

## Physical Properties Bulletin

### EasyFlo-Series Plastic Products

Product	EasyFlo 60	EasyFlo 90	EasyFlo 95	EasyFlo 100 FR	EasyFlo 120	EasyFlo Black	EasyFlo Clear	EasyFlo Spray FR
<b>Mix Ratio By Volume (By Weight)</b>	1A:1B (100A:90B)	1A:1B (100A:90B)	1A:1B (100A:90B)	1A:1B (100A:100B)	1A:1B (100A:90B)	1A:1B (1A:1B)	1A:1B (100A:85B)	1A:1B (100A:90B)
<b>Part A Color</b>	Clear Yellow	Clear Yellow	Clear Yellow	Clear Yellow	Clear Yellow	Clear Brown	Clear Yellow	Clear Yellow
<b>Part B Color</b>	Clear Slight Yellow	Clear Slight Yellow	Clear Slight Yellow	Clear Yellow/Pink	Clear Slight Yellow	Black	Clear Slight Yellow	Clear Yellow/Pink
<b>Initial Mixed Viscosity, cP</b>	60	200	95	120	120	200	110	250
<b>Pot Life, min</b>	2 - 2½	5	5	2 - 2½	2 - 2½	1½ - 2	2 - 2½	5 seconds
<b>Maximum Exotherm, °F (°C)</b>	230 (110)	175	206 (97)	200 (93)	200 (93)	245 (121)	208 (98)	251 (122)
<b>Demold Time (min)</b>	15-30	60-120	30-60	15-30	15-30	10-15	15-30	5-10
<b>Total Cure Time</b>	7 Days	7 Days	7 Days	7 Days	7 Days	4 Days	7 Days	7 Days
<b>Linear Shrinkage</b>	0.0041	<0.001	0.0074	0.0065	0.0065	0.008	0.0154	*
<b>Specific Gravity</b>	1.03	1.06	1.03	1.10	1.03	1.05	1.08	1.16
<b>Shore D Hardness</b>	65	70	65	65	65	70	72	75
<b>Tensile Strength, psi (mPA)</b>	2,936 (20.2) 4,730 (32.6) **	4,387 (30.2)	3,743 (25.8) 4,071 (28.1) **	3,170 (21.9) ND	3,534 (24.4) 5,395 (37.2) **	3,835 (26.4)	4,091 (28.2) ND**	7,110 (49.0)
<b>Elastic Modulus, psi (mPA)</b>	72,627 (500.9) 96,286 (664.0) **	134,685 (928.8)	22,758 (157.0) 112,202 (773.8) **	85,928 (592.6) ND**	85,149 (587.2) 134,384 (926.8) **	76,056 (524.5)	97,532 (672.6) ND**	165,600 (1142.0)
<b>Flexural Strength, 5% Strain, psi (mPA)</b>	3,915 (27.0) 5,226 (36.0) **	6,125 (42.2)	1,649 (11.4) 5,991 (41.3) **	4,284 (29.5) ND**	4,845 (33.4) 5,728 (39.5) **	5,521 (38.1)	6,007 (41.4) ND** ND**	10,545 (72.7)
<b>Flexural Modulus psi (mPA)</b>	93,112 (642.1) 127,429 (878.8) **	157,356 (1,085.2)	25,072 (172.9) 32,559 (224.5) **	117,878 (812.6) ND**	133,765 (922.5) 142,940 (985.8) **	120,904 (833.8)	165,733 (1,143.0) ND**	280,007 (1931.1)
<b>Heat Deflection Temperature, °F (°C)</b>	149 (65) 167 (75) **	164 (75)	132 (56) 148 (64) **	165 (74) ND**	146 (63) 159 (71) **	197 (94)	133 (56) ND**	175 (79)
<b>% Elongation</b>	13.9 9.4**	5.1	10.1 7.1**	9.0 ND**	10.3 7.9**	6.3	7.7 ND**	8.3

<sup>1</sup> Component requires stirring before use.

\* Shrinkage is primarily caused by gelling while hot then cooling. Parts that cure with minimal temperature rise exhibit minimal shrinkage. Reported shrinkage is inch/inch.

\*\* Post cured for 16 hours at 160°F. Post cure is not recommended for EasyFlo Black or EasyFlo Spray FR.

Conventions: °C = (°F -32) x 0.57

psi/145 = MPa (megaPascals)

pli x .1751 = kN/m (kiloNewtons per meter)

ND = Not Determined

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