

Hapflex™ 650

Thermoplastic

Hapco Inc.

Message:

The Hapflex 500 series offers a full range of soft durometers, from 45 - 95 Shore A, while the Hapflex 600 series yields harder durometers on the Shore D scale ranging from 50 - 70 Shore D. All are relatively fast, room curing, flexible systems that do not require post curing, but can be accelerated with moderate heat for faster curing. Most Hapflex 500 & 600 products are offered in 2 speeds: a standard 30-45 minute working time, and a 3-6 minute working time for fast demold.

The Hapflex elastomers are low viscosity, making them easy to handle and pour, yet still provide precise duplications of surface details surface finishes. In addition, the Hapflex elastomers are virtually shock resistant and unbreakable, making them exceptionally well suited for permanent molds, parts or master patterns that will not crack or chip during use or storage. A major advantage is the superior abrasion resistance properties of the Hapflex elastomers.

Precision tracing patterns, roll coverings, fixtures, flexible parts, forming dies, bending tools, and a variety of foundry applications are just a few examples of Hapflex applications.

Available in Flame Retardant

General Information			
Features	Fast Cure		
	Good Abrasion Resistance		
	Good Flexibility		
	Good Toughness		
	Low Shrinkage		
	Low Viscosity		
	Moisture Resistant		
	Shock Resistant		
Uses	Gaskets		
	Liners		
	Molds/Dies/Tools		
	Patterns		
	Rollers		
Appearance	Black		
Forms	Liquid		
Processing Method	Casting		
	Machining		
	Thermoforming		
	Vacuum Casting		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.01	g/cm ³	ASTM D4669
Molding Shrinkage - Flow	0.10 to 0.30	%	ASTM D2566
Weight - per cubic inch	17	g	

Gel Time ¹ (25°C)	25.0	min	ASTM D2971
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	50		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	103	MPa	ASTM D638
Tensile Strength	19.3	MPa	ASTM D638
Tensile Elongation (Break)	260	%	ASTM D638
Flexural Modulus	80.7	MPa	ASTM D790
Flexural Strength	5.79	MPa	ASTM D790
Elastomers	Nominal Value	Unit	Test Method
Tear Strength ²	62.3	kN/m	ASTM D624
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	75	J/m	ASTM D256
Unnotched Izod Impact	230	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (0.45 MPa, Unannealed)	106	°C	ASTM D648
Thermoset	Nominal Value	Unit	Test Method
Thermoset Components			
Part A	Mix Ratio by Weight: 100, Mix Ratio by Volume: 100		
Part B	Mix Ratio by Weight: 85, Mix Ratio by Volume: 90		
Thermoset Mix Viscosity (25°C)	870	cP	ASTM D4878
Demold Time (21°C)	120 to 300	min	Internal Method
NOTE			
1.	100 g		
2.	Die C		

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