

## Rapid Demold / Rigid

### Rigid polyurethane

#### Key Properties

- Excellent physical properties after RT cure
- Free of mercury, MOCA or TDI
- Excellent green strength yielding enhanced demold characteristics
- Yields easy to paint surfaces requiring little preparation

#### Applications

- For room temperature hand-batch or meter-mix equipment

#### Processing Properties

			Resin (Isocyanate)	Hardener (Polyol)
Mix ratio		pbw	100	91
		pbv	100	100
Density	ASTM D-792	g/cm <sup>3</sup>	ca. 1.19	ca. 1.08
Viscosity at 77°F (25°C)	ASTM D-2393	cP	ca. 75	ca. 450
			Mixture	
Mix viscosity at 77°F (25°C)	ASTM D-2393	cP	ca. 150	
Gel time at 77°F (25°C)		min	1:30-2:30	
Peak Exotherm	200gr	°F (°C)	260 (127)	
Demold time at 77°F (25°C)		min	7:30-12:30	

#### Cured / Mechanical Properties (approximate values)

Cure 1: 7 days at 77°F			Cure 1
Aspect	visual		White
Density	ASTM D-792	g/cm <sup>3</sup>	1.08
Shore hardness D	ASTM D-2240		70-80
Deflection temperature, HDT (66psi)	ASTM D-648	°F (°C)	158 (70)
Tensile strength	ASTM D-638	psi	5,000
Elongation at Break	ASTM D-638	%	20
Tensile modulus	ASTM D-638	psi	165,000
Flexural strength	ASTM D-790	psi	10,200
Flexural modulus	ASTM D-790	psi	270,000
Notched Izod	ASTM D-256	ft-lbf/in	0.5
Linear shrinkage	ASTM D-2566	in/in	0.001-0.005

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**Processing**

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

This product will slightly separate upon storage.

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

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**Packaging**

IE-3031 Quart Kit	3.82 lbs.
IE-3031 1 Gal. Kit	15.28 lbs.
IE-3031 5 Gal. Kit	76.4 lbs.
IE-3031 Drum Kit	859.5 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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