

60A / Excellent Green Strength / 10 Min. Gel / Black

60 shore A polyurethane elastomer

Key Properties

- Excellent physical properties after RT cure
- Free of mercury, MOCA or TDI
- Excellent green strength for quick demold times

Applications

- For hand-batch processing, vacuum assisted processing or meter mix dispensed

Processing Properties

			Resin (Isocyanate)	Hardener (Polyol)
Mix ratio		pbw	52	100
		pbv	50	100
Density	ASTM D-792	g/cm ³	ca. 1.18	ca. 1.13
Viscosity at 77°F (25°C)	ASTM D-2393	cP	ca. 900	ca. 500

			Mixture
Mix viscosity at 77°F (25°C)	ASTM D-2393	cP	ca. 850
Gel time at 77°F (25°C)		min	8-12
Demold time at 77°F (25°C)		min	45-75

Cured / Mechanical Properties (approximate values)

			Cure 1	Cure 2
Cure 1: 24 hours at 77°F + 1 hour at 150°F				
Cure 2: 7 days at 77°F				
Aspect	visual		Black	Black
Density	ASTM D-792	g/cm ³	1.13	1.13
Shore hardness A	ASTM D-2240		55-65	55-65
Tensile strength	ASTM D-638	psi	350	325
Elongation at Break	ASTM D-638	%	140	100
Tear strength	ASTM D-624	pli	40	40
Linear shrinkage	ASTM D-2566	in/in	0.001-0.003	0.001-0.003

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Processing

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

For best results, place the poured tool into a pressure vessel and pressurize to 60 psi until cured.

This material will slightly darken as it ages. The hardener contains black pigment that will settle out of solution.

Agitate Hardener and Resin before mixing to ensure a homogenous formulation.

Packaging

VA-1615 Quart Kit	3.04 lbs.
VA-1615 1 Gal. Kit	12.16 lbs.
VA-1615 5 Gal. Kit	60.8 lbs.
VA-1615 Drum Kit	684 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.
