

**IMUTHANE**
CASTABLE POLYURETHANE
ELASTOMERS
12-80A**IMUTHANE**
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IMUTHANE 12-80A is a TDI / POLYESTER based prepolymer which yields an 80 Shore-A elastomer when cured with 4, 4' methylene bis ortho chloroaniline (MBOCA).

Typical Prepolymer Properties

% NCO	3.1 – 3.5
Brookfield Viscosity @ 100° C	7.0 – 9.5
Specific Gravity @212° F (100° C)	1.15

Typical Process Conditions

IMUTHANE 12-80, °F (°C)	200 (93)
MBOCA, °F (°C)	240 (115)
Mold, °F (°C)	212 (100)
% Theory	90
Pot Life, min	4
Cure Time, min @ °F (°C)	30 @ 212 (100)
Post Cure, hrs @ °F (°C)	16 @ 212 (100)

Typical Physical Properties

Shore Hardness	80A
100% Modulus, psi (MPa)	700 (4.8)
300% Modulus, psi (MPa)	1250 (8.6)
Tensile, psi (MPa)	6500 (44.8)
Elongation, %	625
Tear Strength, Die C, pli (kN/m)	400 (70.0)
Tear Strength, (D470), pli (kN/m)	110 (19.3)
Bashore Rebound, %	33
Compression Set, Method B, 22 hrs @ 158°F (70°C), %	30
Specific Gravity	1.25

The data contained herein are believed to be reliable. However, there is no guarantee that the same results will be obtained under different conditions. Fit for use testing should be conducted by each user.