

Innothane® IE-65D

Polyurethane Thermoset Elastomer

Innovative Polymers, Inc.

Message:

IE-65D is a tough, impact resistant elastomer formulated for room temperature hand-batch processing. Excellent physical properties can be obtained with a room temperature cure without the utilization of mercury, MOCA, or TDI.

General Information			
Features	Good Impact Resistance		
	Good Toughness		
RoHS Compliance	RoHS Compliant		
Appearance	Amber		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
Hardener	1.06	g/cm ³	
Cured	1.08	g/cm ³	
Base Resin	1.09	g/cm ³	
Molding Shrinkage - Flow	0.10 to 0.30	%	ASTM D2566
Mechanical	Nominal Value	Unit	Test Method
Flexural Modulus	241	MPa	ASTM D790
Flexural Strength	13.1	MPa	ASTM D790
Thermoset	Nominal Value	Unit	Test Method
Thermoset Components			
	Mix Ratio by Volume: 20		
Hardener	Mix Ratio by Weight: 20		
	Mix Ratio by Weight: 100		
Resin	Mix Ratio by Volume: 100		
Demold Time	120 to 240	min	
Additional Information	Nominal Value	Unit	Test Method
Peak Exotherm - 200g mass	57	°C	
Uncured Properties	Nominal Value	Unit	Test Method
Viscosity			
25°C ¹	0.10	Pa·s	
25°C ²	2.0	Pa·s	
25°C ³	3.0	Pa·s	

Curing Time ⁴	40	hr	
Gel Time	10 to 14	min	
Cured Properties	Nominal Value	Unit	Test Method
Shore Hardness (Shore D)	45 to 55		ASTM D2240
Tensile Strength	16.5	MPa	ASTM D638
Tensile Elongation at Break	210	%	ASTM D638
NOTE			
1.	Hardener		
2.	Mixed		
3.	Resin		
4.	24 hours at 77°F + 16 hours at 180°F		

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