

	Product	Color	Mix Ratio (pbw) Isocyanate / Polyol	Mix Viscosity at 77°F (25°C) cP ASTM D-2393	Demold Time at 77°F (25°C) h	Gel Time at 77°F (25°C), min	Shore Hardness ASTM D-2240	Tensile Strength, psi ASTM D-638	Elongation at Break, % ASTM D-638	Flexural Modulus, psi ASTM D-790	Izod Impact Strength Notched, ft-lbf/in - ASTM D-256	Heat Deflection Temperature, at 66 psi, °F (°C) ASTM D-648
Inno-FR™ FX Series Data: Shore A Elastomers	FX-8041	White	27 / 100	1,300	2 – 4	10 – 15	40 – 50A	255	90	–	–	–
	FX-8061	White	36 / 100	1,300	2 – 4	10 – 15	55 – 65A	525	180	–	–	–
	FX-8071	White	39 / 100	1,850	2 – 4	10 – 15	65 – 75A	600	150	–	–	–
	FX-8072	Black	100 / 100	1,950	8 – 10	20 – 25	65 – 75A	1,175	250	–	–	–
	FX-8081	White	44 / 100	1,850	2 – 5	10 – 15	75 – 85A	1,050	150	–	–	–
	FX-8030	White	53 / 100	1,000	3 – 5 min	25 – 35 sec	75 – 85A	1,200	90	–	–	–
	FX-8031	White	53 / 100	1,000	3 – 5	10 – 15	75 – 85A	1,200	90	–	–	–
	FX-8091	White	55 / 100	1,180	2 – 4	10 – 15	85 – 95A	1,400	125	–	–	–
Inno-FR™ FX Series Data: Shore D Rigids	FX-8575	Clear	100 / 63	175	1 (66°C)	10 – 15	77 – 87D	11,600	5	350,000	0.8	131 (55)
	FX-8580	Amber	100 / 60	700	1 (66°C)	8 – 14	75 – 85D	8,000	5	250,000	1.8	150 (66)
	FX-8585	Tan	100 / 56	1,400	1:30 – 3:30	5:30 – 8:30	80 – 90D	6,600	3	235,000	0.7	207 (97)
	FX-8586	Clear	100 / 50	930	2 – 4	15 – 20	75 – 85D	9,100	2	300,000	1.0	158 (70)
InnoTuf® TP Series Data	TP-4014	Amber	100 / 50	700	1 (66°C)	10 – 15	65 – 75D	5,500	55	110,000	2.5	140 (60)
	TP-4015	Black	100 / 50	350	30 – 50 min	1:25 – 1:35	65 – 75D	4,900	18	168,300	2.5	153 (67)
	TP-4016	Black	100 / 52	350	2 – 4	5 – 7	65 – 75D	7,700	18	168,300	2.5	153 (67)
	TP-4004-1	Amber	100 / 50	2,100	1 (66°C)	10 – 14	60 – 70D	5,500	55	115,000	6.0	149 (65)
	TP-4007	Amber	100 / 50	400	1 (66°C)	8 – 12	75 – 85D	10,500	10	325,000	1.2	212 (100)
	TP-4008	Light Amber	100 / 71	580	1 – 2	8 – 12	75 – 85D	7,500	10	200,000	2.8	160 (71)
	TP-4009	Amber	100 / 55	1,250	1 (66°C)	7 – 9	80 – 90D	11,300	15	316,000	1.2	266 (130)

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	Product	Color	Mix Ratio (pbw) Isocyanate / Polyol	Mix Viscosity at 77°F (25°C) cP ASTM D-2393	Demold Time at 77°F (25°C) h	Gel Time at 77°F (25°C), min	Shore Hardness ASTM D-2240	Tensile Strength, psi ASTM D-638	Elongation at Break, % ASTM D-638	Flexural Modulus, psi ASTM D-790	Izod Impact Strength Notched, ft-lbf/in - ASTM D-256	Heat Deflection Temperature, at 66 psi, °F (°C) ASTM D-648
InnoTuf® TP Series Data	TP-4010	Amber	100 / 52	2,100	1 (150°C)	8 – 11	60 – 70D	5,500	55	110,500	6.0	162 (72)
	TP-4020	Tan	100 / 46	1,300	1 (66°C)	8 – 12	75 – 85D	10,900	2	650,000	0.3	345 (174)
	TP-4040	Black	100 / 53	2,100	45 – 75 min	1:30 – 2:30	65 – 75D	4,000	55	110,000	6.5	186 (85)
	TP-4045	Black	100 / 53	2,100	60 – 120 min	4 – 6	65 – 75D	4,000	70	110,000	6.5	186 (85)
	TP-4050	White	100 / 100	325	45 – 75 min	4 – 6	75 – 85D	8,500	20	250,000	1.8	176 (80)
	TP-4051	White	100 / 100	325	1 – 3	6 – 10	75 – 85D	8,500	20	250,000	1.8	164 (73)
	TP-4052	White	100 / 50	600	60 – 120 min	5 – 9	75 – 85D	9,000	10	250,000	1.7	167 (75)
	TP-4053	White	100 / 100	1,000	1 – 3	6 – 10	80 – 90D	9,000	3	450,000	0.7	140 (60)
	TP-4054	White	100 / 100	700	1 – 3	6 – 10	80 – 90D	9,500	5	350,000	1.0	151 (66)
	TP-4055	Translucent	76 / 100	500	2 – 4	6 – 10	65 – 75D	4,700	30	120,000	2.0	151 (66)
	TP-4056	White	100 / 100	325	30 – 60 min	2 – 4	75 – 85D	8,500	20	250,000	1.8	176 (80)
	TP-4058	White	100 / 91	900	30 – 60 min	2 – 4	75 – 85D	10,500	5	304,000	1.8	158 (70)
	TP-4060	White ¹⁾	100 / 82	325	30 – 60 min	2 – 3	75 – 85D	12,000	4	450,000	0.8	150 (65)
	TP-4065	White	61 / 100	250	1 – 2	7 – 10	60 – 70D	3,500	40	80,000	1.5	178 (81)
InnoTuf® HP Series Data	HP-2560	White	50 / 100	600	1 – 3 (49°C)	10 – 20 120°F (49°C)	55 – 65A	2,350	450	–	–	–
	HP-2570	White	60 / 100	600	1 – 3 (49°C)	10 – 20 120°F (49°C)	65 – 75A	2,700	575	–	–	–
	HP-2580	White	83 / 100	600	1 – 3 (49°C)	10 – 20 120°F (49°C)	75 – 85A	3,200	500	–	–	–
	HP-2585	White	94 / 100	600	1 – 3 (49°C)	10 – 20 120°F (49°C)	80 – 90A	4,000	600	–	–	–
	HP-2590	White	100 / 90	600	1 – 3 (49°C)	10 – 20 120°F (49°C)	85 – 95A	4,500	450	–	–	–

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	Product	Color	Mix Ratio (pbw) Isocyanate / Polyol	Mix Viscosity at 77°F (25°C) cP ASTM D-2393	Demold Time at 77°F (25°C) h	Gel Time at 77°F (25°C), min	Shore Hardness ASTM D-2240	Tensile Strength, psi ASTM D-638	Elongation at Break, % ASTM D-638	Flexural Modulus, psi ASTM D-790	Izod Impact Strength Notched, ft-lbf/in - ASTM D-256	Heat Deflection Temperature, at 66 psi, °F (°C) ASTM D-648
InnoTuf® HP Series Data	HP-2120	Light Amber	100 / 43	475	5 – 7	15 – 25	15 – 25A	260	500	–	–	–
	HP-2130	Light Amber	100 / 45	475	5 – 7	20 – 30	25 – 35A	350	500	–	–	–
	HP-2140	Light Amber	100 / 47	475	5 – 7	20 – 30	35 – 45A	600	480	–	–	–
	HP-2150	Light Amber	100 / 47	475	5 – 7	20 – 30	45 – 55A	850	600	–	–	–
	HP-2160	Light Amber	100 / 43	1,660	3 – 5 (66°C)	10 – 20	55 – 65A	900	150	–	–	–
	HP-2170	Amber	100 / 44	2,075	4 – 6	10 – 20	65 – 75A	1,000	400	–	–	–
	HP-2180	Amber	100 / 40	2,800	4 – 6	15 – 25	75 – 85A	1,800	520	–	–	–
	HP-2185	Amber	100 / 34	3,300	4 – 6	20 – 30	80 – 90A	2,800	460	–	–	–
	HP-2190	Amber	100 / 30	3,300	4 – 6	20 – 30	85 – 95A	3,400	250	–	–	–
	HP-2195	Amber	100 / 28	3,300	4 – 6	20 – 30	91 – 99A	3,850	400	–	–	–
	HP-2250	Amber	100 / 22	3,300	4 – 6	15 – 25	45 – 55D	4,325	280	–	–	–
	HP-2260	Amber	100 / 20	3,300	4 – 6	20 – 30	55 – 65D	5,000	280	–	–	–
	HP-2270	Amber	100 / 22	3,800	1 – 3	10 – 20	65 – 75D	5,000	180	60,000	14	–
InnoClear™ OC Series Data: Shore A Urethane Elastomers	OC-5050	Clear	50 / 100	650	16 – 24	15 – 25	45 – 55A	225	65	–	–	–
	OC-5060	Clear	30 / 100	900	4 – 8	12 – 18	55 – 65A	300	80	–	–	–
	OC-5070	Clear	60 / 100	700	4 – 8	12 – 18	65 – 75A	450	85	–	–	–
	OC-5080	Clear	35 / 100	750	3 – 5	12 – 18	72 – 82A	550	85	–	–	–
	OC-5090	Clear	50 / 100	750	2 – 4	13 – 19	85 – 95A	1,950	65	–	–	–

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	Product	Color	Mix Ratio (pbw) Isocyanate / Polyol	Mix Viscosity at 77°F (25°C) cP ASTM D-2393	Demold Time at 77°F (25°C) h	Gel Time at 77°F (25°C), min	Shore Hardness ASTM D-2240	Tensile Strength, psi ASTM D-638	Elongation at Break, % ASTM D-638	Flexural Modulus, psi ASTM D-790	Izod Impact Strength Notched, ft-lbf/in - ASTM D-256	Heat Deflection Temperature, at 66 psi, °F (°C) ASTM D-648
InnoClear™ OC Series Data: Shore D Rigid Urethanes	OC-5284	Water Clear	100 / 50	1,200	16 – 24	40 – 60	80 – 90D	10,100	8	275,000	1.1	129 (54)
	OC-5085	Water Clear	100 / 57	650	16 – 24	80 – 120	75 – 85D	8,000	8	350,000	0.3	129 (54)
	OC-5272	Water Clear	100 / 50	1,200	2 – 4	15 – 20	75 – 85D	10,000	2	325,000	0.6	140 (60)
	OC-5086	Water Clear	100 / 57	650	2 – 4	15 – 20	75 – 85D	8,000	8	350,000	0.5	129 (54)
	OC-5274	Water Clear	100 / 50	750	4 – 8	15 – 23	80 – 86D	7,000	3	385,000	0.4	120 (49)
	OC-5436	Transparent	100 / 56	12,500	110 – 130	18 – 22	80 – 85D	n / a	n / a	390,000	1.0	210 (99)
RapidCast™ RC Series Data	RC-79D	Amber	100 / 100	1,000	9 – 15 min	40 – 70 sec	80 – 90D	5,200	5	325,000	0.6	189 (87)
	RC-0082	Translucent	100 / 86	375	9 – 15 min	40 – 60 sec	75 – 85D	8,500	13	285,000	0.7	158 (70)
	RC-0200	Off-White	100 / 89	900	10 – 15 min	50 – 70 sec	75 – 85D	6,700	5	175,000	3.0	140 (60)
	RC-0210	Black	100 / 89	900	10 – 15 min	50 – 70 sec	75 – 85D	6,700	5	175,000	3.0	140 (60)
	RC-0255	Black	100 / 84	N / A	20 – 30 min	50 – 70 sec	75 – 85D	8,000	10	300,000	1.0	194 (90)
	RC-0510	Black	100 / 90	700	20 – 30 min	40 – 60 sec	80 – 90D	9,400	5	350,000	0.5	284 (140)
	RC-543	Buff	100 / 33	500	10 – 20 min	30 – 50 sec	70 – 80D	6,000	8	225,000	0.5	167 (75)
	RC-0555	Black	100 / 88	500	10 – 15 min	60 – 80 sec	75 – 85D	6,500	9	210,000	1.1	194 (90)
	RC-0900	Amber	100 / 90	425	10 – 15 min	70 – 90 sec	80 – 90D	8,000	3	350,000	0.8	194 (88)
RapidVac™ VA Series Data: Shore A Urethane Elastomers	VA-1500	Neutral Tan	40 / 100	900	30 – 60 min	4 – 6	45 – 55A	370	150	–	–	–
	VA-1505	Black	40 / 100	900	30 – 60 min	4 – 6	45 – 55A	370	150	–	–	–
	VA-1510	Neutral Tan	40 / 100	800	60 – 120 min	8 – 12	45 – 55A	370	150	–	–	–

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RapidVac™ VA Series Data: Shore A Urethane Elastomers	VA-1515	Black	40 / 100	900	60 – 120 min	8 – 12	45 – 55A	370	150	–	–	–
	VA-1600	Neutral Tan	52 / 100	850	20 – 40 min	3 – 5	55 – 65A	325	100	–	–	–
	VA-1605	Black	52 / 100	850	20 – 40 min	3 – 5	55 – 65A	325	100	–	–	–
	VA-1610	Neutral Tan	52 / 100	850	45 – 75 min	8 – 12	55 – 65A	325	100	–	–	–
	VA-1615	Black	52 / 100	850	45 – 75 min	8 – 12	55 – 65A	325	100	–	–	–
	VA-1700	Off-White	70 / 100	1,100	30 – 60 min	4 – 6	65 – 75A	635	100	–	–	–
	VA-1705	Black	70 / 100	1,100	30 – 60 min	4 – 6	65 – 75A	635	100	–	–	–
	VA-1710	Off-White	70 / 100	1,100	60 – 120 min	8 – 12	65 – 75A	635	100	–	–	–
	VA-1715	Black	70 / 100	1,100	90 – 120 min	8 – 12	65 – 75A	635	100	–	–	–
	VA-1800	Off-White	80 / 100	1,750	30 – 60 min	4 – 6	70 – 80A	650	90	–	–	–
	VA-1805	Black	80 / 100	1,750	30 – 60 min	4 – 6	70 – 80A	650	90	–	–	–
	VA-1810	Off-White	80 / 100	1,750	60 – 120 min	8 – 12	70 – 80A	650	90	–	–	–
	VA-1815	Black	80 / 100	1,750	60 – 120 min	8 – 12	70 – 80A	650	90	–	–	–
	VA-1900	Neutral Tan	100 / 100	1,100	30 – 60 min	4 – 6	85 – 95A	1,250	65	–	–	–
	VA-1905	Black	100 / 100	1,100	30 – 60 min	4 – 6	85 – 95A	1,250	65	–	–	–
	VA-1910	Neutral Tan	100 / 100	1,100	60 – 120 min	8 – 12	85 – 95A	1,250	65	–	–	–
	VA-1915	Black	100 / 100	1,100	60 – 120 min	8 – 12	85 – 95A	1,250	65	–	–	–
RapidVac™ VA Series Data: Shore D Urethane Plastics	VA-1257	White	100 / 50	1,000	1:30 – 3:30	5:30 – 8:30	75 – 85D	6,200	8	325,000	0.7	149 (65)
	VA-1290	Amber	100 / 77	1,000	1 (70°C)	5 – 7	75 – 85D	9,000	4	343,500	0.7	230 (110)

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IE SERIES™: SHORE A ELASTOMERS	IE-3210	Cream	100 / 100	600	3 – 5	10 – 14	5 – 15A	150	450	–	–	–
	IE-3220	Cream	100 / 100	600	3 – 5	10 – 14	5 – 15A	200	175	–	–	–
	IE-3235	Translucent	100 / 100	850	1 – 3	10 – 15	30 – 40A	200	150	–	–	–
	IE-3240	Off-White	100 / 95	950	12 – 20	20 – 30	32 – 42A	900	600	–	–	–
	IE-3250	Clear	50 / 100	875	2 – 4	10 – 14	45 – 55A	400	150	–	–	–
	IE-3252	Off-White	40 / 100	800	12 – 20	20 – 30	45 – 55A	1,100	520	–	–	–
	IE-3260	Cream	25 / 100	975	4 – 8	7 – 13	50 – 60A	800	250	–	–	–
	IE-3261	Clear	50 / 100	575	2 – 8	9 – 15	55 – 65A	570	200	–	–	–
	IE-3265	Gray	56 / 100	1,980	16 – 24	22 – 32	60 – 70A	700	117	–	–	–
	IE-3270	Cream	34 / 100	975	6 – 10	7 – 13	65 – 75A	1,700	250	–	–	–
	IE-3280	Cream	35 / 100	975	4 – 8	7 – 13	75 – 85A	1,700	250	–	–	–
	IE-3290	Cream	38 / 100	975	4 – 8	7 – 13	80 – 90A	1,750	180	–	–	–
	IE-3300	Green	100 / 100	1,200	14 – 18	20 – 30	20 – 30A	115	100	–	–	–
	IE-3500 ²⁾	Clear Amber	100 / 100	1,200	5 – 7	15 – 25	35 – 45A	400	200	–	–	–
	IE-3600 ²⁾	Light Amber	60 / 100	2,000	3 – 5	16 – 20	55 – 65A	450	165	–	–	–
IE-3700 ²⁾	Cream	50 / 100	2,000	3 – 5	16 – 20	65 – 75A	800	300	–	–	–	
IE-3800 ²⁾	Cream	35 / 100	2,000	6 – 8	16 – 20	75 – 85A	1,170	270	–	–	–	
CLASSIC IE™ SERIES SHORE D	IE-3170	White	100 / 50	200	16 – 24	120 – 240	65 – 75D	4,000	4	250,000	0.5	140 (60)
	IE-3171	White	100 / 50	200	2 – 4	5 – 9	65 – 75D	5,500	8	250,000	0.5	140 (60)

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CLASSIC IE™ SERIES SHORE D	IE-3172	White	100 / 50	200	1 – 3	2 – 4	65 – 75D	5,500	8	250,000	0.5	140 (60)
	IE-3173	White	100 / 50	200	16 – 24	45 – 75	65 – 75D	5,500	8	250,000	0.5	140 (60)
	IE-3174	White	100 / 50	200	4 – 6	15 – 20	65 – 75D	5,500	8	250,000	0.5	140 (60)
	IE-3010	White	100 / 92	150	5 – 15 min	0:20 – 0:40	65 – 75D	4,950	24	145,000	0.6	149 (65)
	IE-3025	Translucent	100 / 94	100	20 – 40 min	2:30 – 3:30	65 – 75D	4,500	11	200,000	0.6	131 (55)
	IE-3030	White	100 / 92	150	10 – 20 min	2:45 – 3:15	65 – 75D	4,950	24	145,000	0.6	149 (65)
	IE-3031	White	100 / 91	150	7:30 – 12:30 min	1:30 – 2:30	70 – 80D	5,000	20	270,000	0.5	158 (70)
	IE-3040	White	70 / 100	300	1 – 2	4 – 6	55 – 65D	3,400	40	48,500	2.4	137 (58)
	IE-3050	White	100 / 92	150	25 – 35 min	4 – 7	65 – 75D	4,950	24	145,000	0.6	149 (65)
	IE-3065	Light Gray	100 / 97	thixotropic	30 – 60 min	4 – 8	65 – 75D	6,150	2	635,000	0.6	140 (60)
	IE-3067	White	100 / 91	thixotropic	15 – 25 min	2 – 4	65 – 75D	6,150	2	635,000	0.6	140 (60)
	IE-3068	White	100 / 100	150	2 – 4	10 – 16	70 – 80D	5,100	10	240,000	0.6	140 (60)
	IE-3070	White	100 / 92	150	30 – 50 min	6 – 10	65 – 75D	4,950	24	145,000	0.6	143 (62)
	IE-3071	White	100 / 92	150	1 – 3	15 – 20	65 – 75D	4,950	24	145,000	0.6	143 (62)
	IE-3072	Translucent	100 / 92	80	45 – 75	7 – 9	65 – 75D	4,500	11	200,000	0.6	140 (60)
	IE-3075	Translucent	100 / 89	300	30 – 90 min	6 – 10	75 – 85D	10,500	8	420,000	0.7	167 (75)
	IE-3076	Translucent	100 / 89	300	1 – 3	10 – 15	75 – 85D	10,500	8	420,000	0.7	171 (77)
	IE-3077	Translucent	100 / 94	100	20 – 40 min	4 – 6	70 – 80D	7,000	10	267,000	0.6	131 (55)
IE-3080	Translucent	100 / 94	100	45 – 75 min	7 – 9	65 – 75D	4,500	11	200,000	0.6	131 (55)	

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CLASSIC IE™ SERIES SHORE D	IE-3081	Translucent	100 / 94	100	2 – 4	20 – 30	65 – 75D	4,500	11	200,000	0.6	131 (55)
	IE-3082	Translucent ¹⁾	100 / 94	100	6 – 10	50 – 70	65 – 75D	4,500	11	200,000	0.6	131 (55)
	IE-3090	Translucent	100 / 90	100	45 – 75 min	7 – 9	70 – 80D	8,300	3	218,000	0.7	130 (55)
InnoTooling™ Rigid Urethane Plastic	IE-3642	Translucent Amber	100 / 25	3,000	4 – 8	20 – 30	75 – 85A	1,000	185	–	6.0	–
	IE-3643	Amber	100 / 34	5,000	3 – 5	20 – 30	90 – 96A	1,500	113	–	–	–
	IE-3644	Translucent Amber	100 / 50	2,750	4 – 8	20 – 30	50 – 60D	3,000	100	45,000	9.0	–
	IE-3645	Translucent Amber	100 / 51	2,750	10 – 20 min	1:15 – 1:45	50 – 60D	3,000	100	45,000	9.0	–
	IE-3648	Translucent Amber	100 / 60	1,575	4 – 8	14 – 18	57 – 67D	4,900	40	90,000	4.0	–
	IE-3660	Translucent Amber	100 / 12	2,200	2 – 4	9 – 13	40 – 50D	2,100	250	25,000	–	–
	IE-3665	Translucent Amber	100 / 20	2,000	2 – 4	10 – 14	45 – 55D	2,300	275	45,000	10.0	–
	IE-3940	Clear / Yellow	100 / 20	5,000	4 – 8	15 – 25	35 – 45D	2,000	180	–	–	–
	IE-3960	Clear / Yellow	100 / 40	3,300	3 – 7	14 – 20	50 – 60D	3,250	185	50,000	14.0	–
	IE-3980	Clear / Yellow	100 / 20	2,950	4 – 8	15 – 25	75 – 85A	1,100	275	–	–	–

1) Translucent in thin sections. 2) See technical data sheets for electrical properties. 3) Various colors are also available

	Product	Color	Mix ratio (pbw) Isocyanate / Polyol	Mix Viscosity Hardener at 77°F (25°C) cP ASTM D-2393	Demold time at 77°F (25°C) h	Density at 77°F g/cm ³ ASTM D-792	Density at 77°F lb/ft ³ ASTM D-792					
Urethane Liquid Plastic Foam	FM-7004	Light Tan	100 / 88	250	5 – 15 min	0.064 – 0.080	4 – 5					
	FM-7125	Black	100 / 62	2,600	10 – 20 min	0.384 – 0.481	24 – 30					
	FM-7110	Off-White	100 / 100	1,000	15 – 25 min	0.144 – 0.192	9 – 12					
	FM-7204	Light Tan	100 / 88	250	5 – 15 min	0.040 – 0.080	4 – 5					
	FM-7206	Light Tan	100 / 91	250	5 – 15 min	0.080 – 0.120	5 – 6					
	FM-7020	Light Tan	100 / 97	250	5 – 15 min	0.388 – 0.471	25 – 30					
	FM-7025	Light Tan	100 / 90	250	20 – 40 min	0.032 – 0.048	2 – 3					
	FM-7026	Light Tan	100 / 90	250	5 – 15 min	0.032 – 0.048	2 – 3					
	FM-7045	Light Tan	100 / 97	250	10 – 20 min	0.064 – 0.080	4 – 5					
	FM-7046	Light Tan	100 / 97	250	15 – 25 min	0.080 – 0.096	5 – 6					
	FM-7050	White	100 / 80	300	20 – 30 min	0.064 – 0.080	4 – 5					
	FM-7080	Light Tan	100 / 97	250	10 – 20 min	0.128 – 0.176	8 – 11					

1) Translucent in thin sections. 2) See technical data sheets for electrical properties. 3) Various colors are also available