URETHANE CASTING
**URETHANE CASTING**

General process information

| MAX. PART SIZE                  | • 914.4 x 914.4 x 1828.8 mm
|                                 | • 36.0 x 36.0 x 72.0 in
|                                 | • Note: Ability to break parts up into multiple segments to create an even larger assembly |
| MIN. FEATURE SIZE              | • 0.635 mm for features
|                                 | • 0.02 in for features
|                                 | • 1.016 mm wall thickness
|                                 | • 0.040 in wall thickness |
| BEST ACHIEVABLE TOLERANCE      | • 0.005 in (0.127 mm) for first inch, 0.003 in (0.0762 mm) per lineal inch after the first one |
| LEAD TIME                      | • As low as 3 days to first shot depending on part geometries (FA)
|                                 | • After FA approval, as low as 2 weeks for remaining parts |
### URETHANE CASTING

**Shore D materials**

<table>
<thead>
<tr>
<th>STANDARD</th>
<th>HIGH PERFORMANCE</th>
<th>FDA</th>
<th>CLEAR</th>
</tr>
</thead>
<tbody>
<tr>
<td>• ABS-like (80D)</td>
<td>• ABS-like (80D)</td>
<td>• Optical Clear (80D, water clear)</td>
<td></td>
</tr>
<tr>
<td>• PE-like (65D)</td>
<td>• ABS-High Impact (78D)</td>
<td>• PC-like (84D, haze/pale yellow)</td>
<td></td>
</tr>
<tr>
<td>• PC-like (84D)</td>
<td>• High Impact FR (UL-94V0) (85D)</td>
<td></td>
<td></td>
</tr>
<tr>
<td>• PP-like (70D)</td>
<td>• Hi Temp (84D)</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>• 12 Sec burn (78D)</td>
<td>• Hi Impact Class VI (85D)</td>
<td></td>
</tr>
</tbody>
</table>

**Finishing / post-processing options**

**PART FINISHES**

- Smooth
- Satin
- Glossy / polish
- Custom finishing available
# URETHANE CASTING

**Shore A materials**

<table>
<thead>
<tr>
<th>ELASTOMERS</th>
<th>CLEAR ELASTOMERS</th>
<th>SILICONES</th>
<th>MEDICAL SILICONES</th>
</tr>
</thead>
</table>
| - Standard elastomers (15A-94A)  
- High performance elastomers (15A-90A) | - Clear elastomer (45A, water clear)  
- Clear elastomer (65A, water clear)  
- Clear elastomer (70A, water clear)  
- Clear elastomer (90A, water clear) | - 15A  
- 25A  
- 35A  
- 40A  
- 42A  
- 50A  
- 53A  
- 60A  
- 75A | - 38A |

**Finishing / post-processing options**

**PART FINISHES**

- Smooth  
- Satin  
- Glossy / polish  
- Custom finishing available