

Jacket / Mother Mold

80 shore D polyurethane surface coat

Key Properties

- Excellent physical properties after RT cure
- Free of mercury, MOCA or TDI

Applications

- For hand-batch processing
- To be used where vertical lay-ups are required or for use as a strong, durable mother-mold in silicone glove molding processes

Processing Properties

			Resin (Isocyanate)	Hardener (Polyol)
Mix ratio		pbw	100	97
		pbv	100	100
Density	ASTM D-792	g/cm ³	ca. 1.28	ca. 1.24
Viscosity at 77°F (25°C)	ASTM D-2393	cP	ca. 16,000	ca. 2,500

			Mixture
Mix viscosity at 77°F (25°C)	ASTM D-2393	cP	thixotropic
Gel time at 77°F (25°C)		min	4-8
Demold time at 77°F (25°C)		min	30-60

Cured / Mechanical Properties (approximate values)

Cure 1: 7 days at 77°F			Cure 1
Aspect	visual		Light Gray
Density	ASTM D-792	g/cm ³	1.24
Shore hardness D	ASTM D-2240		65-75
Deflection temperature, HDT (66psi)	ASTM D-648	°F (°C)	140 (60)
Tensile strength	ASTM D-638	psi	6,150
Elongation at Break	ASTM D-638	%	2
Flexural strength	ASTM D-790	psi	11,400
Flexural modulus	ASTM D-790	psi	635,000
Notched Izod	ASTM D-256	ft·lbf/in	0.6

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

This product has been specially formulated to be used in applications requiring a paintable material that will cling to vertical surfaces. It is recommended that appropriate amounts of each side are pre-weighed into cups. Add the resin component into the hardener while mixing to attain a smooth texture before painting. There is a filler package located on both sides.

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

Packaging

IE-3065 Quart Kit	3.94 lbs.
IE-3065 1 Gal. Kit	15.76 lbs.
IE-3065 5 Gal. Kit	78.8 lbs.
IE-3065 Drum Kit	886.5 lbs.

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.

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.
