

Crystal Clear® 204

Polyurethane
Smooth-On, Inc

Message:

Crystal Clear® 200, 202, 204 and 206 are water white clear and made specifically for applications that require clarity. These rigid urethane casting resins differ only in working and demold times. Low viscosity ensures easy mixing and pouring. Crystal Clear® resins cure at room temperature* with negligible shrinkage. Cured castings are UV Resistant and are not brittle. Vibrant colors and color effects are achieved by adding pigment dispersions. Applications include encapsulation, making prototype models, lenses, sculpture reproductions, decorative cast pieces, jewelry, prototype models, special effects and props. Crystal Clear® 220 and 221 are harder, heat cured products that offer advantages over these room temp. cure products. A separate tech bulletin is available for CC220 and CC221 at www.smooth-on.com.

General Information	
Features	Good Colorability
	Good UV Resistance
	High Clarity
	High Rigidity
	Low Shrinkage
	Low Viscosity
Uses	Decorative Parts
	Jewelry
	Lenses
	Modeling Material
Appearance	Clear/Transparent
Processing Method	Casting
	Encapsulating

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.03	g/cm ³	ASTM D1475
Specific Volume	0.965	cm ³ /g	ASTM D1475
Mixing Ratio	100A:90B by weight		
Molding Shrinkage - Flow	0.20	%	ASTM D2566
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	80		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	595	MPa	ASTM D638
Tensile Strength	24.1	MPa	ASTM D638
Tensile Elongation (Break)	10	%	ASTM D638
Flexural Modulus	1260	MPa	ASTM D790
Flexural Strength	37.2	MPa	ASTM D790
Compressive Modulus	303	MPa	ASTM D695

Compressive Strength	29.0	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	120	min	
Thermoset Mix Viscosity	600	cP	ASTM D2393
Demold Time ¹ (23°C)	2900	min	
NOTE			

1. Cure Time

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Recommended distributors for this material

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