

RapidVac™ VA-1605

Polyurethane Thermoset Elastomer

Innovative Polymers, Inc.

Message:

VA-1605 is a 60 shore A 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-1605 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 | 20 to 40 | 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 | 3.0 to 5.0 | 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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