

***** Hei-Cast 8421 *****

1. Description

Hei-Cast 8421 is a urethane gel with the following characteristics.

- (1) A gel with low hardness and high elongation can be formed.
- (2) It contains no plasticizer.
- (3) The resin layer is excellent in transparency and resistant to yellowing.
- (4) The hardness can be changed by changing the mixing ratio (A:B=100:19 to 30).

2. Basic characteristic

Parameter		Values	Remark
Appearance	A Comp	Clear liquid	Polyols
	B Comp	Clear liquid	Isocyanates
Product color		Transparent	
Viscosity (mPa · s, 25°C)	A Comp	800	BM viscometer
	B Comp	2000	
Specific gravity (25°C)	A Comp	1.02	Standard gravimeter
	B Comp	1.07	
Mixed ratio	A:B	100:19-30	By weight
Pot life	25°C	20 min.	Resin 100 g
Demolding time	60°C	30 min.	Resin 100 g

3. Basic property

Mixed ratio	A:B	100:20	100:22	100:24
Hardness	Type A	0	0	3
	Type C	0	7	18
	Cone	37	21	-
Tensile strength	MPa	0.15	0.22	0.29
Elongation	%	820	600	470
100% modulus	MPa	0.02	0.06	0.12
200% modulus	MPa	0.03	0.09	0.20
300% modulus	MPa	0.04	0.12	0.25
Tear strength	N/mm	0.66	1.2	2.0
Product density	g/cm ³	1.04	1.04	1.04

Mixed ratio	A:B	100:26	100:28	100:30
Hardness	Type A	10	15	24
	Type C	31	-	-
Tensile strength	MPa	0.46	0.56	0.61
Elongation	%	240	190	140
100% modulus	MPa	0.27	0.39	0.54
200% modulus	MPa	0.43	-	-
Tear strength	N/mm	2.1	2.4	3.2
Product density	g/cm ³	1.04	1.05	1.05

NOTE) Test piece curing conditions: mold temperature 60°C × 60 min. × 60°C × 24 hrs × 25°C × 24 hrs

Mechanical properties: Tensile test according to JIS K-7312: Use of No.2 dumbbells

This physical property value is a representative value of our measurement and is not a standard value or a guaranteed value.

The physical properties of the product differ depending on the shape and molding conditions. Use the product after thoroughly checking the product.

4. Change in Hardness with Time [Storage at 25°C]

Mixed ratio (A:B)		Day 1	2 days	One week	2 weeks	4 weeks	6 weeks	8 weeks
100:19	Type A	0	0	0	0	0	0	0
	Type C	0	0	0	0	0	0	0
	Cone penetration	61	61	61	60	60	60	60
100:20	Type A	0	0	0	0	0	0	0
	Type C	0	0	0	0	0	0	0
	Cone penetration	38	38	37	37	37	37	37
100:21	Type A	0	0	0	0	0	0	0
	Type C	3	3	3	3	3	3	3
	Cone penetration	29	28	28	28	28	28	28
100:22	Type A	0	0	0	0	0	0	0
	Type C	7	7	7	7	7	7	7
	Cone penetration	21	21	21	21	21	21	21
100:23	Type A	0	0	0	0	0	0	0
	Type C	12	12	12	12	12	12	12
100:24	Type A	3	3	3	3	3	3	3
	Type C	18	18	18	18	18	18	18
100:25	Type A	6	7	7	7	7	7	8
	Type C	27	27	27	27	27	27	27
100:26	Type A	10	10	10	10	10	10	10
	Type C	31	31	31	31	31	31	31
100:27	Type A	12	12	12	12	12	12	14
	Type C	-	-	-	-	-	-	-
100:28	Type A	15	15	15	15	15	15	16
	Type C	-	-	-	-	-	-	-
100:29	Type A	20	20	20	20	20	20	21
	Type C	-	-	-	-	-	-	-
100:30	Type A	24	24	24	24	24	24	24
	Type C	-	-	-	-	-	-	-

Mixed ratio (A:B)		12 weeks	16 weeks	20 weeks	1 year and 8 months
100:19	Type A	0	0	0	0
	Type C	0	0	0	0
	Cone penetration	60	59	59	56
100:20	Type A	0	0	0	0
	Type C	0	0	0	0
	Cone penetration	37	37	37	34
100:21	Type A	0	0	0	0
	Type C	3	3	3	3
	Cone penetration	28	27	27	25
100:22	Type A	0	0	0	0
	Type C	7	7	7	7
	Cone penetration	21	21	20	18
100:23	Type A	0	0	0	0
	Type C	12	12	12	12
100:24	Type A	3	3	3	3
	Type C	18	18	18	18
100:25	Type A	8	8	8	8
	Type C	27	27	27	27
100:26	Type A	10	11	11	11
	Type C	31	31	31	31
100:27	Type A	14	15	15	15
	Type C	-	-	-	-
100:28	Type A	17	17	17	17
	Type C	-	-	-	-
100:29	Type A	22	22	23	23
	Type C	-	-	-	-
100:30	Type A	25	26	26	26
	Type C	-	-	-	-

NOTE) Curing conditions: Mold temperature 60°C 60°C × 60 minutes + 25°C × days

5. Endurance test

5.1 Chemical resistance

Chemical	Mixed ratio A:B	Gloss loss	Discoloring	Cracking	Warp	Swelling	Decomposition	Dissolution
Ion-exchanged water [Immersion at room temperature for 24 hours]	100:19	○	△※1	○	○	×	○	○
	100:20	○	△※1	○	○	×	○	○
	100:25	○	○	○	○	△	○	○
	100:30	○	○	○	○	○	○	○
Ion-exchanged water [Immersion at room temperature for 7 days]	100:19	○	×※1	○	○	×	○	○
	100:20	○	×※1	○	○	×	○	○
	100:25	○	△※1	○	○	×	○	○
	100:30	○	○	○	○	△	○	○
10% sulfuric acid [Immersion at room temperature for 24 hours]	100:19	○	×※1	○	○	△	○	○
	100:20	○	×※1	○	○	△	○	○
	100:25	○	○	○	○	○	○	○
	100:30	○	○	○	○	○	○	○
10% hydrochloric acid [Immersion at room temperature for 24 hours]	100:19	○	△※1	○	○	×	○	○
	100:20	○	△※1	○	○	×	○	○
	100:25	○	○	○	○	×	○	○
	100:30	○	○	○	○	△	○	○
10% sodium hydroxide [Immersion at room temperature for 24 hours]	100:19	○	○	○	○	○	○	○
	100:20	○	○	○	○	○	○	○
	100:25	○	○	○	○	○	○	○
	100:30	○	○	○	○	○	○	○
10% aqueous ammonia [Immersion at room temperature for 24 hours]	100:19	○	△※1	○	○	○	○	○
	100:20	○	△※1	○	○	○	○	○
	100:25	○	○	○	○	○	○	○
	100:30	○	○	○	○	○	○	○
Acetone [Immersion at room temperature for 15 minutes]	100:19	○	○	○	×	×	○	○
	100:20	○	○	○	×	×	○	○
	100:25	○	○	○	×	×	○	○
	100:30	○	○	○	△	×	○	○
Ethanol [Immersion at room temperature for 24 hours]	100:19	○	○	○	○	×	○	○
	100:20	○	○	○	○	×	○	○
	100:25	○	○	○	○	×	○	○
	100:30	○	○	○	○	×	○	○
Ethyl acetate [Immersion at room temperature for 15 minutes]	100:19	○	○	○	×	×	○	○
	100:20	○	○	○	×	×	○	○
	100:25	○	○	○	×	×	○	○
	100:30	○	○	○	×	×	○	○

Chemical	Mixed ratio A:B	Gloss loss	Discoloring	Cracking	Warp	Swelling	Decomposition	Dissolution
Toluene [Immersion at room temperature for 24 hours]	100:19	○	○	○	○	×	○	○
	100:20	○	○	○	○	×	○	○
	100:25	○	○	○	○	×	○	○
	100:30	○	○	○	○	×	○	○
Methylene chloride [Immersion at room temperature for 15 minutes]	100:19	○	○	○	×	×	○	○
	100:20	○	○	○	×	×	○	○
	100:25	○	○	○	×	×	○	○
	100:30	○	○	○	×	×	○	○
Gasoline [Immersion at room temperature for 24 hours]	100:19	○	×	○	○	×	○	○
	100:20	○	×	○	○	×	○	○
	100:25	○	×	○	○	×	○	○
	100:30	○	×	○	○	×	○	○
Engine oil [Immersion at room temperature for 24 hours]	100:19	○	○	○	○	○	○	○
	100:20	○	○	○	○	○	○	○
	100:25	○	○	○	○	○	○	○
	100:30	○	○	○	○	○	○	○

NOTE) Good: Good: Slight: Poor X: Poor *1 White turbidity immediately after immersion, but returns to clear when dry

5.2 Weather Resistance [Allowed at Window]

Mixed ratio		Blank	One week	2 weeks	3 weeks	4 weeks	6 weeks
100:19	Type A	0	0	0	0	0	0
	Type C	0	0	0	0	0	0
	Cone penetration	61	60	60	60	60	60
	Changes in the appearance	-	No change	No change	No change	No change	No change
100:20	Type A	0	0	0	0	0	0
	Type C	0	0	0	0	0	0
	Cone penetration	38	38	37	37	37	37
	Changes in the appearance	-	No change	No change	No change	No change	No change
100:25	Type A	6	6	6	6	6	6
	Type C	27	25	25	25	25	25
	Cone penetration	-	-	-	-	-	-
	Changes in the appearance	-	No change	No change	No change	No change	No change
100:30	Type A	24	24	24	24	24	24
	Type C	-	-	-	-	-	-
	Cone penetration	-	-	-	-	-	-
	Changes in the appearance	-	No change	No change	No change	No change	No change

Mixed ratio		8 weeks	12 weeks	16 weeks	20 weeks	1 year and 8 months
100:19	Type A	0	0	0	0	0
	Type C	0	0	0	0	0
	Cone penetration	60	60	60	59	58
	Changes in the appearance	No change	No change	No change	No change	No change
100:20	Type A	0	0	0	0	0
	Type C	0	0	0	0	0
	Cone penetration	37	37	37	36	35
	Changes in the appearance	No change	No change	No change	No change	No change
100:25	Type A	6	6	7	7	7
	Type C	25	25	25	25	24
	Cone penetration	-	-	-	-	-
	Changes in the appearance	No change	No change	No change	No change	No change
100:30	Type A	25	25	25	25	25
	Type C	-	-	-	-	-
	Cone penetration	-	-	-	-	-
	Changes in the appearance	No change	No change	No change	No change	No change

5.3 Heat resistance [Allow to stand in a constant temperature bath with 40°C hot air circulation]

Mixed ratio		Blank	One week	2 weeks	3 weeks	4 weeks	6 weeks
100:19	Type A	0	0	0	0	0	0
	Type C	0	0	0	0	0	0
	Cone penetration	61	60	59	58	58	58
	Changes in the appearance	-	No change	No change	No change	No change	No change
100:20	Type A	0	0	0	0	0	0
	Type C	0	0	0	0	0	0
	Cone penetration	38	37	37	36	36	36
	Changes in the appearance	-	No change	No change	No change	No change	No change
100:25	Type A	6	6	6	6	7	7
	Type C	27	26	26	26	26	25
	Cone penetration	-	-	-	-	-	-
	Changes in the appearance	-	No change	No change	No change	No change	No change
100:30	Type A	24	25	25	25	26	27
	Type C	-	-	-	-	-	-
	Cone penetration	-	-	-	-	-	-
	Changes in the appearance	-	No change	No change	No change	No change	No change

Mixed ratio		8 weeks	12 weeks	16 weeks	20 weeks	1 year and 8 months
100:19	Type A	0	0	0	0	0
	Type C	0	0	0	0	0
	Cone penetration	58	57	57	56	55
	Changes in the appearance	No change	No change	No change	No change	Slight yellowing
100:20	Type A	0	0	0	0	0
	Type C	0	0	0	0	0
	Cone penetration	36	36	36	35	33
	Changes in the appearance	No change	No change	No change	No change	Slight yellowing
100:25	Type A	7	7	7	7	7
	Type C	25	25	25	25	25
	Cone penetration	-	-	-	-	-
	Changes in the appearance	No change	No change	No change	No change	Slight yellowing
100:30	Type A	28	28	28	28	28
	Type C	-	-	-	-	-
	Cone penetration	-	-	-	-	-
	Changes in the appearance	No change	No change	No change	No change	Slight yellowing

5.4 Heat Resistance [Allow to stand in a 60°C hot air circulating thermostatic oven]

Mixed ratio		Blank	One week	2 weeks	3 weeks	4 weeks	6 weeks
100:19	Type A	0	0	0	0	0	0
	Type C	0	0	0	0	0	0
	Cone penetration	61	57	56	56	56	56
	Changes in the appearance	-	No change	No change	Slight yellowing	Slight yellowing	Slight yellowing
100:20	Type A	0	0	0	0	0	0
	Type C	0	0	0	0	0	0
	Cone penetration	38	36	35	35	35	35
	Changes in the appearance	-	No change	No change	Slight yellowing	Slight yellowing	Slight yellowing
100:25	Type A	6	6	6	6	6	7
	Type C	27	25	25	25	25	25
	Cone penetration	-	-	-	-	-	-
	Changes in the appearance	-	No change	No change	Slight yellowing	Slight yellowing	Slight yellowing
100:30	Type A	24	25	25	25	26	27
	Type C	-	-	-	-	-	-
	Cone penetration	-	-	-	-	-	-
	Changes in the appearance	-	No change	No change	Slight yellowing	Slight yellowing	Slight yellowing

Mixed ratio		8 weeks	12 weeks	16 weeks	20 weeks	1 year and 8 months
100:19	Type A	0	0	0	0	0
	Type C	0	0	0	0	0
	Cone penetration	56	56	53	52	47
	Changes in the appearance	Slight yellowing	Slightly yellowing	Slightly yellowing	Slightly yellowing	Yellowing
100:20	Type A	0	0	0	0	0
	Type C	0	0	0	0	0
	Cone penetration	35	35	34	33	29
	Changes in the appearance	Slight yellowing	Slightly yellowing	Slightly yellowing	Slightly yellowing	Yellowing
100:25	Type A	7	7	8	8	8
	Type C	25	25	25	25	25
	Cone penetration	-	-	-	-	-
	Changes in the appearance	Slight yellowing	Slightly yellowing	Slightly yellowing	Slightly yellowing	Yellowing
100:30	Type A	28	28	29	29	29
	Type C	-	-	-	-	-
	Cone penetration	-	-	-	-	-
	Changes in the appearance	Slight yellowing	Slightly yellowing	Slightly yellowing	Slightly yellowing	Yellowing

5.5 Heat Resistance [Allow to stand in a thermostatic oven with 80°C hot air circulation]

Mixed ratio		Blank	One week	2 weeks	3 weeks	4 weeks	6 weeks
100:19	Type A	0	0	0	0	0	0
	Type C	0	0	0	0	0	0
	Cone penetration	61	57	56	55	54	52
	Changes in the appearance	-	Slight yellowing	Slight yellowing	Slightly yellowing	Slightly yellowing	Yellowing
100:20	Type A	0	0	0	0	0	0
	Type C	0	0	0	0	0	0
	Cone penetration	38	36	36	34	34	34
	Changes in the appearance	-	Slight yellowing	Slight yellowing	Slightly yellowing	Slightly yellowing	Yellowing
100:25	Type A	6	6	7	7	7	7
	Type C	27	27	28	28	28	28
	Cone penetration	-	-	-	-	-	-
	Changes in the appearance	-	Slight yellowing	Slight yellowing	Slightly yellowing	Slightly yellowing	Yellowing
100:30	Type A	24	25	25	25	25	26
	Type C	-	-	-	-	-	-
	Cone penetration	-	-	-	-	-	-
	Changes in the appearance	-	Slight yellowing	Slight yellowing	Slightly yellowing	Slightly yellowing	Yellowing

Mixed ratio		8 weeks	12 weeks	16 weeks	20 weeks	1 year and 8 months
100:19	Type A	0	0	0	0	0
	Type C	0	0	0	0	0
	Cone penetration	51	50	49	48	51
	Changes in the appearance	Yellowing	Yellowing	Yellowing	Yellowing	Marked yellowing
100:20	Type A	0	0	0	0	0
	Type C	0	0	0	0	0
	Cone penetration	33	33	32	31	33
	Changes in the appearance	Yellowing	Yellowing	Yellowing	Yellowing	Marked yellowing
100:25	Type A	8	8	9	9	7
	Type C	27	27	27	27	24
	Cone penetration	-	-	-	-	-
	Changes in the appearance	Yellowing	Yellowing	Yellowing	Yellowing	Marked yellowing
100:30	Type A	27	27	28	28	25
	Type C	-	-	-	-	-
	Cone penetration	-	-	-	-	-
	Changes in the appearance	Yellowing	Yellowing	Yellowing	Yellowing	Marked yellowing

5.6 Heat and humidity resistance [85°C 85% RH constant humidity and constant temp. oven left]

Mixed ratio		Blank	One week	2 weeks	3 weeks	4 weeks	6 weeks
100:19	Type A	0	0	0	0	0	0
	Type C	0	0	0	0	0	0
	Cone penetration	61	63	63	63	64	65
	Changes in the appearance	-	Slightly yellowing	Yellowing	Yellowing	Marked yellowing	Marked yellowing
100:20	Type A	0	0	0	0	0	0
	Type C	0	0	0	0	0	0
	Cone penetration	38	39	39	39	39	39
	Changes in the appearance	-	Slightly yellowing	Yellowing	Yellowing	Marked yellowing	Marked yellowing
100:25	Type A	6	6	6	6	6	6
	Type C	27	25	25	25	25	25
	Cone penetration	-	-	-	-	-	-
	Changes in the appearance	-	Slightly yellowing	Yellowing	Yellowing	Marked yellowing	Marked yellowing
100:30	Type A	24	25	25	25	25	26
	Type C	-	-	-	-	-	-
	Cone penetration	-	-	-	-	-	-
	Changes in the appearance	-	Slightly yellowing	Yellowing	Yellowing	Marked yellowing	Marked yellowing

Mixed ratio		8 weeks	12 weeks	16 weeks
100:19	Type A	0	0	0
	Type C	0	0	0
	Cone penetration	68	71	71
	Changes in the appearance	Marked yellowing	Marked yellowing	Marked yellowing
100:20	Type A	0	0	0
	Type C	0	0	0
	Cone penetration	40	41	42
	Changes in the appearance	Marked yellowing	Marked yellowing	Marked yellowing
100:25	Type A	6	6	6
	Type C	24	23	23
	Cone penetration	-	-	-
	Changes in the appearance	Marked yellowing	Marked yellowing	Marked yellowing
100:30	Type A	26	26	26
	Type C	-	-	-
	Cone penetration	-	-	-
	Changes in the appearance	Marked yellowing	Marked yellowing	Marked yellowing

NOTE) JIS K2220 1/4 cone use

(The hardness of a soft material is measured by a method in which the larger the number, the softer the hardness.)

Since the Blank values were reexamined in a series of tests, there are some differences between the basic physical properties and the values.

6. Casting method

6.1 Atmospheric pressure casting method

(1) Preliminary degassing

Preliminary degassing should be performed in the vacuum degassing chamber for 5 to 10 minutes for both solution A and solution B as required.

Separate and defoam as much as is used.

(2) Resin temperature

Keep solution A between 20°C and 40°C and solution B between 20°C and 50°C.

When the liquid temperature is high, the service life is shorter, and when the liquid temperature is low, the service life is longer.

If the liquid temperature is extremely low, mixing failure or curing failure may occur.

(3) Injection container, silicone type

Dry the injection container and silicone type in advance.

When moisture is high, many bubbles are generated in the cured material.

Keep the temperature of the silicone mold between 60°C and 70°C beforehand.

If the temperature of the silicone type is extremely low, curing failure may occur, resulting in deterioration of physical properties.

The mold temperature affects the dimensions of the product and should be carefully controlled.

When poured into an additional type of silicone rubber, the surface in contact with the silicone mold does not cure completely, leaving a solid surface.

(4) Measuring

The mixing ratio is A:B= 100:19 to 30.

Measure the required amounts of solution A and solution B in the same container with the weighing error within $\pm 1\%$.

If the mixing ratio is different, not only the specified physical properties cannot be obtained, but also poor curing may occur.

(5) Mixture

Stir and mix the two liquids with a stirrer for 60 seconds.

Be careful not to mix the bottom or wall of the container.

Insufficient mixing may cause the cured product to stick or cause poor curing.

(6) Defoaming

Defoaming should be performed in a vacuum defoaming chamber as necessary.

(7) Casting

Immediately inject the product into the injection container, silicone type, etc.

(8) Defoaming

Defoaming should be performed in a vacuum defoaming chamber as necessary.

(9) Curing condition

Curing at 25°C may cause poor curing.

Place the watch in a thermostatic oven at 60°C to 70°C for 30 to 60 minutes to cure. If the temperature of the silicone mold or the liquid temperature of the resin is low or the cured product is small, it may take longer to cure the product.

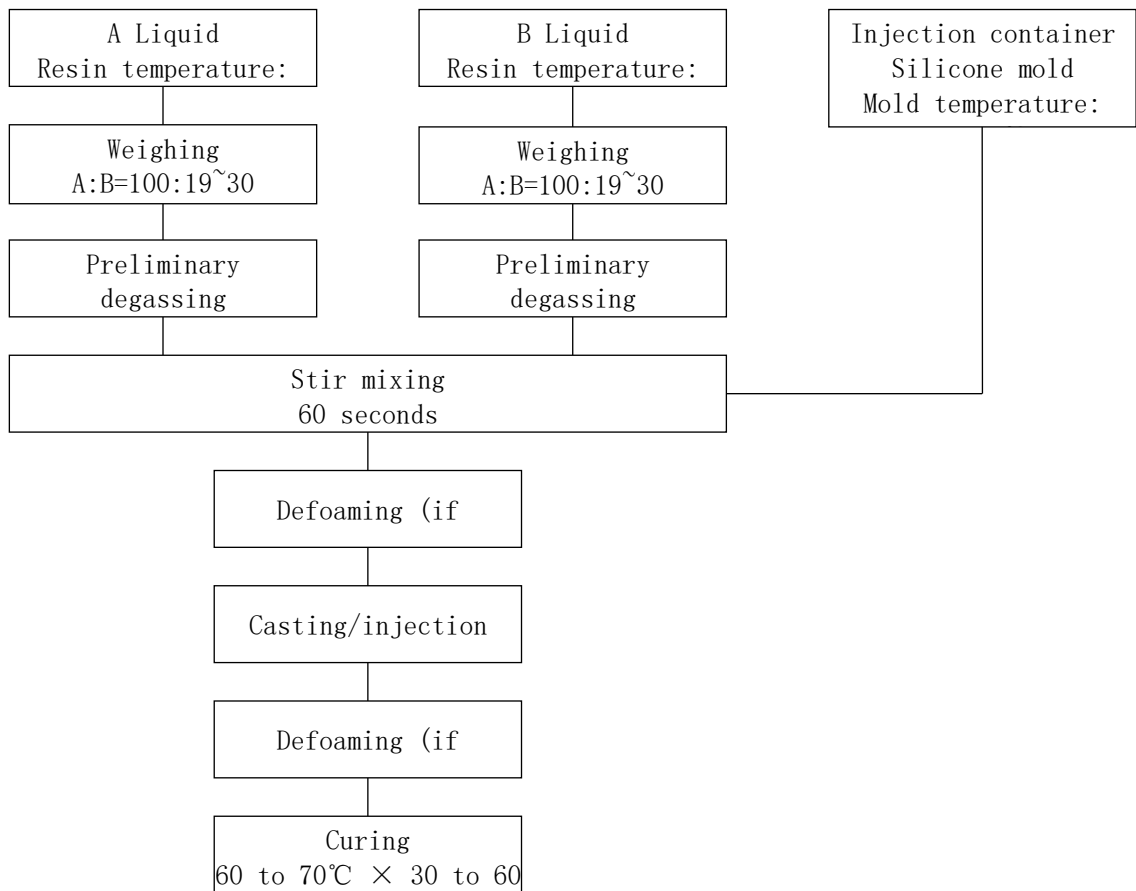
(10) Vacuum casting system

By stirring solution A and solution B in a vacuum, it is possible to cast a product without entrained bubbles. Contact your sales representative for details.

(11) Automatic discharge machine

Mass production is possible by using a two-liquid mixing and discharging machine that automates metering, stirring, and washing of liquid A and liquid B. Contact your sales representative for details.

6.2 Normal Pressure Casting Flow Chart



6.3 Vacuum casting method

(1) Preliminary degassing

Preliminary degassing should be performed in the degassing room for 5 to 10 minutes. Separate and defoam as much as is used.

(2) Resin temperature

Keep solution A between 20°C and 40°C and solution B between 20°C and 50°C. When the liquid temperature is high, the service life is shorter, and when the liquid temperature is low, the service life is longer. If the liquid temperature is extremely low, mixing failure or curing failure may occur.

(3) Mold temperature

Keep the temperature of the silicone mold between 60°C and 70°C beforehand. If the mold temperature is low, curing failure may occur, resulting in deterioration of physical properties. The mold temperature affects the dimensions of the product and should be carefully controlled. When poured into an additional type of silicone rubber, the surface in contact with the silicone mold does not cure completely, leaving a solid surface.

(4) Measuring

The mixing ratio is A:B= 100:19 to 30. Take the required amounts of solution A and

solution B into the container with a weighing error of $\pm 1\%$. If the mixing ratio is different, not only the specified physical properties cannot be obtained, but also poor curing may occur.

(5) Casting

Set the container so that solution A is added to solution B.

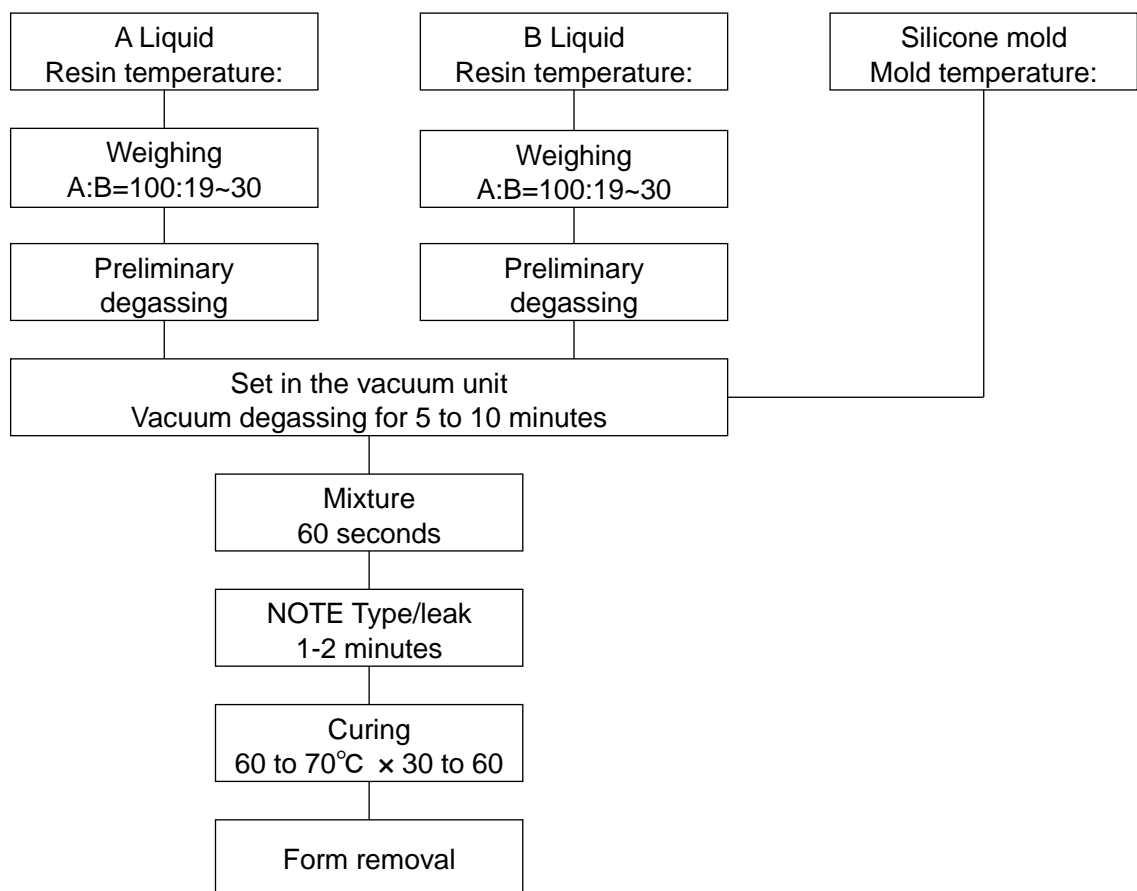
After evacuating the work chamber, defoam it for 5 to 10 minutes.

Add solution A to solution B, stir for 60 seconds, immediately inject into the silicone mold, and leak.

(6) Curing condition

Place it in a thermostatic oven at 60 to 70°C for 30 to 60 minutes to cure and remove the mold.

6.4 Vacuum Casting Flow Chart



7. Precautions for handling

- (1) Do not mix or contact with moisture for a long time. Be sure to seal after use, since both fluid A and fluid B do not contain moisture.
- (2) If moisture is mixed into the liquid A, a lot of air bubbles will be generated in the cured product.
- (3) Liquid B may react with moisture and become cloudy or hardened. Do not use the product that is extremely transparent or hardened because it may cause deterioration in physical properties.
- (4) Continued heating of solution B at 50°C or higher for a long time may cause deterioration and swelling of the can due to internal pressure.
- (5) Coloring with dyes, pigments, etc. is possible, but depending on the type, it may affect the cured product.
- (6) When poured into an additional type of silicone rubber, the surface in contact with the silicone mold does not cure completely, leaving a solid surface.

8. Safety and Health Precautions

- (1) Solution B is an isocyanate component. Install a local exhaust ventilation system in the workshop and take care of ventilation.
- (2) Be careful not to touch the hands or skin directly with the raw material. If the raw material comes into contact, wash it off immediately with soapy water. If the watch is left in contact with the watch for a long time, it may become fogged.
- (3) If the raw material comes into the eyes, flush the eyes immediately with running water for 15 minutes and consult an ophthalmologist.
- (4) Be sure to install a duct so that the vacuum pump is exhausted to the outside.

9. Classification of Dangerous Goods under the Fire Defense Law

Liquid A Hazardous Substances Class 4 Petroleum Class 4

Liquid B: Hazardous Substances Class 4 Petroleum Class 4

10. Coloring of Gel Raw Materials

The use of liquid toner for coloring the gel raw material may result in color transfer to the coating film (coating agent W1830, W2030) in contact with the gel cured product. It is recommended to use a paste for coloring the gel raw material.

11. Preparation of condensation type silicone type

In condensation-type silicone, alcohol and the like are generated at the time of curing. If 8421 is cast into a newly manufactured mold, 8421 tends to cause poor curing at the contact surface with the mold.

Recommended curing conditions for silicone type

Cure at room temperature for 12 to 24 hours → Remove the master model → After-cure at 60°C to 120°C for 12 to 24 hours → Cast 8421 at 60°C to 70°C

- (1) After the master model is demolded, after-cure hardens the cure failure. If 8421 is cast immediately after the master model is demolded, or if 8421 is cast after the

master model is left at room temperature for 24 hours after demolding, it is likely that 8421 will harden at the contact surface with the mold.

- (2) Adjust the after-cure conditions according to the type of silicone and the size and shape of the mold.
- (3) If the mold is split, after-cure the mold with the mold open.

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