

mCAST 7389 is a two-component coating and bonding epoxy suitable for applications requiring Title 21 FDA compliance. Viscosity variations and colorant are available upon request. mCAST 7389 is packaged in Dual Cartridge Syringes.

<u>Uncured Properties</u>	<u>Part A</u>	<u>Part B</u>	<u>Mixed</u>
Color:	Translucent	Clear Straw	Straw
Viscosity:	~15,000 cps (RVT)	~ 15,000 cps (RVT)	~4,000 cps (C & P)
Specific Gravity:	~1.12	~1.00	
Mix Ratio By Volume:	2:1		
Pot Life @ 25°C:	Mixed: 2 hours at RT*		
Gel Time:	4 hours at 20°C 20 g mass		
Cure Time:	24 hours at RT (20-25°C)		
(dependent upon mass of material mixed)	30 minutes at 90°C		
Shelf Life of Dual Cartridge @ 20-25°C:	1 year unmixed		
	Product may crystallize, Warm cartridges in a 50°C oven for 4-6 hours and cool to 20-25°C before mixing.		

*Pot Life times are mass dependent. EMIUV makes no guarantee of accuracy. Your results may vary.

Cured Properties

Color:	Clear Straw
Hardness:	75 Rex D
Tg:	65-75°C
CTE:	90-100 ppm/°C
Max recommended operating Temperature:	115°C
Young's Modulus:	200,000 psi
Tensile Strength:	5200 psi
Elongation:	5%

These values are provided as Typical Properties and are NOT to be used as a Specification

Cure Profile:

This product will solidify at Room Temperatures once mixed. Heat is required for full crosslink and development of ultimate properties.

- ◆ Minimum heat cure temperature is 20-25°C. Maximum heat cure temperature recommended is 90°C
- ◆ Always wear proper Skin Protection when working with amine curing agents.

Handling and Storage:

This product can be shipped and stored at ambient temperatures.

- ◆ Pot life once mixed depends upon the mass of material mixed.
- ◆ Double barrel syringes require one full-length dispense of material through the mix tube before application to the substrate, for best mixed results.
- ◆ The Part A resin may crystallize, warm double barrel syringes in a 50-60°C oven for 4-6 hours. Cool to 20-25°C before mixing.

Shipping and Unpacking Procedure

This material is packed and shipped at ambient temperatures. It is a stable material and can be stored at 20-25°C for up to one year.

- ◆ It is critical that the shipping container is not opened in transit and is expedited to its final destination.
- ◆ DO NOT ALLOW THE SHIPMENT TO BE LEFT ON LOADING DOCKS, IN CUSTOMS WAREHOUSES, OR ON FREIGHT TRUCKS FOR EXTENDED TIME PERIODS.

IMPORTANT NOTICE

Good housekeeping rules are always important. Provide ample ventilation in all areas of handling, and use. Avoid prolonged breathing of possible fumes. Minimize skin contact. Use of goggles, rubber gloves, and protective creams is recommended. Always wash exposed areas immediately using warm water and soap followed by rinsing with clear water. If material comes in contact with eyes, flush with clear water for fifteen minutes and consult a physician immediately. This datasheet provides "typical" values for this material, it is not the official manufacturing specification.

All data in this bulletin are based on our own research and the research of others. They are believed to be accurate. However, no guarantee of accuracy is made. Product description is sold without warranty except conformity to specification and on condition that the purchasers shall determine suitability for their particular purpose.

TDS7389.004
3/2019

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