

Typical Mixed Properties of Parts-In-Minutes Polyurethanes

		Gel Time, ASTM D-2471, sec.	Estimated Maximum Shoot Time, min.	Demold Time, min.	Color, Visual Resin	Hardener	Cured	Viscosity, ASTM D-2393, cP Resin	Hardener	Mix Ratio, Resin to Hardener, By wt.	By vol.
Elastomeric	RP 6473 Si R/H Clear Silicone	150-200 min.	3.0-5.0	24 hrs.	Clear	Clear	Clear	50,000	90	100:7	—
	RP 6481 R/H Shore 60-65A PUR	60-90	1.1-2.25	60	Lt. Yellow	Off-white	Natural	135	2,000	50:100	50:100
	RP 6482 R/H Shore 70-75A PUR	60-90	1.1-2.25	60	Amber	Off-white	Natural	45	1,700	50:100	50:100
	RP 6483 R/H Shore 80-85A PUR	60-120	1.1-3.0	60	Amber	Off-white	Natural	45	2,200	50:100	50:100
	RP 6484 R/H Shore 90-95A PUR	60-120	1.1-3.0	60	Amber	Off-white	Natural	45	2,100	67:100	67:100
Low Flexural Modulus	RP 6457 R/H Shore 65D Large Part PUR	90-120	2.25-3.0	60-120	Dk. Brown	Cream	Buff	170	750	53:100	50:100
	RP 6480 R/H Rigid PUR Foam	100	2.5	30-60	Dk. Brown	Clear	Yellow	170	440	100:100	85:100
	RP 6487 R/H Ultra High Impact, High HDT PUR	60-80	1.75	15-30	Lt. Amber	Dk. Amber	Dk. Amber	7,800	40	100:44	100:50
Medium Flexural Modulus	RP 6450 R/H 55-Second PUR	45-65	1.2-1.7	15-30	Dk. Brown	Cream	Buff	170	1,600	80:100	67:100
	RP 6451 R/H 75-Second PUR	65-85	1.7-2.2	20-45	Dk. Brown	Cream	Buff	170	1,600	80:100	67:100
	RP 6452 R/H High Impact PUR	50-70	1.25-1.75	15-30	Clear Amber	Cream	Off-white	30	1,600	80:100	67:100
	RP 6453-1 R/H Flame Retardant PUR	50-70	1.25-1.75	15-30	Amber	Cream	Buff	200	2,400	65:100	65:100
	RP 6456 R/H Shore 72D PUR	45-65	1.2-1.7	15-30	Dk. Brown	Cream	Buff	170	1,600	60:100	50:100
	RP 6459 R/H Shore 80D Clear PUR	180-240	4.5-6.0	120	Clear	Clear	Clear	1,200	1,200	100:100	100:100
	RP 6460 R/H High Heat PUR	45-65	1.2-1.7	15-30	Dk. Brown	Cream	Buff	170	1,500	80:100	67:100
	RP 6462 R/H Fast, High Impact, High Heat PUR	40-50	1.2-1.5	5	Brown	Black	Black	550	1,400	75:100	66:100
	RP 6463 R/H Slow, Crystal Clear PUR	18-25 min.		16 hrs.	Clear	Clear	Crystal Clear	280	700	100:100	100:100
	RP 6463 R/H Fast, Crystal Clear PUR	4-6min.	6-9	4hrs.	Clear	Clear	Crystal Clear	280	700	100:100	100:100
High Flexural Modulus	RP 6486 R/H Slow, Ultra High Impact PUR	7-8min.	10	2 hrs.	Lt. Amber	Amber	Amber	7,800	75	100:50	100:50
	RP 6486 R/H Fast, Ultra High Impact PUR	90-150	3	60	Lt. Amber	Amber	Amber	7,800	100	100:50	100:50
	RP 6454 R/H High Flexural Modulus PUR	45-65	1.2-1.7	15-30	Amber	Cream	Caramel	75	1,700	80:100	67:100
	RP 6455 R/H 2-Minute PUR	100-130	2.5-3.25	45-90	Dk. Brown	Cream	Caramel	170	1,800	80:100	67:100
	RP 6458 R/H Very High Flexural Modulus PUR	35-60	1.1-1.6	15-30	Amber	Clear	Clear Amber	75	400	100:85	100:100
	RP 6461 R/H 300°F Rigid PUR	45	1.2	60	Amber	Black	Black	30	2,150	100:85	100:100