

**IMUTHANE**
CASTABLE POLYURETHANE
ELASTOMERS
12-83A**IMUTHANE**
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IMUTHANE 12-83A is a TDI / POLYESTER based prepolymer which yields an 85 Shore-A elastomer when cured with 4, 4' methylene bis ortho chloroaniline (MBOCA).

Typical Prepolymer Properties

% NCO	3.2 – 3.6
Brookfield Viscosity @ 100° C	9.0 – 15.0
Specific Gravity @212° F (100° C)	1.17

Typical Process Conditions

IMUTHANE 12-83A, °F (°C)	212 (100)
MBOCA, °F (°C)	240 (115)
Mold, °F (°C)	212 (100)
% Theory	95
Pot Life, min	6
Cure Time, min @ °F (°C)	30 @ 212 (100)
Post Cure, hrs @ °F (°C)	16 @ 212 (100)

Typical Physical Properties

Shore Hardness	85A
100% Modulus, psi (MPa)	775 (5.3)
300% Modulus, psi (MPa)	1200 (8.3)
Tensile, psi (MPa)	5700 (39.3)
Elongation, %	800
Tear Strength, Die C, pli (kN/m)	425 (74.7)
Tear Strength, (D470), pli (kN/m)	140 (24.5)
Bashore Rebound, %	40
Compression Set, Method B, 22 hrs @ 158°F (70°C), %	30
Specific Gravity	1.23

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.