

## High Impact / Polypropylene / Fast

Tough, impact resistant elastomer

### Key Properties

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

### Applications

- Formulated for room temperature meter-mix dispensing systems and short mold cycle times

### Processing Properties

			Resin (Isocyanate)	Hardener (Polyol)
Mix ratio		pbw	100	89
		pbv	100	100
Density	ASTM D-792	g/cm <sup>3</sup>	ca. 1.20	ca. 1.07
Viscosity at 77°F (25°C)	ASTM D-2393	cP	ca. 500	ca. 1,000

			Mixture
Mix viscosity at 77°F (25°C)	ASTM D-2393	cP	ca. 900
Gel time at 77°F (25°C)		sec	50-70
Demold time at 77°F (25°C)		min	10-15

### Cured / Mechanical Properties (approximate values)

			Cure 1	Cure 2
<b>Cure 1: 24 hours at 77°F + 16 hours at 150°F</b>				
<b>Cure 2: 7 days at 77°F</b>				
Aspect	visual		Off-white	Off-white
Density	ASTM D-792	g/cm <sup>3</sup>	1.05	1.05
Shore hardness D	ASTM D-2240		75-85	75-85
Deflection temperature, HDT (66psi)	ASTM D-648	°F (°C)	149 (65)	140 (60)
Tensile strength	ASTM D-638	psi	6,500	6,700
Tensile modulus	ASTM D-638	psi	250,000	300,000
Elongation at Break	ASTM D-638	%	5	5
Flexural strength	ASTM D-790	psi	7,500	8,700
Flexural modulus	ASTM D-790	psi	165,000	175,000
Notched Izod	ASTM D-256	ft-lbf/in	2.6	3.0
Linear shrinkage	ASTM D-2566	in/in	0.001-0.005	0.001-0.005

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### Processing

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

To ensure an adequate mix has been established during meter mixing this material, it is recommended that a 3/8 x 40 mix tube is used.

The components can freeze when stored or shipped in temperatures below 32°F. In the event your system freezes, call your RAMPF Group Inc. representative to discuss reconstitution methods.

Depending on the wall section of the piece or the cure cycle you are using, the final color of the material can also change from a clear translucent to white. In both cases, pigmentation can easily overcome this discoloration.

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

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### Packaging

RC-0200 Quart Kit	3.78 lbs.
RC-0200 1 Gal. Kit	15.12 lbs.
RC-0200 5 Gal. Kit	75.60 lbs.
RC-0200 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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