



**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 536-80D-3M-BLACK

Typical Properties PC 536-80D A-COMP (ISO)

NCO, %:	22.7-23.2
Viscosity, mPa-s @ 25°C:	600-1100
Specific Gravity @ 25°C :	1.21
Appearance @ 25°C:	liquid

Typical Properties PC 536-80D B-COMP (polyol blend)

Viscosity, mPa-s @ 80°C:	900-1200
Specific Gravity @ 25°C :	1.02
Appearance @ 25°C:	viscous liquid

Typical Physical Properties

Hardness	Shore D	75-80
Rebound	%	36
Die C Tear Strength	PLI	1400-1700
Tensile Strength	PSI	5500-6500
Ultimate Elongation	%	20-40

Product Description:

PC 536-80D-3M is a two-component, 100% solid Elastomeric Urethane system designed for processing by either hand mix or typical polyurethane dispensing equipment. Recommended uses include; Automotive parts, air-filters, sporting goods, tooling, or applications where superior tensile strength, elongation, and high-resilience are required with a Shore D hardness of 75-80.

Storage and Handling:

Containers for both A and B components 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. Component B may be stored at ambient temperatures. Storage for Component A should be maintained between 77°F (25°C) and 95°F (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 and avoid contact with skin and eyes. 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.

Processing Characteristics

Mix ratio by weight A/B		53/47
A component temperature	°F	90-100
B Component temperature	°F	80-100
Mold temperature	°F	90-150
Gel time*, 74 °F	seconds	160-180
<i>*Variety of gel times available</i>		

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 Products representative.

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