



MAGIKAST 300

Technical Data Sheet

Product Description

Magikast 300 is a rigid, fast setting polyurethane with a 1:1 ratio by volume. Great looking void free parts can be cast with no vacuum or pressure. Excellent physical properties can be obtained with a room temperature cure without the utilization of mercury, MOCA or TDI

Key Features

- Low viscosity
- Fast demold time
- Soft white color

Main Application

- Rotational Casting Applications
- Formulated for hand-batch / vacuum assisted casting equipment
- Applications not requiring high temperature resistance.

CHEMICAL AND PHYSICAL CHARACTERISTICS

Mix Ratio	Resin:Hardener (parts by weight)	100:92
Mix Ratio	Resin:Hardener (parts by volume)	100:100
Viscosity (cps@77°)	Resin	75
	Hardener	450
	Mixed	150
Specific Gravity (g/cc)	Resin	1.16
	Hardener	1.06
Gel Time		5.5 ± 1.5 minutes
Demold Time*		30 ± 5 minutes
Color		White

CURE CHARACTERISTICS

Cured properties are 7 days @ 77°

	Method	Cure
Hardness (shore D)	ASTM D-224	70 ± 5
Tensile strength (psi)	ASTM D-638	4,950
Elongation at break	ASTM D-638	24%
Ultimate flex strength (psi)	ASTM D-790	7,100
Flexural modulus (psi)	ASTM D-790	175,000
Notched Izod (ft.lbs./in.)	ASTM D-638	165,000
Linear shrink (in./in.)	ASTM D-256	0.6
Heat deflection temperature (66psi)	ASTM D-2566	.002-.006
Heat deflection temperature (264psi)	ASTM D-648	72°C / 162°F
Specific gravity (g/cc)	ASTM D-648	65°C / 149°F

MIXING AND DE-AERATION

This product will slightly separate upon storage. For best results, de-air the material prior to casting, then pressurize to 60 psi until cured. **Agitate hardener and resin before mixing to ensure that the formula is homogeneous.**

SHELF-LIFE AND STORAGE

Store containers in a dry location. Partially used containers should be blanketed with dry nitrogen to prevent moisture contamination. Moisture will react with the resin component, creating carbon dioxide gas and a possible pressure increase in the container.

Not for Product Specification

The technical data listed herein is provided as a reference only and **is not** intended as sales specifications. For sales and technical assistance or for product recommendations, please call 800.297.4541

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