

## Translucent / Rigid

### Rigid polyurethane

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Page 1 of 2

#### Key Properties

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

#### Applications

- For room temperature hand-batch or vacuum assisted casting methods

#### Processing Properties

			Resin (Isocyanate)	Hardener (Polyol)
Mix ratio		pbw	100	89
		pbv	100	100
Density	ASTM D-792	g/cm <sup>3</sup>	ca. 1.25	ca. 1.11
Viscosity at 77°F (25°C)	ASTM D-2393	cP	ca. 75	ca. 850

			Mixture
Mix viscosity at 77°F (25°C)	ASTM D-2393	cP	ca. 300
Gel time at 77°F (25°C)		min	6-10
Peak Exotherm	200gr	°F (°C)	310 (154)
Demold time at 77°F (25°C)		min	30-90

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

Cure 1: 24 hours at 77°F + 16 hours at 200°F Cure 2: 7 days at 77°F			Cure 1	Cure 2
Aspect	visual		Translucent	Translucent
Density	ASTM D-792	g/cm <sup>3</sup>	1.11	1.11
Shore hardness D	ASTM D-2240		75-85	75-85
Deflection temperature, HDT (66psi)	ASTM D-648	°F (°C)	177 (81)	167 (75)
Tensile strength	ASTM D-638	psi	10,000	10,500
Elongation at Break	ASTM D-638	%	9	8
Flexural strength	ASTM D-790	psi	16,500	17,000
Flexural modulus	ASTM D-790	psi	390,000	420,000
Compression modulus	ASTM D-695	psi	300,000	NA
Notched Izod	ASTM D-256	ft·lbf/in	0.7	0.7
Linear shrinkage	ASTM D-2566	in/in	0.002-0.004	0.002-0.004

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### Processing

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

IE-3075 is ideal for custom pigmenting. Ask your RAMPF Group Inc. representative to learn more about these pigments.

IE-3075 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.

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

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### Packaging

IE-3075 Quart Kit	3.78 lbs.
IE-3075 1 Gal. Kit	15.12 lbs.
IE-3075 5 Gal. Kit	75.6 lbs.
IE-3075 Drum Kit	850.5 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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