

Physical Properties of Poly PT Series Liquid Plastics & Rubbers

Product	PT Flex 20	PT Flex 50	PT Flex 60	PT Flex 70	PT Flex 85
Mix Ratio By Weight (By Volume)	1A:1B (1A:1B)	1A:1B (1A:1B)	1A:1B (1A:1B)	1A:1B (1A:1B)	1A:1B (100A:97B)
Part A Color	Clear Yellow	Clear Yellow	Clear Yellow	Clear Yellow	Clear Yellow
Part B Color	Opaque Tan	Clear Yellow/Amber	Clear Yellow/Amber	Clear Yellow/Amber	Clear Yellow/Amber
Mix Viscosity, cP	520	550	625	680	1600
Pot Life, min	5	8	5	5	5
Demold Time (hr)	0.5 @ 158°F 1½ @ 78°F	0.5 @ 158°F 1 @ 78°F	0.5 @ 158°F 1 @ 78 °F	0.5 @ 158°F 1 @ 78°F	0.5 @ 158°F 1 @ 78°F
Total Cure Time	7 Days @ 78°F 16 hr @ 140°F	7 Days @ 78°F 16 hr @ 140°F	7 Days @ 78°F 16 hr @ 140°F	7 Days @ 78°F 16 hr @ 140°F	7 Days @ 78°F 16 hr @ 140°F
Linear Shrinkage*	0.0050	0.0020	0.0026	0.0041	0.0013
Specific Gravity	1.00	1.03	1.03	1.05	1.06
Shore Hardness	A20	A50	A60	A70	A85
Tensile Strength, psi (MPa)	250 (1.72)	250 (1.72)	345 (2.38)	730 (5.03)	1064 (7.34)
Elastic Modulus, psi (MPa)	85	160	190	915	2700
Die C Tear Strength, pli (kN/m)	50 (8.8)	50 (8.8)	70 (12.3)	130 (22.8)	190 (33.2)
% Elongation	770	200	235	175	250

* 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.

Conventions: °C = (°F -32) x 0.57
 psi/145 = MPa (megaPascals)
 pli x .1751 = kN/m (kiloNewtons per meter)
 NA = Not Applicable

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