PRODUCT INFORMATION

Formulated Systems

TECHNICAL DATASHEET
4/15/2011

DURAMOULD ET 30A

Introduction

DURAMOULD™ ET 30A is a polyol based curative which reacts with DURAMOULD 5234 Isocyanate prepolymer to produce a low hardness polyurethane elastomer with high extensibility. The product has good moisture tolerance and can be used to take masters from stone, plaster etc. The product can also be used as a sealant or grouting compound in a variety of different applications.

Component Properties

Polyol Component

Product Reference	DURAMOULD ET 30A
Appearance	Amber Liquid at 25 °C
Viscosity	100 - 300 cps at 25 °C
Specific Gravity	1 – 1.04 at 25 °C

Isocyanate Component

Product Reference	DURAMOULD 5234 Isocyanate
Appearance	Pale Straw Liquid at 25 °C
Viscosity	4000 - 10000 cps at 25 °C
Specific Gravity	1.04 – 1.06 at 25 °C

Mixed System

Mixing Ratio	0.7 : 1 by weight (Polyol : Isocyanate)
Gel Time	15′ 0″ – 25′ 0″ (100 gms at 25 °C)

Cured System – Typical Properties

Property	Test Method	Value	Unit
Shore Hardness	BS EN ISO 868	30	°A
Tensile Strength	BS 903 Pt A2	2.2	MPa
Elongation at Break	BS 903 Pt A2	>1000	%
100% Modulus	BS 903 Pt A2	0.6	MPa
Angle Tear Strength	BS 903 Pt A3	16	N/mm
Split Tear Strength	ASTM D470	4	N/mm

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Processing Details

The following information is given as a guide to processing this product. It is recommended that optimum conditions for a specific application are determined experimentally. Our Technical Service Department can offer more detailed advice.

Recommended Processing Temperatures

Polyol Component	20 – 30 °C
Isocyanate Component	20 – 30 °C

Recommended Cure Cycle

Product will be fully cured within 24 - 72 hours at room temperature (25 °C). However, moulds should not go into service for 5 - 7 days.

Additional Processing Details

Material should be processed through suitable two-component dispensing machinery. Our Technical Service Department can advise on choice of equipment for this product. For improved adhesion to a range of substrates suitable primers can be recommended.

Storage and Handling

		Shelf life
Polyol Component	Store in tightly sealed containers at a temperature of 0 - 30 °C. Raise to the processing temperature and mix well before use. Avoid contact with moisture.	12 months
Isocyanate Component	Store in tightly sealed containers at a temperature of 0 - 30 °C. Avoid contact with moisture. Storage below the recommended minimum temperature may result in freezing of the Isocyanate. If the Isocyanate does not fully melt out when raised to the processing temperature it may be necessary to re-melt at a temperature of 60 - 70 °C following the procedures laid down in the information sheet 'ISOCYANATES - HAZARDS AND SAFE HANDLING PROCEDURES'.	12 months

More detailed information on the storage and handling of polyurethane components can be obtained by contacting our Technical Service Department.

Packaging

Polyol Component	25 Kgs, 200 Kgs
Isocyanate Component	25 Kgs, 207 Kgs

Safety Considerations Customer should refer to the Dow product Material Safety Data Sheet (MSDS) to understand the hazards of the product and safe handling guidance.

Customer Notice Dow encourages its customers to review their applications of Dow products from the standpoint of human health and environmental quality. For further information about safety considerations for your product/application, please contact your Dow Sales representative.

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