

Advanced Materials**RenCast[®] 6434 / Ren[®] 6434 / Ren[®] 6434 Additive**

POLYURETHANE ELASTOMER

A VARIABLE HARDNESS RESILIENT SHORE 10 – 40A ELASTOMER

DESCRIPTION :

RenCast[®] 6434 (Resin) / Ren[®] 6434 (Hardener) / Ren[®] 6434 Additive, the most flexible polyurethane of the Polyurethane line, allows easy stripping of molds from undercuts and complex parts. Low viscosity makes RenCast[®] 6434 easy to handle. Complete cure can be obtained at room temperature.

APPLICATIONS :

- Flexible Molds
- Resilient Parts
- Pads

Note : Contains an ingredient not recommended for applications that might come in contact with human skin.

MIX RATIO :

By weight :	25 to 100	Resin to Hardener
By volume :	25 to 100	Resin to Hardener

Mixing Instructions : Stir each component thoroughly before use. Weigh each component accurately (\pm 5%) into clean containers. Thoroughly mix resin and hardener together (minimum 3 minutes) scraping container sidewalls, bottom and mixing stick several times to assure a uniform mix.

TYPICAL HANDLING PROPERTIES :

Tested @ 77 °F (25 °C) unless otherwise noted.

Property	Criteria	ASTM Test Method	Test Values	
Color	Resin	Visual	Light amber	
	Hardener		Light amber	
	Cured		Light amber	
Specific Gravity	Resin	D-792	1.18	
	Hardener		1.15	
Viscosity, cP	Resin	D-2393	50	
	Hardener		450 – 650	
Gel Time, minutes	150 g	D-2471	14 – 20	
Gel Time and Viscosity Profile	150 g	D-2471	<u>Minute</u>	<u>cP</u>
			5	500

NOTE : These physical properties are reported as typical test values obtained by our test laboratory. If assistance is needed establishing product specifications, please consult with our Quality Control Department.

PROCESSING :**Ren[®] 6434 Additive for Variable Hardness Shore 10 – 40A****Hardness, Shore A**

35 – 40
27 – 31
17 – 21
10 – 14
4 – 8

Parts by Weight

25 to 100 to 0
25 to 100 to 25
25 to 100 to 50
25 to 100 to 75
25 to 100 to 100

Resin to Hardener to Additive
Resin to Hardener to Additive
Resin to Hardener to Additive
Resin to Hardener to Additive
Resin to Hardener to Additive

Mixing Instructions :

Weigh the resin and additive components and blend thoroughly. Add the appropriate amount of hardener by weight and blend for 3 minutes. Carefully scrape container walls and mixing utensils to fully blend all ingredients before use.

DEMOLD TIME :

Temperature	Time	Thickness
77 °F (25 °C)	24 hours	1/8"

RECOMMENDED CURE SHCEDULE :

Temperature	Time
77 °F (25 °C)	7 days

TYPICAL CURE PROPERTIES :

Cured 7 days @ 77 °F (25 °C)

Tested @ 77 °F (25 °C) unless otherwise noted.

Property	ASTM Test Method	Test Value
Hardness (Shore A)	D-2240	35 -40
Ultimate Tensile Strength, psi	D-412	1,100
% Elongation	D-638	500
Tear Strength, ppi	D-624	120

HANDLING :**RenCast® 6434**

This product may crystallize upon storage. If crystallized, vent container and heat to 125 – 145 °F until crystals dissolve. Stir well after product has liquefied.

RenCast® 6434 System

If heating of products in plastic packaging is necessary, heat in a ventilated oven to 145 °F maximum. Before heating loosen the container lid slightly to relieve any pressure buildup and place container to be heated into a metal bucket of sufficient volume to contain the product should the container tip over or leak.

STORAGE :

RenCast® 6434 (Resin) / Ren® 6434 (Hardener) / Ren® 6434 Additive should be stored in a dry place, in the sealed original container, at temperatures between +2°C and +40°C (+35.6°F and 104°F). Under these storage conditions, the shelf life is 1 year. The product should not be exposed to direct sunlight.

PRECAUTIONARY STATEMENT :

Huntsman Advanced Materials Americas LLC maintains up-to-date Material Safety Data Sheets (MSDS) on all of its products. These sheets contain pertinent information that you may need to protect your employees and customers against any known health or safety hazards associated with our products. Users should review the latest MSDS to determine possible health hazards and appropriate precautions to implement prior to using this material.

First Aid!

Refer to MSDS as mentioned above.

KEEP OUT OF REACH OF CHILDREN

FOR PROFESSIONAL AND INDUSTRIAL USE ONLY

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