



TECHNICAL DATA SHEET

PC 536 95A

PRODUCT DESCRIPTION: PC 536-95A elastomer is a two component, one hundred percent solid, polyurethane elastomer designed for use as a general purpose casting material with good physical properties.

APPLICATIONS: PC 536-95A elastomer is suitable for manufacturing automotive parts, sporting goods, tooling and many other types of casting applications.

PHYSICAL PROPERTIES:

<u>PROPERTY</u>	<u>TEST METHOD</u>	
Hardness Shore A	D-2240	93-97
Tensile Strength, PSI		
100% Modulus	D-412	2500-3000
300% Modulus		3000-3500
Elongation Ultimate %	D-412	330
Tear Strength, Split, PLI	D-470	210
Die C, PLI		570
Bashore Rebound		50
Compression Set % @ 22 Hrs. 158° F	D-395, B	60
Shrinkage in./in.		.015-.020

PROCESSING PARAMETERS:

<u>Ratio by Weight</u>	
Component "A"	43
Component "B"	57
<u>Ratio by Weight</u> (per 100 parts "B")	
Component "A"	75
Component "B"	100

Specific Gravity

Component "A"	1.2
Component "B"	1.02-1.04
<u>Viscosity CPS @ 74° F</u>	
Component "A"	700-900
Component "B"	800-1000
<u>Gel Time (Sec)</u>	
Temp 74° F	110-130
Temp 95 - 100° F	45-55

DISPENSING PARAMETERS:

Chemical Temperature

Component "A"	90-110°F
Component "B"	90-110°F
Mold Temperature	110-140°F
Demold Time, (min)	4-6

STORAGE:

Component "A" (Isocyanate): The isocyanate must be stored in tightly sealed containers and protected from moisture. The material should be stored at temperatures between 85 and 100°F. If material becomes solidified due to freezing, material can be liquified by heating in a convection oven to 130°F under constant agitation and nitrogen blanket.

Component "B" (Polyol): The polyol is hygroscopic (moisture absorbent). Keep containers sealed to prevent moisture absorption. Store material at temperatures between 85 and 100°F. Thoroughly mix component "B" under dry nitrogen immediately before use.

SAFETY INFORMATION: MATERIAL SAFETY DATA SHEETS ARE SENT WITH EACH SHIPMENT OF POLYCOAT PRODUCTS. THESE DATA SHEETS SHOULD BE READ AND UNDERSTOOD BY ALL PERSONNEL WHO WILL COME IN CONTACT WITH THE PRODUCT BEFORE THE CONTAINERS ARE OPENED. IF THE SAFETY DATA SHEETS ARE LOST OR YOU REQUIRE ADDITIONAL DATA SHEETS, PLEASE CONTACT POLYCOAT PRODUCTS.

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2 Nov 99 Rev. 8