



## Product Data

# RenCast™ 6494/Ren® 6494 Flexible Polyurethane System

**DESCRIPTION:** RenCast™ 6494 (Resin)/Ren® 6494 (Hardener), a non-mercury, flexible polyurethane system. This product is a new development in the family of RenCast fast polyurethanes, having been specifically formulated with the desirable combination of long work time (gel time) and short demolding time. RenCast 6494 is designed to produce rubber-like parts with flexibility and hardness of 40-50 Shore A.

### APPLICATIONS:

- Handcasting
- Vacuum Casting
- Pressure Pot Casting

### ADVANTAGES:

- Contains no mercury catalyst
- Convenient mix ratio
- Can be used in a broad range of processes
- Neutral color makes this system easily pigmentable

**MIXING INSTRUCTIONS:** Reaction Ratio 50R to 100H by weight  
47R to 100H by volume

### TYPICAL MIXED PROPERTIES:

Color	Light Amber
Reaction Ratio, by weight	50R/100H
Mixed Viscosity, cp	2200 cps @ 3 min
Gel Time 150 gm mass	5 - 6 min
Demold Time (depending upon part thickness and geometry)	4 hours @ RT 2 hrs @ 140F

### TYPICAL CURED PROPERTIES:

Cured Color	Light Amber
Hardness	45 (+/- 5) Shore A
Tensile Strength	385 psi
% Elongation at Break	410%
Tear Strength	85 ppi

**STORAGE/HANDLING INFORMATION:** Store at 70° - 90°F. This product is moisture sensitive and packaged under a blanket of dry nitrogen. Maintain factory seal. After use reblanket with nitrogen and tightly reseal. 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. 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. Work in a well ventilated area and use clean, dry tools for mixing and applying.

Combine the resin and hardener according to mix ratio, mix together thoroughly and use immediately after mixing. Material temperature should not be below 65°F (18°C) when mixing.

**SHELF LIFE:** Provided materials are stored under the recommended storage conditions in their original containers, they will remain in useable condition for at least six months from date of shipping.

**PACKAGING:** This product is available in the following package sizes:

Preweighed gallon kit (12# total) contains 4# of resin base and 8# of hardener catalyst and 5-gallon pails containing 20# of resin base and 40# of hardener catalyst

Please call Customer Service (800) 367-8793 for price and availability

**SAFETY/HANDLING PRECAUTIONS:** Do not use or handle this product until the Material Safety Data Sheet has been read and understood.

**FIRST AID:** In case of contact with:

**Skin:** Immediately wash with soap and water. Remove contaminated clothing and launder before reuse. Destroy contaminated shoes.

**Eyes:** Immediately flush with water for at least 15 minutes. Call a physician.

**Ingestion:** If conscious, give 2-4 glasses of water to drink. Do not induce vomiting. Call a physician.

**Inhalation:** Remove to fresh air. Call a physician.

**PRECAUTIONARY NOTE:** Thermosetting systems generate heat when curing. The amount of heat and the period of time in which heat is released vary significantly between systems. Additionally, ambient or compound temperature, amount of material mixed, and construction and shape of the mold or container can also be factors in the temperature profile of a mixed system. In some cases, the thermosetting reaction can be vigorous, generating heat sufficient to cause decomposition of the system with subsequent liberation of large volumes of acrid smoke.

A good rule of thumb is never mix more material than can be applied during the stated pot life or gel time. Also take care when using materials in applications other than stated on the Product Data Sheet, i.e., a laminating resin for casting.

Please feel welcome to call our Product Information Department or your local Ren representative for instructions before you start your job.

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