

mCAST 7390 is a two component, RT coating and bonding epoxy suitable for applications requiring Title 21 FDA compliance. Viscosity variations and a blue colorant are available upon request. mCAST 7390 is packaged in dual cartridge syringes or two component kits.

Please specify both viscosity and color when ordering.

Viscosity variations:

7390-5K: 5000 cps
7390-10K: 10,000 cps
7390-20K: 20,000 cps

Uncured Properties

Color
Specific Gravity
Mix Specific Gravity
Mix Ratio By Weight
Mix Ratio By Volume
Pot Life @ 25°C
Gel Time:
Cure Time:
(dependent upon mass
of material mixed)

Part A

Clear or dark Blue
1.14
1.09
2.3:1
2:1
Mixed: 1 hour at RT
4 hours at 20°C 20 g mass
24 hours at RT (20-25°C)
30 minutes at 90°C

Part B

Clear Straw
0.98

Cured Properties

Color
Hardness
Tg
Maximum Operating Temperature
Young's Modulus
Tensile Strength
Elongation

Clear Straw
82 Rex D
95°C
125°C
315,000 psi
6400 psi
3%

Cure Profile:

This product is cured at Room Temperature or by using heat.

- ◆ 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. Blue colored product should be kept shaded from light until cured.

- ◆ 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.

Shipping and Unpacking Procedure

This material is packed and shipped at ambient temperatures. It is a stable material but should be refrigerated at 5°C or less upon receipt.

- ◆ 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.
- ◆ Maintaining temperature at 5°C or less upon receipt is critical to maintain the functionality and performance of the material.
- ◆ Failure to maintain these temperatures will void any warranties and will adversely affect the materials performance.
- ◆ Upon receipt, the syringes should be transferred from the shipping container to a freezer at 5°C or less.
- ◆ Care must be taken during this step as a sudden increase in temperature can cause irreversible air voids due to the thermal expansion of the syringe barrels.

Storage and Thawing

Prior to application, the material must be allowed to thaw naturally to room temperature (ideally 20-25°C) by placing the syringes in a vertical position with dispense tip facing downward. This is a critical step for obtaining optimum dispensing performance.

- ◆ Under no circumstance should artificial heat sources be used to increase thaw speed.
- ◆ Do not place the syringes in, or near, any heat source including ovens, hot plates, hot air guns, etc. to speed thawing.
- ◆ Thaw time varies by package style, size, and ambient temperature, but is typically 30 to 120 minutes.
- ◆ Do not attempt to dispense the material before it reaches ambient temperature.
- ◆ Wipe all excess moisture or condensation from the syringes prior to use.
- ◆ A small amount of air in the tip area is normal. Carefully remove the tip cap and manually extrude a small amount of material. This will displace any air that may be in the tip area.
- ◆ A small amount of air may accumulate at the rear of the syringe near the piston. This is also normal and this air can easily be removed by manually placing a light amount of pressure on the piston near the location of the visible air with the tip cap in place. This will force the air to by-pass the piston and exit the rear of the syringe. Mount the syringe onto the dispense equipment and purge material through the system until an unbroken flow of material is extruded.

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.

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.