ENDUROSET
ESD 1084FG

Product Highlights

- Low viscosity for detailed molds
- Easy to use 1:1 mix ratio by weight for meter hand mixing applications
- High heat resistance
- Manufactured using FDA approved materials (21CFR175 and 21CFR177)

Mixing Properties:	Resin (Isocyanate) Part A	Hardener (Polyol) Part B
Mix Ratio (Parts by Weight)	100	100
Mix Ratio (Parts by Volume)	87	100
Color	Clear Amber	Clear
Viscosity @ 77F	450	500
Mixed Viscosity @ 77F	525	
Specific Gravity @ 77F (mixed)	1.12	
Gel Time (Minutes) @77F	10 minutes +/- 2	
Demold Time @77F (varies w/ mass)	3 hr +/- .5	
Visual color of cured parts	Amber/Translucent	

Physical Properties:	ASTM Method	Cure 1	Cure 2
Hardness, Shore D	D-2240	80 +/- 5	80 ± 5
Flexural Modulus (PSI)	D-790	420,000	450,000
Tensile Strength (PSI)	D-638	8,000	8,000
Elongation (%)	D-638	10 %	10 %
IZOD Impact Notched (ft-lb/in)	D-256	1.8	1.4
Heat Deflection Temperature (@ 66 PSI) (2mm Deflection)	D-648	150°F	400°F
Shrinkage (in/in) (5" sample)	D-2566	.003	.003

Cure 1: Physical properties obtained using ambient room temperature (77°F). Tested after 7 days
Cure 2: Physical properties obtained with 12 hours at 150°F. Tested after 7 days

FDA DISCLAIMER: Thermoset Solutions formulations have been successfully used to manufacture products that have passed various levels of compatibility testing, however, the responsibility for testing cured parts to verify suitability for any application lies with the customer and/or end user. Thermoset Solutions makes no warranty, expressed or implied, of fitness for a particular use.

Other related products offered

- Silicone rubber
- Mold release agents
- Mix tubes
- Additional products available. Inquire directly for products not listed.

Processing suggestions:

- Thoroughly agitate polyol (hardener) component to be sure the liquid is homogeneous.
- Properly weigh out the appropriate amounts of resin and hardener.
    - Mix Thoroughly for two minutes being sure to scrape sides and bottom of container.
    - For best results, de-air the product before pouring into mold.
    - Pressurize mold in a pressure pot at 60psi until cured.
    - Mold temperature is recommended to be 150 °F for faster de-mold, otherwise longer time in room temperature mold will be required.
    - A heated post cure is recommended to achieve maximum properties and heat resistance. Depending on geometry, the part may need to remain in the mold or fixtured to maintain part tolerances.

Kit Sizes and Weights:

• Quart Kit	(0.43 gal)	4 lbs.
• Gallon Kit	(1.7 gal)	16 lbs.
• Five Gallon Kit	(8.6 gal)	80 lbs.
• Drum Kit	(94.7 gal)	880 lbs.

Safety Precautions:

The safety data sheet (SDS) for this or any Thermoset Solutions, LLC product should be read prior to use and is available upon request from Thermoset Solutions, LLC.
Use in a ventilated area. Avoid contact with skin using protective gloves and protective clothing. Repeated or prolonged contact on the skin may cause an allergic reaction. Eye protection is extremely important. Always use approved safety glasses or goggles when handling this product.

If Contact Occurs:

- Eyes: Immediately flush with water for at least 15 minutes. Call a physician.

- Skin: Immediately wash with soap and water. Remove contaminated clothing. Do not use solvents to wash skin. Seek medical attention if allergic reaction occurs.

- Ingestion: If swallowed, call a physician immediately. Remove stomach contents by gastric suction or induce vomiting only as directed by medical personnel.

Notice:

The information contained in this tech data sheet is considered accurate. However, no warranty is expressed or implied regarding the accuracy of the data, the results to be obtained from the use thereof, or that any such use will not infringe upon a patent. User shall determine the suitability of the product for the intended application and assume all risk and liability whatsoever in connection therewith.