

## 90A / Excellent Green Strength / 10 Min. Gel.

90 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	100	100
		pbv	95	100
Density	ASTM D-792	g/cm <sup>3</sup>	ca. 1.16	ca. 1.10
Viscosity at 77°F (25°C)	ASTM D-2393	cP	ca. 900	ca. 1,100

			Mixture
Mix viscosity at 77°F (25°C)	ASTM D-2393	cP	ca. 1,100
Gel time at 77°F (25°C)		min	8-12
Demold time at 77°F (25°C)		min	60-120

### Cured / Mechanical Properties (approximate values)

			Cure 1	Cure 2
<b>Cure 1: 24 hours at 77°F + 1 hour at 150°F</b>				
<b>Cure 2: 7 days at 77°F</b>				
Aspect	visual		Neutral Tan	Neutral Tan
Density	ASTM D-792	g/cm <sup>3</sup>	1.10	1.10
Shore hardness A	ASTM D-2240		85-95	85-95
Tensile strength	ASTM D-638	psi	1,200	1,250
Elongation at Break	ASTM D-638	%	75	65
Tear strength	ASTM D-624	pli	140	130
Linear shrinkage	ASTM D-2566	in/in	0.002-0.005	0.002-0.005

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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. It is not recommended that custom color-matching be incorporated into this system due to this slight color change that transpires.

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

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### Packaging

VA-1910 Quart Kit	4 lbs.
VA-1910 1 Gal. Kit	16 lbs.
VA-1910 5 Gal. Kit	80 lbs.
VA-1910 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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