

Innothane®

Product Name

IE-3025
70 Shore D Translucent

Description

IE-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. IE-3025 has a very low mixed viscosity. It is ideal for color-matching due to its neutral semi-transparent appearance. Contact your Innovative representative to find out more about custom color-matching services.

Physical Properties

Mix Ratio	Resin:Hardener (parts by weight)		100:94	
Mix Ratio	Resin:Hardener (parts by volume)		100:100	
Viscosity (cps@77°F)	Resin	40	Gel Time	3 ± .5 Minutes
	Hardener	250	Demold Time*	30 ± 10 Minutes
	Mixed	100	Color	Translucent
Specific Gravity (g/cc)	Resin	1.10	* Demold time is always mass dependant	
	Hardener	1.03		
Peak Exotherm	200 g.	240°F		

Cured Properties

Cure 1 ► 7 days at 77°F



	Method	Cure 1
Hardness (shore D)	ASTM D-2240	70 ± 5
Tensile Strength (psi)	ASTM D-638	4,500
Elongation at Break	ASTM D-638	11%
Ultimate Flex Strength (psi)	ASTM D-790	7,800
Flexural Modulus (psi)	ASTM D-790	200,000
Notched Izod (ft.lbs./in.)	ASTM D-256	0.6
Linear Shrink (in./in.)	ASTM D-2566	.005-.010
Heat Deflection Temp. (66psi)	ASTM D-648	60°C / 140°F
Heat Deflection Temp. (264psi)	ASTM D-648	55°C / 131°F
Specific Gravity (g/cc)		1.08

Processing Notes

Formulated for hand-batch or vacuum assisted casting equipment. For best results, de-air the material prior to casting, then pressurize to 60 psi until cured.

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

<u>Kit Weights</u>	Quart Kit	1 Gal. Kit	5 Gal. Kit	Drum Kit
	3.88 lbs.	15.52 lbs.	77.6 lbs.	873 lbs.

Safety and Handling

DO NOT USE UNTIL MSDSs HAVE BEEN READ AND UNDERSTOOD. Store containers in a dry location. Partially used containers should be blanketed with dry nitrogen to prevent moisture contamination. Moisture will react with the resin component, creating carbon dioxide gas and a possible pressure increase in the container.

SPECIFICATION WRITERS: The above values are meant to represent typical properties only. Users are encouraged to qualify products in their own laboratories prior to specification publication.

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