



**POLYCOAT
PRODUCTS**
A Division of American Polymers Corp.

GREATER LOS ANGELES-14722 Spring Avenue - Santa Fe Springs, CA 90670
DALLAS / FT.WORTH METROPLEX-2100 Reliance Parkway - Bedford, TX 76021

Tel: (562) 802-8834
Fax: (562) 921-7363

www.Polycoat.com

TECHNICAL DATA SHEET

PC 523-65A-M5-25M GREY

Typical Properties PC 523-65A-M5 A-COMP (ISO)

Viscosity, mPa-s @ 74°F: 800-1100
Specific Gravity @ 74°F : 1.20
Appearance @ 74°F: liquid

Typical Properties PC 523-65A-M5 B COMP (polyol blend)

Viscosity, mPa-s @ 74°F: 850-1000
Specific Gravity @ 74°F : 1.03
Appearance @ 74°F: viscous liquid

Product Description:

PC 523-65A-M5 elastomer is a two-component, one hundred percent solids, casting elastomer suitable for many casting applications. The ability to extend the gel time on these products allows for casting of extremely large parts.

PC 523-65A-M5 is designed for use as a general purpose casting material with good physical properties. The systems have been used for manufacturing concrete tooling and other large casting applications.

Storage and Handling:

Containers for both A and B components should be kept tightly closed to prevent moisture contamination. Do not reseal if contamination is suspected. Use of a dry nitrogen blanket for partial drums is recommended. Component B may be stored at ambient temperatures. Storage for Component A should be maintained between 77°F (25°C) and 95°F (35°C). For best results, this product should not be allowed to freeze, although it may be re-heated in a well ventilated oven for a period of time to re-liquefy solid particles. To avoid product degradation, product temperature during re-heating should not exceed 140°F (60°C). An additional note of caution is that exposure to temperatures over 400°F (204°C) can create excessive pressure potentially causing containers to rupture. Do not breathe aerosol or vapors and avoid contact with skin and eyes. Exposure to vapors of heated MDI can be dangerous. To heat product properly, use well ventilated convection ovens or other methods that distribute heat evenly. Avoid using drum heaters or other heat sources that may cause excessive local heating.

Health and Safety Information:

Appropriate literature has been assembled which provides information concerning the health and safety precautions that must be observed when handling any of the products listed above. Before working with these products, it is your responsibility to read and become familiar with the available information on its hazards, proper use and handling. This is extremely important and cannot be overemphasized. Information is available in several forms, e.g. material safety data sheets and product labels. To obtain this information, contact your Polycoat Products representative.

WARRANTY:

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Typical Physical Properties		74°	180°F
Hardness	Shore A	67	60A
	%		40
Resilience	Rebound	40	
Die C Tear Strength	PLI	160-200	120-140
Tensile Strength	PSI	1300-1500	800-900
Ultimate Elongation	%	230-280	160-190
Shrinkage in./in.		.015-.02	N/A
Density	pcf	62-67	62-67

Processing Characteristics

Mix ratio by weight A/B		35/65
Mix Ratio by Volume, A/B		1/2.02
A component temperature	°F	90-110
B Component temperature	°F	80-110
Mold temperature	°F	100-140
Gel time*, 74 °F	minutes	21-24
Gel time, 95-100 ° F	Minutes	12-14
Demold time	Minutes	~60
<i>*Variety of gel times available</i>		

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