

**IMUTHANE**
CASTABLE POLYURETHANE
ELASTOMERS
27-53D**IMUTHANE**
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IMUTHANE 27-53D is a MDI / POLYETHER based prepolymer which yields a 53 Shore-D elastomer when cured with 1, 4 butanediol (BDO).

Typical Prepolymer Properties

% NCO	11.0 – 11.4
Brookfield Viscosity @ 100° C	1.0 – 3.0
Specific Gravity @ 77° F (25° C)	1.10
@ 212° F (100° C)	1.05

Typical Process Conditions

IMUTHANE 27-52D °F (°C)	170 (77)
BDO, °F (°C)	77 (25)
Mold, °F (°C)	240 (115)
% Theory	95
Pot Life, min	3
Cure Time, min @ °F (°C)	60 @ 240 (115)
Post Cure, hrs @ °F (°C)	16 @ 240 (115)

Typical Physical Properties

Shore Hardness	53D
100% Modulus, psi (MPa)	2650 (18.3)
300% Modulus, psi (MPa)	3800 (26.2)
Tensile, psi (MPa)	6000 (41.4)
Elongation, %	325
Tear Strength, Die C, pli (kN/m)	550 (96.3)
Tear Strength, (D470), pli (kN/m)	150 (26.3)
Bashore Rebound, %	36
Specific Gravity	1.11

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.