



Technical Data Sheet: Neuthane 335 Con Series

TDI Prepolymer Systems

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Neuthane 335 Con - TDI Prepolymer Systems

Properties			Processing			Special Considerations		
<p>The Neuthane 335 Con series of TDI based prepolymers cure in combination with Neuthane 30 Con, 40 Con, 50 Con and 60 Con curatives to give highly durable elastomers suitable for mould making.</p> <p>The finished elastomers offer:</p> <ul style="list-style-type: none"> • a high level of elasticity • good tear resistance • good abrasion resistance • low process temperatures • good dimensional stability <p>Typical Applications</p> <ul style="list-style-type: none"> • Concrete Industry (e.g. moulds for decorative slabs and walls) • Model making 			<p>Processing can be carried out by hand or by dispensing machine.</p> <p>Hand Processing</p> <ul style="list-style-type: none"> • It is important the ambient curing conditions be at least 20°C. • Prior to casting please ensure the polyol component is mixed thoroughly as it is a blend. • Bring all components to the recommended process temperature. • Add pigments and Antifoam (as applicable) to the polyol component whilst mixing • Add all components and thoroughly mix ensuring that no unmixed material is left on the container sides (if necessary the mix can be transferred to a second clean container and mixed again). • If a vacuum facility is unavailable please limit the amount of air entrapped during mixing. • Cast into moulds, preheated to the recommended temperature • Cure as recommended 			<p>Processing</p> <ul style="list-style-type: none"> • Avoid moisture contamination of all materials. Part used containers should be flushed with dry nitrogen and resealed immediately after use • It is vital to ensure that the curative component is completely liquid and thoroughly mixed prior to use • Due to the exothermic nature of the system larger mixes will have a shorter pot life • Allow longer demould times if curing sub ambient <p>Properties</p> <ul style="list-style-type: none"> • If cured at room temperature then physicals will develop fully over a 7 day. Alternatively a post-cure at 60-70°C for 4-8 hours can be employed. • Depending upon system hardness and cure conditions the development of physicals may take longer. It is therefore advisable to assess tear strength before using the mouldings. 		
COST	PROCESSING	ABRASION	DYNAMIC	RESILIENCE	SOLVENT	HUMID/WET	TEMPERATURE	UV STABILITY

Key

Excellent / Good

Good / Average

Average / Poor

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Neuthane			30 CON	40 CON	50 CON	60 CON
335 Con		by weight	100	100	100	200
Curative, Con Series		by weight	200	150	100	100
Resin Temperature		°C	20 - 25	20 - 25	20 - 25	20 - 25
Curative Temperature		°C	20 - 25	20 - 25	20 - 25	20 - 25
Recommended Mould Temperature		°C	20 - 25	20 - 25	20 - 25	20 - 25
Viscosity @ 25°C	Resin	cps	6400	6400	6400	6400
	Curative	cps	600	600	600	600
Pot life (on a 500g mix)		minutes	15 - 20	15 - 20	15 - 20	15 - 20
Recommended Cure Temperature / Days		°C / Days	25 / 7	25 / 7	25 / 7	25 / 7
Demould Cure Time		Hours	24	24	24	24
Hardness	DIN 2240-91	Shore A	30-35	40-45	50-55	60-65
100% Modulus	BS 903 Pt A2 - ISO 37	lb/in ² (Mpa)	90 (0.6)	116 (0.8)	190 (1.3)	205 (1.4)
300% Modulus	BS 903 Pt A2 - ISO 37	lb/in ² (Mpa)	-	-	-	-
Tensile Strength	BS 903 Pt A2 - ISO 37	lb/in ² (Mpa)	600 (4.0)	740 (5.1)	800 (5.5)	1160 (8.0)
Elongation at Break	BS 903 Pt A2 - ISO 37	%	1000	1000	1000	1000
Tear Strength	BS 903 Pt A3 - ISO 34-1	lb/in (KN/m)	90 (15.8)	100 (17.5)	150 (26.3)	200 (35.1)
Trouser Tear	BS 903 Pt A3 - ISO 34-1	KN/m	5.0	6.8	8.5	10.0
Compression Set	BS903 Pt A6 - ISO 815	KN/m	-	-	-	-
Abrasion loss	DIN 53516	mm ³	-	-	-	-
Resilience	ASTM D 2632-92	%	-	-	-	-
Specific Gravity		g/cm ³	1.10	1.10	1.10	1.10

Information contained in the data above is, to the best of our knowledge, true and accurate. Since conditions of use are beyond our control, no warranty is given or implied in respect of any recommendations or suggestions made by ourselves, nor is freedom from patent infringement inferred.



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