



Product Information

PCA 4-1

POLYETHER/TDI ELASTOMER

PREPOLYMER PROPERTIES

% NCO	3.9-4.3
AMINE EQUIVALENT	975-1075
APPEARANCE @ 77°F	LIQUID*
TYPICAL VISC. @212°F, CPS.	550

PROCESSING INFORMATION

CURATIVE	MOCA
CURATIVE, pph	11.8
STOICHIOMETRY, %	90
PREPOLYMER TEMP, °F	212
CURATIVE TEMP, °F	240
POT LIFE, minutes	12-14

ELASTOMER PROPERTIES **

SHORE A HARDNESS	90
100% MODULUS, psi.	1100
300% MODULUS, psi.	2150
TENSILE STRENGTH, psi	5000
ELONGATION, %	440
TEAR STRENGTH, DIE C, pli	550
TEAR STRENGTH, D-470, pli	75
BASHORE RESILIENCE, % REBOUND	43
COMPRESSION SET, % - METHOD B, 22 hr. @ 158°F	26
LOW TEMPERATURE BRITTLINESS – ASTM D 746-14	Colder than – 75° C
FLUID IMMERSION – ASTM D 471-12a – IRM 901	Durometer point change - none Volume change + 0.4%
NBS ABRASION – ASTM D 1630-06(12)	400 rotations
TORSIONAL STIFFNESS, PSI (MPa) (CLASH-BERG)	@ 75°F (24°C) 2500 (17.2)
	@ 0°F (-18°C) 3100 (21.3)
	@ -40°F (-40°C) 10200 (70.3)
	@ -70°F (-57°C) 29600 (204.0)

* MAY SOLIDIFY UPON PROLONGED STANDING.

** CURED 1 hrs @ 212°F; POSTCURED 24 hr @ 158°F

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