

## CASTING URETHANE ELASTOMER SYSTEM

### ■ Description

VFI-176 is a unique moderate viscosity casting designed for easy processing and rapid demolding. This system produces a high hardness elastomer with good rebound properties.

### ■ Usage

VFI-176 has numerous application possibilities such as potting of mechanical parts to control vibration, poured in place supports for equipment, resilient furniture parts and low temperature flexible molds.

### ■ Color

Both the Iso and Poly are moderate viscosity fluids. The Iso is light amber in color and the Poly is either a semi-transparent fluid or is colored to the customer's specification.

## Physical Properties

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### ■ Tensile

ASTM D-412  
Strength: 3500 psi  
Elongation: 500%  
Permanent Set: 10% max.

### ■ Hardness

ASTM D-2240  
Shore A 80-83

### ■ Tear Resistance

ASTM D-624  
Die C 350 pli

### ■ Shrinkage

0.5% - 1.0%  
Depending upon cure temperature.

### ■ Abrasion Resistance

Excellent.

## Liquid Component Properties

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### ■ Solids

Weight: 100%  
Volume: 100%

### ■ Viscosity

Poly Component:  
975 ± 25 cps @ 77°F  
Iso Component:  
1600 - 2200 cps @ 77°F

### ■ Density

Poly Component:  
8.9 - 9.3 lbs./gal. (S.G. 1.07-1.12)  
Depending on color.  
Iso Component:  
9.06 lbs./gal. (S.G. 1.09)

### ■ Flash Point

ASTM D 56 (TCC)  
Greater than 200°F.

### ■ Storage Stability

12 months in unopened containers @ 50° - 90°F.

## Application

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### ■ Mixing

The above liquid component properties are for the standard product of 1 to 1 by volume mixing. Hand mix thoroughly for 30 seconds. Power mixing is mandatory for larger quantities (over ½ gallon).

### ■ Pot Life

Pot life is 4-5 minutes at room temperature. When gelation occurs, the clear mixture forms a translucent, white rubbery, compound.

### ■ Cure & Demold

VFI-176 will be slightly tacky for some time however it can be demolded in approximately 5 times the pot life. Thin films applied to cold surfaces may require up to 4 hours to cure to a removable film strength. A faster curing product is available to meet needs for quicker cycling of molds. The material will reach maximum physical properties in 3 to 10 days.

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