

PROPERTIES	TEST METHOD	2380	2398	2456	2463	2501	
PHYSICAL PROPERTIES	Mix Ratio by volume A:B by weight A:B	Calculation 100:20 100:18	100:15 100:15	100:20 100:20	100:25 100:25	100:25 100:22	
	Gel time 100 grams @ 25°C	ASTM D-2971 27 min.	25 min.	25 min.	20 min.	32 min.	
	Color (cured)	Visual	clear / slight haze	clear / slight haze	clear / cloudy	clear / cloudy	clear / cloudy
	Hardness Shore Scale	ASTM D-2240 85 D	77 D	76 D	80 D ± 3	80 D ± 3	
	Viscosity mixed @ 25°C cps	ASTM D-4878	7,500 ±500	8,500 ±1,500	9,000 ±1,500	6,700 ±1,000	30,000 ±5,000
	Specific Gravity mixed @ 25°C	ASTM D-4669	1.10 1.09 1.10 1.11 1.10				
	Shrinkage inch/inch See shrinkage paragraph	ASTM D-2566	.0005-.002	.0005-.002	.0005-.002	.0005-.002	.0005-.002
	Demold time @ 70°F 1/8" thick (For faster demold times contact Hapco)	HAPCO TEST	6-12 hrs. or 2-4 hrs. @ 50°C	6-12 hrs. or 2-4 hrs. @ 50°C	6-12 hrs. or 2-4 hrs. @ 50°C	6-12 hrs. or 2-4 hrs. @ 50°C	6-12 hrs. or 2-4 hrs. @ 50°C
	Weight per cubic inch (lbs.)	Calculation	0.0397	0.0394	0.0397 0.0402	0.0397	
	PRODUCT PROPERTIES	Tensile Strength psi	ASTM D-638	8,000 4,000 3,500 7,500 4,900			
Elongation %		ASTM D-638	7 22.3		24.4	6 16	
Modulus of Elasticity psi (000)		ASTM D-638	400 145 144 370 26				
Izod Impact (Ft.lbs/inch) notched unnotched		ASTM D-256	0	0	0	0	0
			1.60	1.40	1.80	0.95	2.10
Heat Distortion Temperature (°C) 66 psi 264 psi		ASTM D-648	2	2	3	2	3
			3	2	0	0	8
			98°C	88°C	64°C	98°C	94°C
			94°C	64°C	52°C	93°C	80°C
Flexural Strength psi		ASTM D-790	10,500 4,850 4,300 10,300 7,100				
Flexural Modulus psi (000)	ASTM D-790	190 92 88 198 133					
Available in Flame Retardant (FR)	94V NA		NA	NA	NA	NA	
FDA Status (components may appear in one or more of these sections)	CFR CFR		Uses all FDA approved components per: 21.175.105 CFR 21.177.1680	21.175.300 CFR 21.177.2600			