

Product Description

PCNO 65D is a 100 % solids, no odor solid cast two-component urethane system. It is easy to process, has low exothermal and demolds in 8-15 minutes.

Recommended Uses

Furniture parts, sporting goods, decorative components, ornamental moldings, mirror and picture frames, and other similar items not requiring high temperature resistance.

Storage and Handling

Containers for both Side-A and Side-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. Side-B may be stored at ambient temperatures. Storage for Side-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.

Health and Safety

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.

Typical Properties Side-A (ISO)

Viscosity @ 77°F (25°C)	150-250 cps
Specific Gravity @ 77°F (25°C)	1.15
Appearance @ 77°F (25°C)	liquid

Typical Properties Side-B (polyol blend)

Viscosity @ 77°F (25°C)	150-250 cps
Specific Gravity @ 77°F (25°C)	0.994
Appearance @ 77°F (25°C)	liquid

Typical Physical Properties

Hardness, Shore D ASTM D-2240	65
Density, ASTM D-1622	64 Lbs/ft ² (31.2 g/cm ²)
Elongation, ASTM D-2370	11%
Tensile Strength, ASTM D-2370	4700 psi (32.4 MPa)
Compression Strength	5000 psi minimum (34.5 MPa)
Heat Sag, ASTM D-3769 @ 160°F (71°C)	0.0 IN.
Heat Sag, ASTM D-3769 @ 200°F (93°C)	.45 IN.

Processing Characteristics

Mix Ratio by Weight A:B	50:50
Shrinkage (linear) Unfilled	0.01 in. (0.254 mm)
Shrinkage (linear) Filled	0.005 in. (0.127 mm)
Gel Time*	210-230 seconds
Demold Time	8-15 minutes

*Variety of gel times available



Limited Warranty: Please read all information in the General Guidelines, Technical Data Sheets, Guide Specifications and Safety Data Sheets (SDS) before applying material. These products are for professional use only and preferably applied by professionals who have prior experience with the Polycoat Products materials or have undergone training in application of Polycoat Products materials. Published technical data and instructions are subject to change without notice. Contact your local Polycoat Products representative or visit our website for current technical data, instructions, and project specific recommendations.

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