PRODUCT OVERVIEW

The Smooth-Cast™ 325 EU, 326 EU & 327 EU plastics are phthalate free urethane resins that were developed specifically for adding color pigments and fillers to achieve true color representation or filler effect. The Smooth-Cast™ 325 EU, 326 EU & 327 EU are formulated “color neutral”. Small amounts of pigment will yield accurate, vivid colors from cured castings using So-Strong™, UVO™ or Ignite™ colorants. The Smooth-Cast™ 325 EU, 326 EU & 327 EU offers the convenience of a 1A: 1B mix ratio by volume and has a very low viscosity. Demold times range from about 10 minutes to 2-4 hours (depending on product, mass and mold configuration). Note: Large mass castings will get very hot and shrink more, depending on mold configuration.

The Smooth-Cast™ 325 EU, 326 EU & 327 EU also readily accept fillers (such as URE-FIL™ 3 from Smooth-On). Because of its neutral color, Smooth-Cast™ 325 is ideal for creating marble and wood grain casting effects, or duplicating the look of real metal by adding bronze, brass or other metal powder. Applications for the Smooth-Cast™ 325 EU, 326 EU & 327 EU plastics include making pigmented prototype models or figures, special effect props, reproducing small to medium size sculptures, decorative jewelry, etc.

TECHNICAL OVERVIEW

<table>
<thead>
<tr>
<th>Product</th>
<th>Pot Life</th>
<th>Cure Time</th>
<th>Tensile Strength</th>
<th>Tensile Modulus</th>
<th>Elongation at Break</th>
<th>Flexural Strength</th>
<th>Flexural Modulus</th>
<th>Compressive Strength</th>
<th>Compressive Modulus</th>
<th>Shrinkage in/in.</th>
</tr>
</thead>
<tbody>
<tr>
<td>Smooth-Cast™ 325 EU</td>
<td>2.5 Minutes</td>
<td>10 Minutes</td>
<td>3170 psi</td>
<td>140,000 psi</td>
<td>10%</td>
<td>3,690 psi</td>
<td>101,000 psi</td>
<td>3,500 psi</td>
<td>36,500 psi</td>
<td>0.01</td>
</tr>
<tr>
<td>Smooth-Cast™ 326 EU</td>
<td>7-9 Minutes</td>
<td>60 Minutes</td>
<td>3170 psi</td>
<td>140,000 psi</td>
<td>10%</td>
<td>3,100 psi</td>
<td>95,700 psi</td>
<td>3,080 psi</td>
<td>32,200 psi</td>
<td>0.0075</td>
</tr>
<tr>
<td>Smooth-Cast™ 327 EU</td>
<td>10-20 Min.</td>
<td>2 - 4 Hours</td>
<td>3170 psi</td>
<td>140,000 psi</td>
<td>10%</td>
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</table>

PROCESSING RECOMMENDATIONS

PREPARATION... Safety - Materials should be stored and used in a warm environment (73°F / 23°C). These products have a limited shelf life and should be used as soon as possible. All liquid urethanes are moisture sensitive and will absorb atmospheric moisture. Mixing tools and containers should be clean and made of metal, glass or plastic. Mixing should be done in a well-ventilated area. Wear safety glasses, long sleeves and rubber gloves to minimize contamination risk. Because no two applications are quite the same, a small test application to determine suitability for your project is recommended if performance of this material is in question.

Applying A Release Agent - A release agent is necessary to facilitate demolding when casting into or over most surfaces. Use a release agent made specifically for mold making (Universal™ Mold Release or Mann's Ease Release™ 200 available from Smooth-On or your Smooth-On distributor). A liberal coat of release agent should be applied onto all surfaces that will contact the plastic.

~IMPORTANT: To ensure thorough coverage, apply release and brush with a soft brush over all surfaces. Follow with a light mist coating and let the release agent dry for 30 minutes. Smooth-On silicone rubber molds usually do not require a release agent unless casting silicone into the mold. Applying a release agent will prolong the life of the mold.
**PIGMENTING, MEASURING & MIXING...**

**Pigmenting** - Pre-Mix Pigment Or Fillers With Part B - For consistent results, pigment or fillers should be added by weight each time. Some “test” castings may have to be made until desired affect is achieved. Add desired amount of pigment or filler to Part B and blend thoroughly to a uniform consistency before adding Part A.

**NOTE**: When adding SO-Strong™ RED tint to Smooth-Cast™ 326 EU or 327 EU, the color will darken and change. For a better match when using SO-Strong™ RED, use Smooth-Cast™ 325 EU as your casting resin. This is only an issue with SO-Strong™ RED, all other SO-Strong™ colors will behave normally.

**How Much Pigment or Filler? Pigment Example**: Generally, 0.5% - 1% Smooth-On pigment added by weight of Part B will yield rich, vibrant color. For translucent effect, add 0.1% pigment. **Metal Cold Casting**: Ask for our Technical Bulletin On Metal Cold Casting. Because end-user requirements vary for desired finished effect, we can not offer all pigment or filler loading percentage possibilities. Again, “test” castings may have to be made until desired effect is achieved.

**Measuring & Mixing** - Liquid urethanes are moisture sensitive and will absorb atmospheric moisture. Mixing tools and containers should be clean and made of metal, glass or plastic. Materials should be stored and used in a warm environment (73°F/23°C). **Stir or shake both Part A & Part B thoroughly before dispensing**. After dispensing equal volumes of Parts A and B into mixing container (115A:100B by weight) and mix thoroughly. Stir deliberately making sure that you scrape the sides and bottom of the mixing container several times. Be careful not to splash low viscosity material out of the container.

**Pouring, Curing & Performance...**

**Pouring** - For best results, pour your mixture in a single spot at the lowest point of the containment field and let the mixture seek its level. This will help minimize air entrapment.

**Curing - Important**: Use this product with at least room size ventilation or in proximity to a forced outlet air vent and do not inhale/breathe fumes. Fumes, which may be visible with a significant mass concentration, will quickly dissipate with adequate ventilation. Castings with significant mass will be hot to the touch and irritate skin immediately following cure. Let casting cool to room temperature before handling.

Demold time of the finished casting depends on mass and mold configuration. Low mass or thin-walled castings will take longer to cure than castings with higher mass concentration. Smooth-Cast™ 325 EU will cure in 7-10 minutes, Smooth-Cast™ 326 EU in 60 minutes and Smooth-Cast™ 327 EU in 2-4 hours depending on mass and mold configuration. Castings made with Smooth-Cast™ 325 EU, 326 EU & 327 EU liquid plastics will remain semi-rigid longer that other Smooth-Cast™ resins depending on mass.

**Post Curing** - Castings will reach “full cure” faster and achieve maximum physical properties if post cured. Allow material to cure for recommended cure time at room temperature followed by 4 - 6 hours at 150°F / 65°C. Allow casting to come to room temperature before handling.

**Performance** - Cured castings are rigid and durable. They resist moisture, moderate heat, solvents, dilute acids and can be machined, primed/painted or bonded to other surfaces (any release agent must be removed). If machining cured material, wear dust mask or other apparatus to prevent inhalation of residual particles. Castings can be displayed outdoors after priming and painting. Unpainted castings will yellow over time - more quickly when exposed to ultra-violet light.

Because no two applications are quite the same, a small test application to determine suitability is recommended if performance of this material is in question.