

# NEUTHANE 3300

MDI – PPG Ether Rotational Casting System  
 Published December 2023 Version 2

## Processing

- Heat the prepolymer and curative to the recommended temperature
- Ensure that the curative is thoroughly mixed prior to use (the storage tank on the machine should be fitted with agitation to prevent separation during use)
- Degass to remove air
- Dispense at 700-2000g per minute\*
- Adjust rotation and traverse speed until a smooth build up is achieved\*
- Cure as recommended

\* This will vary depending upon diameter of roller. As a general guide the output rate, rotational and traverse speeds will all increase as the diameter of the roller increases

NEUTHANE GRADE			3300
NEUTHANE CURATIVE			3390
Mix Ratio: Curative per 100 Parts resin		by weight	26
Resin Temperature		°C	30
Curative Temperature		°C	30
Recommended Roller Temperature		°C	Room Temperature
Viscosity @ 23°C	Curative	cPs	600
Pot life (on a 500g mix)		seconds	15-20
Recommended Cure Temperature / Time		°C / hrs	Minimum 20 / 48

Hardness	ISO 48-4	Shore A	79
	ISO 48-4	Shore D	-
100% Modulus	ISO 37	lb/in <sup>2</sup> (MPa)	934 (6.4)
300% Modulus	ISO 37	lb/in <sup>2</sup> (MPa)	1730 (12.0)
Tensile Strength	ISO 37	lb/in <sup>2</sup> (MPa)	2700 (18.6)
Elongation at Break	ISO 37	%	420
Tear (Die C)	ISO 34-1	lbf/in (kN/m)	373 (65)
Specific Gravity		g / cm <sup>3</sup>	1.09

Data above represents typical physical properties. 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.