machined. For strong plastic, heat cure 1420 at 150-180°F. For brittle, glass-like castings, cure at room temperature.

PRODUCT LINE FEATURES

- Crystal clear
- Reproduces fine detail
- Can be machined, drilled and sanded
- Tough and hard, but not brittle
- Long working time
- Low shrinkage upon cure

PHYSICAL PROPERTIES

Product	Poly-Optic® 1411	Poly-Optic® 1420
Mix Ratio by Volume	1A:1B	N/A
Mix Ratio by Weight	100A:90B	2A:1B
Shore Hardness	D80	D85
Pot Life (1-lb mix)	9 min.	15 min.
Demold Time* @ 73°F unless otherwise noted	30 min. (0.5" thick)	8 hr. @ 150°F 30 min. @ 175°F
Cured Color	Water Clear	Water Clear
Mixed Viscosity (cP)	600	250
Specific Volume (in ³ /lb)	25.8	26.3
Specific Gravity	1.07	1.05
Linear Shrinkage (in/in)	0.0018	ND
Elongation (%)	7	5.3
Max Exotherm (°F)	228	311
Heat Deflection Temp. (°F)	138	168
Tensile Strength (psi)	6,083	7,900
Elastic Modulus (psi)	133,956	171,500
Flexural Modulus (psi)	250,992	250,000
Flexural Strength, 5% Strain (psi)	8,478	12,600

MOLD PREPARATION: Poly-Optic products reproduce minute detail from a mold or pattern, but may stick or foam when poured on improperly prepared surfaces; ensure that the surface is moisture-free. Perform a trial casting on a surface similar to the final mold to avoid damaging a valuable mold. Polyethylene and silicone rubber (i.e., PlatSil® 71- and 73-Series) molds, do not require a release agent. [CAUTION: Condensation-cure silicones (i.e., TinSil® 70-Series) are not recommended for casting Poly-Optic since residual alcohol can inhibit cure or produce hazy castings.] Latex, polyurethane or metal molds must be dry and require a coat of a suitable release agent (i.e., Pol-Ease® 2300 Release Agent). For optically clear castings, use highly polished masters to create molds with excellent surface quality.

MIXING: Before mixing resins, be sure that both Parts A and B are at room temperature and that all tools and molds are ready to go! Use metal or plastic mixing vessels (i.e., polyethylene pail) and spatulas to avoid introducing moisture. Shake or stir Part B before use, if required. Carefully weigh or measure proper ratios of A and B into a mixing container. Mix immediately, thoroughly scraping sides and bottom. Vacuum degas mix and pour into the mold as quickly as possible. Using pre-heated molds (i.e., 150°F) reduces shrinkage and improves the surface quality of Poly-Optic parts. Pressure casting helps produce clear castings. A light spray of Pol-Ease 2300 Release Agent or quickly passing the flame of a torch over the back of the casting helps to break bubbles on the back of the pour. To produce bubble-free castings, vacuum degassing and pressure casting is necessary.

Once Part A and B containers are opened, use the product completely or reseal tightly since atmospheric moisture may cause foaming of the plastic. To lengthen shelf life, spray Poly Purge, a heavier-than-air dry gas, into the open containers before resealing. If containers collapse slightly over time, reopen containers and spray more Poly Purge to keep containers from further collapse.

CURING: Allow castings to remain in the mold until thoroughly cured. Parts demolded too soon may be subject to deformation. Use pre-warmed molds to hasten curing, and reduce shrinkage and improve overall quality of the casting. Low temperatures slow the cure and extend demold time.

Poly-Optic 1411 cures at room temperature. For plastic castings less than ¼-inch thick, 1411 is recommended because it can be demolded more quickly in thin sections. For thinner castings, or when using Poly-Optic 1410 for thin parts, add Part 14X Catalyst or heat cure (8 hr at 140-150°F). Castings greater than ½-in thick do not require heat or 14X, but the addition or use of either will speed up the curing process considerably.

Poly-Optic 1420 is demoldable after 30 minutes at 175°F and, if desired, can be post cured for 16 hours at 150°F for optimum physical properties. To produce brittle, glass-like parts and props, cure 1420 at room temperature.

Wash mold release from surfaces prior to painting or bonding.

ACCELERATING CURE SPEED: Poly-Optic® 14 Part X Accelerator can be mixed into Part B prior to adding Part A to accelerate gel and cure times. For castings less than ½-in thick, Part X is recommended. Add 0.5% Part X to the total mix weight to speed the cure significantly. Exotherm (heat of reaction) and thus shrinkage on cooling is also increased. Experiment to determine the best amount of Part X to use, but do not use more than 1% Part X because final physical properties may be affected.

RETARDING CURE SPEED: Poly-Optic® 14 Part R Retarder slows the cure of Poly-Optic systems. Slowing the cure also reduces exothermic heating, which can cause distortion, waviness and shrinkage especially in castings >½-inch thick. For every part of Part R added, an equal part of Part A must be added to the mix. Add 1.5% Part R to the total mix weight of 1410 to increase the pot-life from 15 to 70 minutes. Add 1% Part R to 1411 to double the working time from 9 to 18 minutes. The extended pot-life creates a lower exotherm upon curing, allowing larger castings to be made without distortion. Never use more than 4% Part R since the system may not cure properly.

COLORS: Add PolyColors to 14-Series Part B before mixing with Part A to create clear plastics of any color.

EXTERIOR USES: Although Poly-Optic 1411 and 1420 are non-yellowing formulas however, they are not recommended for long-term exterior use. To improve durability for exterior applications, add 1% Poly UV Additive to the total mix weight of Poly-Optic to reduce the onset of chalking and pitting of the outside surface for ~2 years. Add 3% Poly UV Additive to achieve good exterior stability beyond 5 years.

CLEAN UP: Tools should be wiped clean before the plastic is hard. Denatured ethanol is a good cleaning solvent, but it must be handled with extreme caution owing to its flammability and health hazards. Work surfaces can be waxed or coated with Pol-Ease 2300 Release Agent so cured rubber can be removed.

SAFETY: Before use, thoroughly read Safety Data Sheets and product labels. Follow safety precautions and directions.

Part A: Keep out of reach of children. Avoid breathing fumes, vapors, mists, or spray. Use only outdoors or with adequate general or local exhaust ventilation to minimize exposure levels. If needed, a NIOSH-approved respirator with organic vapor cartridge may be used. If inhaled, remove victim to fresh air and keep at rest in a position comfortable for breathing. If experiencing respiratory irritation, get medical attention. Wear impervious gloves, such as butyl rubber or nitrile rubber. Wash contaminated clothing before reuse. Wash skin thoroughly with soap and water after handling. If skin irritation or rash occurs, get medical attention. Wear eye protection, such as chemical safety glasses/goggles. If in eyes, rinse cautiously with water for several minutes, removing contact lenses if present and easy to do. Store in a well-ventilated place and keep container tightly closed.

Part B: Keep out of reach of children. Do not breathe fumes or vapors. Use with adequate general or local exhaust ventilation to minimize exposure levels. If needed, a NIOSH-approved respirator with organic vapor cartridge may be used. If inhaled, remove victim to fresh air and keep at rest in a position comfortable for breathing. Wear impervious gloves, such as butyl rubber or nitrile rubber. Wash skin thoroughly with soap and water after handling. Wear eye protection, such as chemical safety glasses/goggles. If in eyes, rinse cautiously with water for several minutes, removing contact lenses if present and easy to do. If spilled, avoid release to the environment.

STORAGE LIFE: Poly-Optic liquids can be stored for at least 6 months in unopened containers stored at room temperature. Poly-Optic Part As may crystallize slightly or become viscous during storage. If crystallization occurs warm the container to 100-120°F until crystals dissipate. Cool to room temperature before use.

DISCLAIMER: The information in this bulletin and otherwise provided by Polytek® Development Corp. 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, the user shall determine the suitability of the product for the intended use and user assumes all risk and liability whatsoever in connection therewith.

ACCESSORIES

Accelerator:

Poly 14 Part X Accelerator

Retarder:

Poly 14 Part R Retarder

Sealers & Release Agents:

Pol-Ease® 2300 Release Agent

Pol-Ease® 2500 Release Agent

Product Life Extender:

PolyPurge Aerosol Dry Gas

Colors:

PolyColor Dyes

Black - Brown - Blue - Green - Red

- Yellow - White - Fleshtone

Fillers:

Bronze Powder

UV Stabilizers:

UV Additive

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