

80331

Sterling 80331 is a light tan color Shore D72 polyurethane rotocasting system. Advantages of this system are low viscosity, easy and fast processing (1:1 volume ratio, fast demold), as well as good physical properties.

This formula is a polyether polyol/MDI based extended system. It can easily be pigmented as well as filled with most types of mineral fillers, plastic or glass microspheres.

The recommended processing includes: rotomolding, injection molding, and open pour.

This system is molded into any major type of molds: RTV silicone, metal, urethane, etc.

Storage and Mixing

Both A and B components are very stable mixtures. However, we suggest re-mixing the B-component at least once a week. Recommended storage temperature is 70-105°F.

Store containers tightly closed since this material is moisture sensitive. If properly stored, the shelf life is 6 months or more.

Processing

This system cures at room temperature (77°F). We recommend preheating the mold to at least 100°F (preferably 120-140°F) if the final part consists of thin sections.

Note

- For industrial use only.
- Use for reference purpose only.
- Refer to the material safety data sheet for additional information.
- Use proper ventilation.

Processing Data

Mix Ratio By volume By weight	A: 1 pbv A: 100 pbw	B: 1 pbv B: 90 pbw
Specific Gravity	A: 1.11	B: 0.99
Viscosity	A: 50 cps	B: 100 cps
Gel Time	3.5-4 minutes (mass dependant)	
Demold Time	10-15 minutes (mass dependant)	

Physical Properties

Hardness (D-2240)	D 70 +/-2
Flexural Strength (D-790)	4,600 psi
Flexural Modulus (D-790)	150,000 psi
Tensile Strength (D-638)	2,600 psi
Ultimate Elongation (D-638)	15%
Tear Resistance/Die-C (D-624)	250 pli
Izod Impact-Unnotched (D-256)	6.50 ft-lbs/in
Izod Impact-Notched (D-256)	0.5 ft-lbs/in
HDT @66psi (D-648)	140 °F
HDT @264psi (D-648)	130 °F

