

# Smooth-Cast® ColorMatch® 327

Polyurethane  
Smooth-On, Inc

Message:

The Smooth-Cast® 325, 326 & 327 ColorMatch® Series plastics are fast-cast resins that were developed specifically for adding color pigments and fillers to achieve true color representation or filler effect. The ColorMatch® Series is formulated "color neutral". Small amounts of pigment will yield accurate, vivid colors from cured castings using So-Strong® tints or Ignite® color pigments. The ColorMatch® Series offers the convenience of a 1A: 1B mix ratio by volume and has a very low viscosity. Demold times range from about 10 minutes to 2-4 hours (depending on product, mass and mold configuration). Note: Large mass castings will get very hot and shrink more, depending on mold configuration.

The ColorMatch® Series also readily accept fillers (such as URE-FIL® 3 from Smooth-On). Because of its neutral color, Smooth-Cast® 325 is ideal for creating marble and wood grain casting effects, or duplicating the look of real metal by adding bronze, brass or other metal powder (see Smooth-On technical bulletin for metal cold casting). Applications for the ColorMatch® Series plastics include making pigmented prototype models or figures, special effect props, reproducing small to medium size sculptures, decorative jewelry, etc.

General Information			
Features	Good Colorability		
Uses	Decorative Parts		
	Jewelry		
	Modeling Material		
Appearance	Clear Amber		
Processing Method	Casting		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.07	g/cm <sup>3</sup>	ASTM D1475
Specific Volume	0.936	cm <sup>3</sup> /g	ASTM D1475
	115A:100B by weight		
Mixing Ratio	1A:1B Volume		
Molding Shrinkage - Flow	0.75	%	ASTM D2566
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	72		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	965	MPa	ASTM D638
Tensile Strength	21.9	MPa	ASTM D638
Tensile Elongation (Break)	10	%	ASTM D638
Flexural Modulus	660	MPa	ASTM D790
Flexural Strength	21.4	MPa	ASTM D790
Compressive Modulus	222	MPa	ASTM D695
Compressive Strength	21.2	MPa	ASTM D695
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	48.9	°C	ASTM D648

Thermoset	Nominal Value	Unit	Test Method
Pot Life	10 to 20	min	
Thermoset Mix Viscosity	100	cP	ASTM D2393
Demold Time <sup>1</sup> (23°C)	120 to 480	min	
NOTE			
1.	Cure Time		

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#### Recommended distributors for this material

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