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AUSTRALIA
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Erapol OC25A

WATER CLEAR POLYETHER BASED URETHANE
ELASTOMER

TECHNICAL DATASHEET

Erapol OC25A is a two-component, water clear polyurethane that cures at room temperature to produce a 25 Shore A elastomer. This material when cured at 25°C will take longer than 24 hours to reach 25 Shore A. The material can be cured for 2 - 4 hours at 35-40°C to speed up the cure.

The material can be used in a number of diverse applications, from special effects, badges and any product requiring a clear protective coating.

Product Specification

	PART (A)	PART (B)
Specific Gravity at 25°C	1.02	1.05
Viscosity at 25°C (cps)	650	300
Appearance	Water clear	Water clear

Mixing and Curing Conditions

Part (A)	(pbw)	100
Part (B)	(pbw)	275
Recommended % Theory		95
Part A Temperature	(°C)	20 – 30
Part B Temperature	(°C)	20 – 30
Pot Life	(mins)	15 – 20
Demould Time at 25°C	(hrs)	24 – 36
Demould Time at 60°C	(hrs)	6 – 8
Post Cure Time at 25°C	(hrs)	7 days fully cured at 25°C



This information is of general nature and is supplied without recommendation of guarantee. It does not make claim to be free from patent infringement. Properties shown are typical and do not imply specification tolerances. Era Polymers cannot accept liability for loss or damage through use. Whilst these technical details are based on expert knowledge, practical experience and laboratory testing, successful application depends upon the nature and conditions in which the products are supplied. Users must, by comprehensive testing, evaluate this product in their own application.

Physical Properties

Properties presented below are to be used as a guide and not intended for specification purposes.

		OC25A	TEST METHOD
Hardness	(Shore A)	25 ± 5	AS1683.15
Tensile Strength	(MPa)	1.0	AS1683.11
Angle Tear Strength, Die C	(kN/m)	4.1	AS1683.12
Elongation	(%)	277	AS1683.11

Moulding Materials

Any of the EraPol OC products can be poured into a urethane mould that has been prepared with an appropriate release agent. The EraPol OC products can be used in silicone moulding materials but they must be addition-cured silicones. Contact Era Polymers about specific grades of silicones that are suitable. Post curing the EraPol OC product at 50-60°C for 6-8 hours can improve the surface finish.

NOTE: Both Part A and Part B components are moisture sensitive. Once opened, containers should be purged with nitrogen, if they are to be stored for a period of time. Part A should be clear, if it is cloudy, warm to 40°C for 1-2 hours until it is clear.

Processing Procedure

Erapol **OC25A** products can be processed by hand or machine dispensing equipment. Do not cast this material when the Part A or Part B temperature is below 20°C as it will take too long to cure. **OC25A** must be cured in a room where the temperature does not drop below 20°C. This is critical in winter.

1. Weigh the amount of Part A into a container and degas at -95kPa of vacuum until excessive foaming stops.
2. Part B should be added to Part A and mixed thoroughly. Be careful not to entrap air whilst mixing. (It can be advised that the mixed product can be degassed at -95kPa of vacuum if required.)
3. Pour the mixed materials into moulds that have been prepared.
4. Allow casting to cure before demoulding.

NOTE: PART B must be completely stirred mechanically before use. In the colder months it may also be necessary to slightly warm the Part B (40°C) as it may solidify.

Handling Precautions

Erapol OC25A should be used in well-ventilated area. Avoid breathing in vapours and protect skin and eyes from contact.

In case of skin contact remove excess, wash with soap and water. For eye contact, immediately flush with water for at least 15 minutes. Call a physician.

If nose, throat or lungs become irritated from breathing in vapours, remove exposed person to fresh air. Call a physician.