



OPTICAL CLEAR UV 80D

Product Description:

IE-72DC is a tough, impact resistant elastomer formulated for room temperature hand-batch or vacuum-assisted casting methods. Excellent physical properties can be obtained with a room temperature cure without the utilization of mercury, MOCA, or TDI. The unique chemistry of IE-72CD imparts excellent optical clarity as well as U.V. stability.

Physical Properties

Mix Ratio	Resin:Hardener (parts by weight)	100:50		
Mix Ratio	Resin:Hardener (parts by volume)	100:55		
Viscosity (cps@77°F)	Resin	900	Gel Time	17.5 ± 2.5 Minutes
	Hardener	4000	Demold Time*	3 ± 1 Hours
	Mixed	1200	Color	Water Clear
Specific Gravity (g/cc)	Resin	1.16	*Demold time is always mass dependant	
	Hardener	1.05		
Peak Exotherm	(200g)	138°C / 280°F		

Cured Properties

	Method	Cure 1	Cure 2
Hardness (shore D)	ASTM D-2240	80 ± 5	80 ± 5
Tensile Strength (psi)	ASTM D-638	8,000	10,000
Elongation at Break	ASTM D-638	2%	2%
Compression Strength (psi)	ASTM D-695	N/A	N/A
Compression Modulus (psi)	ASTM D-695	N/A	N/A
Ultimate Flex Strength (psi)	ASTM D-790	N/A	N/A
Flexural Modulus (psi)	ASTM D-790	250,000	325,000
Notched Izod (ft.lbs./in.)	ASTM D-256	0.5	0.6
Linear Shrink (in./in.)	ASTM D-2566	0.004	0.004
Heat Deflection Temp. (66psi) 8 hour @ 150°F post-cure (66 psi)	ASTM D-648	60°C / 140°F	60°C / 140°F
	ASTM D-648	77°C / 170°F	N/A
Specific Gravity (g/cc)		1.1	1.1
		24 hours at 77°F	7 days at 77°F

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For more information call FusionPM (619) 819.5521 Fax (619) 819.6312 info@fusionpm.com