

## 20A System

Soft, flexible polyurethane / polyether based elastomer

### Key Properties

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

### Applications

- For hand-batch processing

### Processing Properties

			Resin (Isocyanate)	Hardener (Polyol)
Mix ratio		pbw	100	100
		pbv	100	98
Density	ASTM D-792	g/cm <sup>3</sup>	ca. 1.05	ca. 1.07
Viscosity at 77°F (25°C)	ASTM D-2393	cP	ca. 200	ca. 1,500

			Mixture
Mix viscosity at 77°F (25°C)	ASTM D-2393	cP	ca. 600
Gel time at 77°F (25°C)		min	10-14
Demold time at 77°F (25°C)		h	3-5

### Cured / Mechanical Properties (approximate values)

#### Cure 1: 7 days at 77°F

			Cure 1
Aspect	visual		Cream
Density	ASTM D-792	g/cm <sup>3</sup>	1.06
Shore hardness A	ASTM D-2240		5-15
Tensile strength	ASTM D-638	psi	200
Elongation at Break	ASTM D-638	%	175
Tear strength	ASTM D-624	pli	25
Linear shrinkage	ASTM D-2566	in/in	0.001-0.003

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

IE-3220 may be inhibited by certain silicone rubbers. We recommend that a test sample be prepared to verify compatibility. Contact RAMPF Group Inc. for more information. IE-3220 is also susceptible to moisture contamination. We recommend the casting be completely encapsulated to avoid tackiness of any surface exposed to the air.

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

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### Packaging

IE-3220 Quart Kit	4 lbs.
IE-3220 1 Gal. Kit	16 lbs.
IE-3220 5 Gal. Kit	80 lbs.
IE-3220 Drum Kit	900 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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