ENDUROSET
ESD 784-120

Product Highlights

- High density, heavily filled formulation with outstanding flow characteristics
- Exceptional rigidity and dimensional stability
- Excellent heat deflection and thermal distortion resistance
- User friendly 1:1 mix ratio with practical working time
- 100% solids, no solvents and VOC free

Mixing Properties:	Part A (Isocyanate)	Part B (Polyol)
Mix Ratio (Parts by Weight)	100	100
Mix Ratio (Parts by Volume)	100	100
Color	Light Amber	White
Viscosity cps @ 77F	5000	1500
Viscosity cps @ 77F (mixed)	2500	
Gel Time @77F	7 min	
Demold Time (varies w/ mass)	60 min @ RT	

Physical Properties:	ASTM Method	Cure 1
Hardness, Shore D	D-2240	80-85D
Density @ 77°F (g/cc)	D-792	1.9
Flexural Modulus (PSI)	D-790	565,000
Tensile Strength (PSI)	D-638	2,500
Elongation (%)	D-638	4
IZOD Impact Notched (ft-lb/in)	D-256	0.8
Shrinkage (in/in) (10" sample)	D-2566	0.0005
Heat Deflection Temperature (@ 66 PSI)	D-648	140°F
Color	Visual	White

Cure 1: Physical properties obtained with room temperature cure

Other related products offered

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

Processing suggestions:

- Drill mix both sides separately. Both sides will separate but are easy to bring back to a homogenous mix.
- 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.
    - 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 5 lbs.
- Gallon Kit 20 lbs.
- Five Gallon Kit 100 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.