



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

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www.Polycoat.com

PRODUCT DATA SHEET

PC 524-65A-M5-8M NATURAL

Typical Properties PC 524-65A-M5 A-COMP (ISO)

Viscosity, mPa-s @ 74°F: 900-1100
Specific Gravity @ 74°F : 1.20
Appearance @ 74°F: liquid

Typical Properties PC 524-65A-M5 B COMP (polyol blend)

Viscosity, mPa-s @ 74°F: 900-1000
Specific Gravity @ 74°F : 1.03
Appearance @ 74°F: viscous liquid

Product Description:

PC 524-65A 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 524-65A 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 75°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.

Typical Physical Properties		74°	
Hardness	Shore A	65	
	%		
Resilience	Rebound	45	
Die C Tear Strength	PLI	200-250	
Tensile Strength	PSI	1400-1800	
Ultimate Elongation	%	230-330	
Shrinkage in./in.		.015-.02	
Density	pcf	65-70	

Processing Characteristics

Mix ratio by weight A/B		35/65
Mix Ratio by Volume, A/B		31/69
A component temperature	°F	90-110
B Component temperature	°F	80-110
Mold temperature	°F	100-140
Gel time*, 74 °F	minutes	7.5-8.5
Gel time, 95-100 ° F	Minutes	4-5
Demold time	Minutes	~45
<i>*Variety of gel times available</i>		



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WARRANTY:

The information herein is believed to be accurate and reliable as of the date of issuance, but is subject to change without prior notice. It is up to the User to contact Polycoat Products to verify the correctness prior to ordering or specifying this product. Polycoat Products warrants this product for merchantable quality only, does not warranty against unknown risks that may or may not be present, nor do we assume any responsibility for coverage, performance, or injuries resulting from the use of this product. NO OTHER WARRANTY OR GUARANTEE OF ANY KIND IS MADE BY POLYCOAT PRODUCTS EXPRESSED OR IMPLIED, STATUTORY, BY OPERATION OR LAW, OR OTHERWISE, INCLUDING MARKETABILITY AND FITNESS FOR A PARTICULAR PURPOSE. Failure to strictly adhere to recommended procedures shall relieve Polycoat Products of all liability with respect to the product or the use thereof. The buyer assumes all risks whatsoever as to the use of these products and the Buyer's exclusive remedy as to any breach of warranty or negligence claim shall be limited to the purchase price of the materials and agrees that any and all litigation proceedings shall be according to the laws of California and shall be filed in the County of Santa Fe Springs, CA. Each person, firm, or corporation engaged in the application installation, disposal or any other use of the any of these products shall carefully determine whether there is a potential hazard associated with such product in a specific usage, and utilize all appropriate precautionary and safety measures as outlined in Local, State and Federal regulations governing the use or disposal of these products or the construction and/or renovation of structures.