



AeroMarine Products, Inc.
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AeroMarine Urethane Elastomer Concrete Molding Rubber

AeroMarine Urethane Elastomer Concrete Molding Rubber is used for making concrete stamps and molds.

****Always wear a respirator or self-contained breathing apparatus when working with urethanes.****

Do NOT spray. Our urethanes are only for pouring applications.

Urethanes are moisture-sensitive. Do not use paper, wax or wood mixing tools. Always re-cap container immediately after pouring product.

Features:

- Room temperature cure
- Low viscosity
- Simple, noncritical 1-1 mix ratio
- Negligible shrinkage

Specifications:

Viscosity:	2000cps
Color:	Black
Work life:	5 minutes@70F
Cure time:	12 hours@70F
Shore Hardness:	75A
Tensile elongation:	150%
Tensile strength:	650psi
Maximum temperature:	105°C
Thermal conductivity	0.16-0.18 watts per meter Kelvin

For industrial or professional use only

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Directions for Use:

Use between 65F and 75F in a humidity-controlled environment. AeroMarine Products Concrete Molding and Stamping Rubber 75A Urethane is moisture sensitive. Use only clean plastic and/or metal mixing utensils and containers. Do not use paper or wood. Re-cap the bottles immediately after use. Extend-It aerosol nitrogen blanket can be used to protect the product from moisture contamination.

Mixing directions: Shake both A and B sides vigorously. Measure out equal parts, by volume, of A and B into clean plastic or metal containers. Combine both sides into a third clean mixing container and mix vigorously for at least one minute, taking care to scrape the sides and bottom of the mixing container with your mixing utensil, until the product is one uniform color.

If you are pouring layers of Concrete Stamping Rubber 75A Urethane, let each layer fully cure before pouring subsequent layers. 75A Urethane bonds very well to itself.

Mold release: You MUST use a mold release when pouring AeroMarine Products' Concrete Molding and Stamping Rubber 75A Urethane against another surface. AeroMarine Products' Mold Release (sold with the half gallon and two gallon kits) is the standard release for this product. When pouring concrete into the mold, you can also use a concrete mold release available at most hardware stores.

Best practices when using urethane elastomers

Never mix less than about 3 ounces of product. When manufacturers design and test their resins, they normally write the specifications for 100 gram batches, which is about 3 ounces.

There are two things that can go wrong when mixing a smaller batch. It is much more difficult to get the correct mix ratio when working with very small amounts. Also, these mixtures are exothermic, meaning they generate heat in order to cure. A mixture of less than three ounces does not generate much heat and can take significantly longer to cure.

Avoid mixing with drill motors. Because of the friction they generate, mixing with electric drills can start the exothermic cure process and cause the product to cure in the mixing container. They can also whip air into the resin causing air bubbles. It is always best to mix the material by hand, with a plastic or metal mixing utensil.

Don't vary the mix ratio. Unlike some polyester resins, altering the mix ratio to vary the cure cycle will not work with urethanes.

Mix in clean plastic containers. Paper cups and wooden mixing utensils may contain moisture which can adversely affect the urethane rubber. Avoid waxed paper cups because the wax may melt and contaminate the resin.

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How to avoid air bubbles- Air bubbles in urethanes are almost always caused by moisture. Do everything possible to avoid moisture getting into the mix. Replace the lids onto the containers promptly after use. Do not use the urethane rubber during rainy days or times of high humidity. Avoid pouring against an unsealed water based product such as plaster or hydrocal. Seal plaster or hydrocal with a product like Krylon Clear Acrylic.

Shelf life- When stored in the original, unopened containers in a cool, dry environment, out of direct sunlight, the shelf life is six months. Once opened, shelf life can be preserved with the use of "Extend-It" aerosol nitrogen blanket.

Avoid mixing a large batch- The larger the batch, the more exotherm or heat is generated in the cure cycle. If you are making a large mold, mix small batches to make the process more manageable.

Shake or stir well before use- The liquid components may settle in the containers during storage. Shake or stir the components separately and thoroughly before mixing. Let it sit a few minutes to let any bubbles rise to the surface after shaking the container.

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