

Innothane® IE-65D

Polyurethane Thermoset Elastomer

Innovative Polymers, Inc.

Message:

IE-65D is a tough, impact resistant elastomer formulated for room temperature hand-batch processing. Excellent physical properties can be obtained with a room temperature cure without the utilization of mercury, MOCA, or TDI.

General Information			
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Features	Good Impact Resistance Good Toughness		
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RoHS Compliance	RoHS Compliant		
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Appearance	Amber		
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Physical	Nominal Value	Unit	Test Method
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Specific Gravity			
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Hardener	1.06	g/cm ³	
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Cured	1.08	g/cm ³	
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Base Resin	1.09	g/cm ³	
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Molding Shrinkage - Flow	0.10 to 0.30	%	ASTM D2566
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Mechanical	Nominal Value	Unit	Test Method
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Flexural Modulus	241	MPa	ASTM D790
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Flexural Strength	13.1	MPa	ASTM D790
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Thermoset	Nominal Value	Unit	Test Method
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Thermoset Components			
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	Mix Ratio by Volume: 20		
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Hardener	Mix Ratio by Weight: 20		
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	Mix Ratio by Weight: 100		
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Resin	Mix Ratio by Volume: 100		
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Demold Time	120 to 240	min	
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Additional Information	Nominal Value	Unit	Test Method
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Peak Exotherm - 200g mass	57	°C	
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Uncured Properties	Nominal Value	Unit	Test Method
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Viscosity			
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25°C ¹	0.10	Pa·s	
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25°C ²	2.0	Pa·s	
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25°C ³	3.0	Pa·s	
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Curing Time ⁴	40	hr	
Gel Time	10 to 14	min	
Cured Properties	Nominal Value	Unit	Test Method
Shore Hardness (Shore D)	45 to 55		ASTM D2240
Tensile Strength	16.5	MPa	ASTM D638
Tensile Elongation at Break	210	%	ASTM D638

NOTE

1.	Hardener
2.	Mixed
3.	Resin
4.	24 hours at 77°F + 16 hours at 180°F

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