

# RapidVac™ VA-254

Polyurethane Thermoset Elastomer

Innovative Polymers, Inc.

Message:

VA-254 is a 80 shore D polyurethane formulated for hand-batch, vacuum assisted or meter mix equipment. Excellent physical properties can be obtained with a room temperature cure without the utilization of mercury, MOCA, or TDI. VA-254 has excellent green strength for good demold characteristics.

General Information			
Features	Durable		
	General Purpose		
	Good Green Strength		
	Good Mold Release		
Uses	General Purpose		
RoHS Compliance	RoHS Compliant		
Appearance	White		
Processing Method	Vacuum Casting		
Physical	Nominal Value	Unit	
Specific Gravity			
Hardener	1.12	g/cm <sup>3</sup>	
Cured	1.15	g/cm <sup>3</sup>	
Base Resin	1.25	g/cm <sup>3</sup>	
Mechanical	Nominal Value	Unit	Test Method
Flexural Modulus	2210	MPa	ASTM D790
Flexural Strength	96.5	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	59	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	100	°C	
1.8 MPa, Unannealed	95.0	°C	
Thermoset	Nominal Value	Unit	Test Method
Thermoset Components			
Mix Ratio by Volume: 56			
Hardener	Mix Ratio by Weight: 50		

Mix Ratio by Weight: 100

Resin	Mix Ratio by Volume: 100		
Demold Time	60 to 120	min	
Uncured Properties	Nominal Value	Unit	Test Method
Viscosity			
25°C <sup>1</sup>	0.20	Pa·s	
25°C <sup>2</sup>	0.35	Pa·s	
25°C <sup>3</sup>	1.1	Pa·s	
Curing Time <sup>4</sup>	28	hr	
Gel Time	4.0 to 6.0	min	
Cured Properties	Nominal Value	Unit	Test Method
Shore Hardness (Shore D)	75 to 85		ASTM D2240
Tensile Strength	56.5	MPa	ASTM D638
Tensile Elongation at Break	7.0	%	ASTM D638
NOTE			
1.	Resin		
2.	Mixed		
3.	Hardener		
4.	24 hours at 77°F + 4 hours at 180°F		

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