



Silicone & Epoxy Technology

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Set-SIE 3025 Polyurethane Elastomer

Set-SIE 3025 is a rigid polyurethane formulated for room temperature hand-batch or vacuum-assisted casting methods. Excellent physical properties can be obtained with a room temperature cure without the utilization of mercury, MOCA or TDI. **Set-SIE 3025** has a very low mixed viscosity. It is ideal for color-matching due to its neutral semi-transparent appearance.

TYPICAL PROPERTIES:

Resin/Hardener ratio (Parts by Weight)	100/94
Resin/Hardener ratio (Parts by Volume)	100/100
Resin viscosity (@ 77° F.)	40cps
Hardener viscosity (@ 77° F.)	250 cps
Initial mixed viscosity	100 cps
Working life (@ 77° F.)	3 ± .50 Min.
Color	Translucent
Demold time	30 ± 10 Min.
Ultimate cure @ 77° F.	7 days
Specific Gravity (Hardener)	1.15 (gm/cc)
(Resin)	1.08 (gm/cc)
(Mixed)	1.08 (gm/cc)

CURED PROPERTIES

	<u>Test Method</u>	<u>7 Days @ 77° F.</u>
Hardness	ASTM D-2240	70-75 D
Tensile Strength	ASTM D-638	4500 psi
Elongation at Break		11 %
Notched Izod	ASTM D-256	0.6 ft.lbs/in.
Linear Shrinkage	ASTM D-2566	0.005-0.010 in./in.
Ultimate Flex Strength	ASTM D-790	7800 psi
Flex Modulus	ASTM D-790	200,000 psi
Heat Deflection Temp (66psi)	ASTM D-648	60°C/140° F
Heat Deflection Temp (264psi)	ASTM D-648	55°C/131° F

Agitate hardener and resin before mixing to ensure that the formula is homogeneous.

Read Warranty on Back of Technical Data Sheet.

Warranty

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