

Replicator 400

Filled Casting Urethane

Product Description:

Alumilite's Replicator 400 provides users with an excellent general purpose filled urethane casting system that is extremely user friendly. The Replicator 400 is great for nests, fixtures, vacuum form tools, and thermo form tooling. The Replicator 400 is easy to use and has a mix ratio of 1:1 by weight. The fillers do settle over time and need to be agitated prior to measuring. Once mixed, poured, and cured, the Replicator 400 gives you an incredibly tough tooling resin that is great for a wide variety of industrial applications. The material features a 6-8-minute work time with a demold time that ranges from 2-3 hours depending on the mass of the material being cast. The cured cast pieces can be easily machined and polished. The Replicator 400 contains no solvents which make it a great choice when pouring against polystyrene. The material also features minimal shrink and is fire retardant.

Physical Properties:

Color	Gray
Mixed Viscosity (cps)	1,800
Hardness, (ASTM D-2240) Shore D	80
Specific Gravity	1.65
Shrinkage (in/in)	.0007
Tensile Strength (ASTM D-638) (psi)	4,200
Elongation (in/in)	<2%
Heat Deflection (ASTM D-648) (Degrees F)	200
Compression (psi)	9,000

General Properties:

Color	"A" Side	Brown
	"B" Side	Green
Mix Ratio		1:1 by wt.
Shelf Life		6 months
Work Time at 75 Degrees F (100g mass)		6-8 minutes
Demold Time at 75 Degrees F (100g mass)		2-3 hours
Full Cure Schedule		72 hours

Packaging:	Quart Kit	2.5 lbs A/2.5 lbs B
	Gallon Kit	10 lbs A/10 lbs B
	5 Gallon Kit	50 lbs A/50 lbs of B