

50A Polyether

Elastic Polyether system

© RAMPF Tooling Solutions GmbH & Co. KG

PC - Rev.-Status: 01- 2018/09/03

Page 1 of 2

Key Properties

- Excellent physical properties after RT cure
- Free of mercury, MOCA or TDI
- Ideal for color matching due to its neutral color

Applications

- For hand-batch processing

Processing Properties

			Resin (Isocyanate)	Hardener (Polyol)
Mix ratio		pbw	40	100
		pbv	38	100
Density	ASTM D-792	g/cm ³	ca. 1.13	ca. 1.09
Viscosity at 77°F (25°C)	ASTM D-2393	cP	ca. 75	ca. 1,400

			Mixture
Mix viscosity at 77°F (25°C)	ASTM D-2393	cP	ca. 800
Gel time at 77°F (25°C)		min	20-30
Demold time at 77°F (25°C)		h	12-20

Cured / Mechanical Properties (approximate values)

			Cure 1	Cure 2
Cure 1: 24 hours at 77°F + 16 hours at 150°F				
Cure 2: 7 days at 77°F				
Aspect	visual		Off-white	Off-white
Density	ASTM D-792	g/cm ³	1.09	1.09
Shore hardness A	ASTM D-2240		45-55	45-55
Tensile strength	ASTM D-638	psi	900	1,100
Elongation at Break	ASTM D-638	%	520	520
Tear strength	ASTM D-624	pli	120	90
Linear shrinkage	ASTM D-2566	in/in	0.001-0.004	0.001-0.004

50A Polyether

Elastic Polyether system

Processing

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

Due to a color variation with a hardener raw material, the color of this system may vary slightly. The natural color is very light, and is easily pigmented to overcome any variation.

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

Packaging

IE-3252 Quart Kit	2.8 lbs.
IE-3252 1 Gal. Kit	11.2 lbs.
IE-3252 5 Gal. Kit	56 lbs.
IE-3252 Drum Kit	630 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.
