



POLYCOAT PRODUCTS

A Division of American Polymers Corp.

GREATER LOS ANGELES-14722 Spring Avenue - Santa Fe Springs, CA 90670
DALLAS / FT.WORTH METROPLEX-2100 Reliance Parkway - Bedford, TX 76021

Tel: (562) 802-8834
Fax: (562) 921-7363

www.Polycoat.com

PRODUCT DATA SHEET

PC 536 Shore A Series

Product Description:

The PC 536 Shore A Series Elastomers is two-component, one hundred percent solid, casting elastomers suitable for many casting applications.

The ability to extend gel time on these products allow for casting of extremely large parts. The Shore A Hardness can vary from 40 to 95.

The PC 536 Shore A Series Elastomers is designed for use as general purpose casting materials with good physical properties. These systems have been used for manufacturing concrete stamps, tooling, automotive bushings and other applications.

Typical Properties

A Component

NCO, %: 22.7-23.2

Viscosity, mPa·s @ 25°C: 500-1100

Specific Gravity @ 25°C: 1.21

Appearance @ 25°C: Liquid

B Component

Viscosity, mPa·s @ 25°C: 800-1000

Specific Gravity @ 25°C: 1.03

Appearance @ 25°C: Liquid

Typical Physical Properties		536-60	536-70	536-80	536-90	536-95
Hardness	Shore A	58-62	68-73	78-83	88-92	93-96
Resilience	%Rebound	N/A	40	40	38	37
Split Tear Strength	PLI	50	50	100	150	155
Die C Tear Strength	PLI	110	120	450	490	500
Tensile Strength	PSI	800	1100	2400	2500	2700
Ultimate Elongation	%	450	460	440	650	600
Compression Set	%	N/A	19	24	29	36
Processing Parameters						
Ratio by weight A/B		23/77	30/70	32/68	41.2/58.8	42.9/57.1
Ratio by weight (per 100 parts B)		29.9/100	42.9/100	47/100	70/100	75/100
Material temperatures,	° F	90-110	90-110	90-110	90-110	90-110
Mold Temperature,	° F	110-140	110-140	110-140	110-140	110-140
Gel Time,	Min.	2-5	2-5	2-5	2-5	2-5



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Storage and Handling:

Containers should be kept tightly closed to prevent moisture contamination. Do not reseal if contamination is suspected. Use of a dry nitrogen blanket for partial drums is recommended. Storage temperatures for the HS 425 Series should be maintained between 68° and 95°F (20° and 35°C). For best results, this product should not be allowed to freeze, although it may be re-heated in a well ventilated oven for a period of time to re-liquefy solid particles. To avoid product degradation, product temperature during re-heating should not exceed 140°F (60°C). An additional note of caution is that exposure to temperatures over 400°F (204°C) can create excessive pressure potentially causing containers to rupture. Do not breathe aerosol or vapors. Exposure to vapors of heated MDI can be dangerous. To heat product properly, use well ventilated convection ovens or other methods that distribute heat evenly. Avoid using drum heaters or other heat sources that may cause excessive local heating.

Health and Safety Information:

Appropriate literature has been assembled which provides information concerning the health and safety precautions that must be observed when handling any of the products listed above. Before working with these products, it is your responsibility to read and become familiar with the available information on its hazards, proper use and handling. This is extremely important and cannot be overemphasized. Information is available in several forms, e.g. material safety data sheets and product labels. To obtain this information, contact your Polycoat representative.