

Smooth-Cast® 385

Polyurethane
Smooth-On, Inc

Message:

Smooth-Cast® 385 is a mineral filled urethane casting resin that is very hard and durable. When Parts A and B are mixed in proper proportion (1A:5B by weight), Smooth-Cast® 385 cures at room temperature with virtually no shrinkage. This rigid urethane casting resin has high compressive and flexural strength. Fully cured castings are tough, machinable and paintable. Color effects are possible by adding pigment dispersions. They resist moisture and mild solvents. Smooth-Cast® 385 is ideal for making industrial production parts, foundry patterns, vacuum forming molds, and some ceramic applications.

General Information			
Filler / Reinforcement	Mineral		
Features	Durable		
	Good Toughness		
	High Hardness		
	Low Shrinkage		
	Machinable		
	Moisture Resistant		
	Paintable		
	Solvent Resistant		
Uses	Molds/Dies/Tools		
Appearance	Beige		
Processing Method	Casting		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.60	g/cm ³	ASTM D1475
Specific Volume	0.625	cm ³ /g	ASTM D1475
Mixing Ratio	1A:5B by weight		
Molding Shrinkage - Flow	0.060	%	ASTM D2566
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	85		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2760	MPa	ASTM D638
Tensile Strength (Break)	21.4	MPa	ASTM D638
Tensile Elongation (Break)	1.0	%	ASTM D638
Flexural Modulus	2990	MPa	ASTM D790
Flexural Strength	40.7	MPa	ASTM D790
Compressive Modulus	2760	MPa	ASTM D695
Compressive Strength	58.6	MPa	ASTM D695
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	57.2	°C	ASTM D648

Thermoset	Nominal Value	Unit	Test Method
Pot Life (23°C)	20	min	ASTM D2471
Thermoset Mix Viscosity	3000	cP	ASTM D2393
Demold Time (23°C)	120	min	

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