# Hapflex™ 673

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.

| 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 | Red |
| Forms | Liquid |
| Processing Method | Casting |
| | Machining |
| | Thermoforming |
| | Vacuum Casting |

| Physical | Nominal Value | Unit | Test Method |
|---|---|---|---|
| Specific Gravity | 1.06 | g/cm³ | ASTM D4669 |
| Molding Shrinkage - Flow | 0.10 to 0.30 | % | ASTM D2566 |
| Weight - per cubic inch | 17 | g | |
| Gel Time [1] (25°C) | 18.0 | min | ASTM D2971 |

| Hardness | Nominal Value | Unit | Test Method |
|---|---|---|---|
| Durometer Hardness (Shore D) | 70 | | ASTM D2240 |
| **Mechanical** | **Nominal Value** | **Unit** | **Test Method** |
| Tensile Modulus | 376 | MPa | ASTM D638 |
| Tensile Strength | 32.3 | MPa | ASTM D638 |
| Tensile Elongation (Break) | 87 | % | ASTM D638 |
| Flexural Modulus | 393 | MPa | ASTM D790 |
| Flexural Strength | 25.6 | MPa | ASTM D790 |
| **Elastomers** | **Nominal Value** | **Unit** | **Test Method** |
| Tear Strength [2] | 116 | kN/m | ASTM D624 |
| **Impact** | **Nominal Value** | **Unit** | **Test Method** |
| Notched Izod Impact | 120 | J/m | ASTM D256 |
| Unnotched Izod Impact | No Break | | ASTM D256 |
| **Thermal** | **Nominal Value** | **Unit** | **Test Method** |
| Deflection Temperature Under Load | | | ASTM D648 |
| 0.45 MPa, Unannealed | 133 | °C | |
| 1.8 MPa, Unannealed | 124 | °C | |
| **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: 65, Mix Ratio by Volume: 60 | | |
| Thermoset Mix Viscosity (25°C) | 2000 | cP | ASTM D4878 |
| Demold Time (21°C) | 60 to 120 | min | Internal Method |
| **NOTE** | | | |
| 1. | 100 g | | |
| 2. | Die C | | |



## Recommended distributors for this material

### Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China