

ROTO-Cast System / Replicating Polyethylene

Polyethylene-like polyurethane

Key Properties

- Excellent physical properties after post cure
- Free of mercury, MOCA or TDI
- Phthalate free
- Polyethylene / polypropylene simulated product
- Excellent green strength

Applications

- For hand-batch processing, roto-casting

Processing Properties

			Resin (Isocyanate)	Hardener (Polyol)
Mix ratio		pbw	61	100
		pbv	54	100
Density	ASTM D-792	g/cm ³	ca.1.21	ca.1.08
Viscosity at 77°F (25°C)	ASTM D-2393	cP	ca. 75	ca. 630
			Mixture	
Mix viscosity at 77°F (25°C)	ASTM D-2393	cP	ca. 250	
Gel time at 77°F (25°C)		min	7-10	
Demold time at 77°F (25°C)		h	1-2	

Cured / Mechanical Properties (approximate values)

Cure 1: 7 days at 77°F			Cure 1
Aspect	visual		White
Density	ASTM D-792	g/cm ³	1.08
Shore hardness D	ASTM D-2240		60-70
Deflection temperature, HDT (66psi)	ASTM D-648	°F (°C)	178 (81)
Tensile strength	ASTM D-638	psi	3,500
Elongation at Break	ASTM D-638	%	40
Flexural strength	ASTM D-790	psi	2,970
Flexural modulus	ASTM D-790	psi	80,000
Notched Izod	ASTM D-256	ft lbf/in	1.5
Linear shrinkage	ASTM D-2566	in/in	0.001-0.005

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The processing and material temperature should be between 68-77°F (20-25°C).

For best results, de-air material prior to casting, then pressurize to 60 psi until cured. If the mold is preheated to 150°F, the demold time will be reduced to an hour or less. This material does not have to be used in conjunction with heat. However, significant improvements in HDT are made when using the post cure methods above.

The components can freeze when stored or shipped in temperatures below 32°F. In the event your system freezes, call your RAMPF Group Inc. representative to discuss reconstitution methods.

Agitate the hardener and resin before use to ensure that the formula is homogeneous.

Packaging

TP-4065 Quart Kit	3.22 lbs.
TP-4065 1 Gal. Kit	12.88 lbs.
TP-4065 5 Gal. Kit	64.4 lbs.
TP-4065 Drum Kit	724.5 lbs.

Storage

Original containers should be kept tightly sealed and stored at ambient temperatures 59-86°F (15°C to 30°C). If properly stored the products have the shelf-life indicated on the product label. Partly used containers should always be sealed appropriately and used up as soon as possible.

Handling Precautions

Good workplace ventilation is to be ensured during processing. At the same time, the employer's liability insurance association's industrial hygiene safety regulations regarding the handling of reaction resins and their hardeners are to be observed. Please take heed of the appropriate safety data sheets.
