

RapidVac™ VA-1615

Polyurethane Thermoset Elastomer

Innovative Polymers, Inc.

Message:

VA-1615 is a 60 shore A polyurethane elastomer formulated for hand-batch processing, vacuum assisted processing or meter mix dispensed. Excellent physical properties can be obtained with a room temperature cure without the utilization of mercury. MOCA, or TDI. VA-1615 has excellent green strength for quick demold times.

General Information			
Features	Good Green Strength		
RoHS Compliance	RoHS Compliant		
Appearance	Black		
Processing Method	Vacuum Casting		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
Cured	1.13	g/cm ³	
Hardener	1.13	g/cm ³	
Base Resin	1.18	g/cm ³	
Molding Shrinkage - Flow	0.10 to 0.30	%	ASTM D2566
Thermoset	Nominal Value	Unit	Test Method
Thermoset Components			
	Mix Ratio by Volume: 100		
Hardener	Mix Ratio by Weight: 100		
	Mix Ratio by Weight: 52		
Resin	Mix Ratio by Volume: 50		
Demold Time	45 to 75	min	
Uncured Properties	Nominal Value	Unit	Test Method
Viscosity			
25°C ¹	0.50	Pa · s	
25°C ²	0.85	Pa · s	
25°C ³	0.90	Pa · s	
Curing Time ⁴	25	hr	
Gel Time	8.0 to 12	min	
Cured Properties	Nominal Value	Unit	Test Method
Shore Hardness (Shore A)	55 to 65		ASTM D2240
Tensile Strength	2.41	MPa	ASTM D638

Tensile Elongation at Break	140	%	ASTM D638
Tear Strength	7.01	kN/m	ASTM D624
NOTE			
1.	Hardener		
2.	Mixed		
3.	Resin		
4.	24 hours at 77°F + 1 hour at 150°F		

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