

TECHTHANE[®] 325MG, 425MG, 620MG TDI POLYETHER REPOLYMERS**DESCRIPTION**

TECHTHANE 325MG, 425MG, and 620MG are medium-high performance TDI ether urethane prepolymers. When reacted with MBCA, they yield elastomers in the 81-95 Shore A hardness range. Notable characteristics of these elastomers are their high load bearing capacity, low temperature flexibility, excellent abrasion resistance, and good resistance to various environmental conditions and hysteresis. Typical applications include rolls, wheels, linings, belt cleaners, mining parts, slurry equipment, and seals.

PROPERTIES OF LIQUID PREPOLYMER

PROPERTY	325MG	425MG	620MG
Available Isocyanate Content	3.05-3.45	4.05-4.45	6.10-6.30
Liquid-Solid Transition Point, °F (°C)	60 (25)	60 (25)	50 (10)
Viscosity Brookfield, cps @ 110°F (45°C)	4,000	3,300	1,000
Viscosity Brookfield, cps @ 212°F (100°C)	400	300	150
Specific Gravity @ 75°F (24°C)	1.04	1.05	1.07
Specific Gravity @ 212°F (100°C)	0.97	0.98	1.00

PROPERTIES OF CURED ELASTOMER

PROPERTY	325MG	425MG	620MG
Hardness, Shore A (ASTM D2240)	81	88	93
Tensile Strength, psi (ASTM D412)	3,000	3,700	4,500
Elongation, % (ASTM D412)	550	410	310
100% Modulus, psi (ASTM D412)	800	1,100	1,505
300% Modulus, psi (ASTM D412)	1,400	2,900	4,300
Tear Strength, Die-C, pli (ASTM D624)	400	445	520
Tear Strength, Split, pli (ASTM D470)	80	100	135
Specific Gravity (ASTM D792)	1.06	1.11	1.13
Bell Brittle Point, °F (°C) (ASTM D746)	<-60 (-51)	<-60 (-51)	<-60 (-51)

PROCESSING SUMMARY (MBCA)

PROPERTY	325MG	425MG	620MG
MBCA level, pph, approximate	9.80	12.80	18.70
Prepolymer Temperature, °F (°C)	180 (82)	180 (82)	180 (82)
Mold Temperature, °F (°C)	212 (100)	212 (100)	212 (100)
MBCA temperature, °F (°C)	230 (110)	230 (110)	230 (110)
Pot Life, minutes	16	10	6
Cure Time @ 212°F (100°C), hours	1	1	1
Post Cure Time @ 180°F (80°C), hours	16	16	16

INFORMATION BASED ON 95% THEORY

PROCESSING

Thawing

Prepolymers will solidify at temperatures below their liquid/solid transition point. If solidified, thawing can normally be achieved by heating the container to a maximum of 130°F (55°C) using a melting oven, thermostatically-controlled blanket heater, or other uniform heating device (heat bands are not recommended) for a period of 12-24 hours. Re-blend thoroughly after thawing.

Re-blending

Prepolymers must be re-blended thoroughly prior to use to ensure homogeneity of the prepolymer. This is especially important if the prepolymer was exposed or even potentially exposed to cold temperatures or if less than the entire quantity in the container is to be used at one time. Re-blend prior to each use.

Degassing

Removal of any air which has become entrained in the prepolymer can normally be achieved either by heating the prepolymer to 160-180°F (71-82°C) for 15-20 minutes, or by application of vacuum and agitation. Either method is complete when the majority of air is removed.

Heating

Prepolymer and MBCA should be processed at recommended temperatures to achieve proper results. Heating of components at temperatures other than recommended can result in poor physical properties, poor surface finish, and incorrect hardness. Heating to alternate temperatures must only be done after prior testing has confirmed that desired results will be achieved.

Casting

To ensure optimum physical properties and surface finish, molds should be heated to or slightly higher than cure temperature. Application of mold release agents should be in accordance with manufacturer's guidelines.

Curing

Cure/Post Cure in accordance with guidelines on opposite page.

Note: If using curatives other than MBCA such as Ethacure® 300 or Techcure™ 915B, refer to curative manufacturer's suggested cure cycles.

AVAILABILITY

TECHTHANE prepolymers are packaged in 44 lb. (20 kg) pails and 451 lb. (205 kg) drums. Specific quantities and special packaging are available by request.

STORAGE AND SHELF LIFE

TECHTHANE prepolymers are packaged sealed under a dry nitrogen blanket. Containers should be kept in this condition and stored in a cool, dry area that is protected from direct sunlight until they are to be used. A container that has been opened should be resealed immediately, and if its contents are not to be used within 24 hours, it must be purged with dry nitrogen to prevent moisture contamination.

In the absence of heat and moisture, TECHTHANE prepolymers are stable and have a shelf life of a minimum of 1 year. In the presence of heat, however, the NCO of all prepolymers decreases, affecting their reactivity. The following is a summary of the maximum recommended time that prepolymers should be maintained at the given temperature without significant decrease in NCO:

TEMPERATURE	MAXIMUM STORAGE TIME
90°F (32°C)	6 weeks
180°F (82°C)	36 hours
200°F (93°C)	12 hours
212°F (100°C)	8 hours

SAFETY

TECHTHANE prepolymers, in their uncured liquid form, contain a small amount of free toluene-diisocyanate (TDI) which can cause severe irritation to the eyes, skin, respiratory system, and mucous membranes. Contact by inhalation, skin, eye, or ingestion must be avoided. All guidelines for handling TDI-containing materials must be followed when using TECHTHANE prepolymers.

To avoid inhalation, forced air ventilation must be used for all indoor applications. When working in tanks and other confined areas, or anywhere the TLV is exceeded, fresh air breathing equipment must be worn. Chemical cartridge masks suitable for organic vapors and approved by MSHA/OSHA may be used under some conditions with adequate ventilation. To avoid contact with skin or clothing, protective clothing must be worn at all times.

These products are intended for use by professional casting facilities only.

Review each component's Material Safety Data Sheet (MSDS) for further information prior to use of this kit.

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