



Product Name

HP-60 Polyurethane



Description

HP-60 is a tough, abrasion resistant elastomer formulated for vacuum-assisted casting machines. Excellent physical properties can be obtained with a room temperature cure without the utilization of mercury, MOCA, or TDI.

Physical Properties

Mix Ratio	Resin:Hardener (parts by weight)		100:50	
Mix Ratio	Resin:Hardener (parts by volume)		100:50	
Viscosity (cps@77°F)	Resin	6400	Gel Time	13 ± 2 Minutes
	Hardener	50	Demold Time*	90 ± 30 Minutes
	Mixed	1800	Color	Amber
Specific Gravity (g/cc)	Resin	1.07	* Demold time is always mass dependant	
	Hardener	1.07		

Cure 1 ▶ 7 days at 77°F
Cure 2 ▶ N/A

Cured Properties

	Method	Cure 1	Cure 2
Hardness (shore A)	ASTM D-2240	55 ± 5	
Tensile Strength (psi)	ASTM D-638	650	
Elongation at Break	ASTM D-638	450%	
Tear Strength (pli)	ASTM D-624	135	
Linear Shrink (in./in.)	ASTM D-2566	0.003	
Specific Gravity (g/cc)		1.11	

Processing Notes

Preheating the tool to 150 °F will greatly enhance the de-mold time of this material. Additionally, preheating the material will reduce the viscosity, but will also reduce the gel time.

Agitate the hardener and resin before use to ensure that the formula is homogeneous.

Safety and Handling

DO NOT USE UNTIL MSDS HAVE BEEN READ AND UNDERSTOOD. Store containers in a dry location. Partially used containers should be blanketed with dry nitrogen to prevent moisture contamination. Moisture will react with the resin component, creating carbon dioxide gas and a possible pressure increase in the container.

SPECIFICATION WRITERS: The above values are meant to represent typical properties only. Users are encouraged to qualify products in their own laboratories prior to specification publication.

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