

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.

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

Poly-Optic® 1410 cures to a hard, virtually unbreakable, plastic. Cure 1410 at room temperature and, for optimum physical properties, post cure at 150°F.

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® 1411 ES7 a long pot-life (~7 hr) version of 1411, is used for large pours where extra working time or minimal shrinkage is required. 1411 ES7 Part B can be blended with 1411 Part B to shorten pot-life.

Poly-Optic® 1412 is a high-strength, heat-resistant, fast-curing, rapid-prototyping plastic designed for casting in heated molds.

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.

Poly-Optic® 14-70 is a firm rubber. Blend 1410 and 14-70 to achieve any hardness between Shore D85 and Shore A70.

Poly-Optic® 1490 is a mercury-free formula with an easy 1A:1B mix ratio by volume (100A:90B by weight). Must be pressure cast or used with vacuum casting equipment (not degassing).

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

Low Viscosity, Polyurethane Casting Resins — Clear Like Water

Why Choose Poly-Optic Series Plastics?

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

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 1410, 1411, 14-70 and 1490 cure at room temperature. For plastic

PHYSICAL PROPERTIES

Poly-Optic® Product	1410	1411	1411 ES7	1412	1420	14-70	1490^
Mix Ratio	3A:2B by weight	1A:B by volume	100A:90B by weight 1A:B by volume	1A:1B by weight or volume	2A:1B by weight	4A:5B by weight	100A:90B by weight 1A:B by volume
Shore Hardness	D80	D80	D80	D80	D85	A70	D80
Pot Life (min) (2 lb mix)	15	9	420	8	15	15	9
Demold Time (hr)*	2 (1" thick)	0.5 (0.5" thick)	48-96	0.5 @175°F	8 @ 150°F 0.5 @ 175°F	24-48	1
Specific Gravity	1.07	1.07	1.07	1.07	1.05	1.06	1.07
Initial Mixed Viscosity (cP)	700	600	600	750	250	340	690
Specific Volume (in ³ /lb)	25.8	25.8	25.8	25.8	26.3	26.1	25.8
Maximum Exotherm (°F) (1-lb mass)	265	228	100	235	311	190	235

*Demold time varies with thickness of casting and the amount of accelerator used. ^Poly-Optic 1490 must be pressure cast or used with vacuum casting equipment (not degassing).

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 1412 and 1420 are 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 (e.g. 0.5g Part X in a 100g mix of 1410 halves the pour and cure time). 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. Depending on the size and mass of the part, post curing 14-70 and 1410 parts in the mold at >140°F for 12 to 16 hours may be necessary. 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. For larger castings, consider Poly-Optic 1411 ES7 with a 7-hour pot-life and low exotherm.

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 1410, 1411, 1411 ES7, 1412, 1420 and 1490 are non-yellowing formulas, 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, read product labels and Safety Data Sheets. Follow safety

precautions and directions. Contact with uncured products may cause eye, skin and respiratory irritation and dermal and/or respiratory sensitization. Avoid contact with skin and eyes. If skin contact occurs, remove with waterless hand cleaner or alcohol then soap and water. In case of eye contact, flush with water for 15 minutes and call physician. Use only with adequate ventilation. Poly-Optic plastics are not to be used where food or body contact may occur. Poly-Optic plastics burn readily when ignited. Care should be taken with sanding dust and other easily ignitable forms of these products.

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® 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 - 1 oz, 1 lb, 8 lb, 40 lb

Retarder

Poly 14 Part R Retarder - 1 oz, 1 lb, 8 lb, 40 lb

Sealers & Release Agents

Pol-Ease® 2300 Release Agent - 12-oz can, case of 12
 Pol-Ease® 2500 Release Agent - 12-oz can, case of 12

Product Life Extender

PolyPurge Aerosol Dry Gas - 10-oz can, case of 12

Colors

PolyColor Dyes - 0.25 lb, 1 lb, 8 lb
 Black - Brown - Blue - Green - Red - Yellow - White - Fleshtone

Fillers

Bronze Powder - 2 lb, 10 lb, 110 lb

UV Additive - 0.25 lb, 1 lb

PACKAGING

Product(s)	Kit Size (lb)	Part A		Part B	
		Weight (lb)	Volume*	Weight (lb)	Volume*
Poly-Optic® 1410	10.0	3.0	3 qt	4.0	2 qt
	60	36	5 gal	24	3 gal
Poly-Optic® 1411, 1411 ES7*, 1490 *1411 ES7 is only available in 76-lb kits.	3.8	2.0	1 qt	1.8	1 qt
	15.2	8.0	1 gal	7.2	1 gal
	76	40	5 gal	36	5 gal
Poly-Optic® 1412	4.5	2.25	1 qt	2.25	1 qt
	18.0	9.0	1 gal	9.0	1 gal
	90	45	5 gal	45	5 gal
Poly-Optic® 1420	6.0	4.0	2 qt	2.0	1 qt
	24.0	16.0	2 gal	8 gal	1 gal
	120	80	10 gal	40	5 gal
Poly-Optic® 14-70	14.4	16.4	3 qt	8.0	1 gal
	72.0	32	5 gal	40	5 gal

*Volume measurements are approximate.