

## 50A / Translucent

Tough, abrasion resistant elastomer

### Key Properties

- Excellent physical properties after RT cure
- Free of mercury, MOCA or TDI
- Ideal for color-matching applications due to its transparent appearance

### Applications

- For hand-batch processing

### Processing Properties

			Resin (Isocyanate)	Hardener (Polyol)
Mix ratio		pbw	50	100
		pbv	51	100
Density	ASTM D-792	g/cm <sup>3</sup>	ca. 1.21	ca. 1.23
Viscosity at 77°F (25°C)	ASTM D-2393	cP	ca. 45	ca. 1,350

			Mixture
Mix viscosity at 77°F (25°C)	ASTM D-2393	cP	ca. 875
Gel time at 77°F (25°C)		min	10-14
Demold time at 77°F (25°C)		h	2-4

### Cured / Mechanical Properties (approximate values)

Cure 1: 7 days at 77°F			Cure 1
Aspect	visual		Clear
Density	ASTM D-792	g/cm <sup>3</sup>	1.21
Shore hardness A	ASTM D-2240		45-55
Tensile strength	ASTM D-638	psi	400
Elongation at Break	ASTM D-638	%	150
Tear strength	ASTM D-624	pli	100
Linear shrinkage	ASTM D-2566	in/in	0.001-0.004

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### Processing

**The processing and material temperature should be between 68-77°F (20-25°C).**

IE-3250 is ideal for custom pigmenting using the proper polyester based pigments. Ask your RAMPF Group Inc. representative to learn more about these pigments.

IE-3250 may be inhibited by certain silicone rubbers. It is recommended that a test sample be prepared to verify compatibility. Contact RAMPF Group Inc. for more information. Due to variances in the raw materials that are used to manufacture this product, RAMPF Group Inc. may suggest the use of slightly altered ratio to achieve the hardness and physical properties listed on our data bulletin. The technical and sales staff will contact customers appropriately if any change is necessary.

**Agitate the hardener before mixing to ensure that the formula is homogeneous.**

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### Packaging

IE-3250 Quart Kit	3 lbs.
IE-3250 1 Gal. Kit	12 lbs.
IE-3250 5 Gal. Kit	60 lbs.
IE-3250 Drum Kit	675 lbs.

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### Storage

Original containers should be kept tightly sealed and stored at ambient temperatures 59-86°F (15°C to 30°C). If properly stored the products have the shelf-life indicated on the product label.

Partly used containers should always be sealed appropriately and used up as soon as possible.

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### Handling Precautions

Good workplace ventilation is to be ensured during processing. At the same time, the employer's liability insurance association's industrial hygiene safety regulations regarding the handling of reaction resins and their hardeners are to be observed. Please take heed of the appropriate safety data sheets.

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