



**CROSSLINK TECHNOLOGY INC.**  
FORMULATED EPOXIES, URETHANES - CUSTOM CAST PARTS



## Three Component Variable Hardness Polyurethane System

(HARDNESS: 10 - 90 Shore A)

### PHYSICAL PROPERTIES

	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16
<b>COMPONENTS:</b>	<b>MIX RATIO (By Weight)</b>															
<b>1V-019-A</b> (Hardner-1)	83.33	78.60	73.64	69.55	65.40	61.62	58.02	51.61	45.73	40.46	35.71	31.58	27.50	20.64	12.25	0.00
<b>1V-019-B</b> (Hardner-2)	0.00	2.00	3.88	5.64	7.27	8.80	10.24	12.91	15.25	17.34	19.23	21.05	22.50	25.23	28.57	33.74
<b>1V-019-C</b> (Resin)	16.67	19.40	22.48	24.81	27.33	29.58	31.74	35.48	39.02	42.20	45.06	47.37	50.00	54.13	59.18	66.26
Pot Life (Minutes) <sup>(1)</sup>	29.00	26.00	18.00	18.00	16.00	14.00	12.00	10.00	9.50	8.50	8.00	7.00	6.50	6.00	5.00	4.50
Gel Time (Minutes) <sup>(2)</sup>	40	40	38	30	28	25	20	16	15	11	9	7	6	6	5	5
Machine Mixed Samples:	<b>PHYSICAL PROPERTIES<sup>(3)</sup></b>															
<b>Hardness (Shore)</b>	<b>10A</b>	<b>20A</b>	<b>25A</b>	<b>30A</b>	<b>35A</b>	<b>40A</b>	<b>45A</b>	<b>50A</b>	<b>55A</b>	<b>60A</b>	<b>65A</b>	<b>70A</b>	<b>75A</b>	<b>80A</b>	<b>85A</b>	<b>90A</b>
100% Modulus (psi)	64	82	106	130	165	200	242	283	345	397	450	503	566	628	751	875
200% Modulus (psi)	86	116	162	207	264	321	385	450	541	617	689	760	840	918	1059	1200
300% Modulus (psi)	92	156	223	290	366	442	523	605	724	816	904	991	1084	1178	1314	1450
UTS (psi)	97	200	275	350	440	527	664	800	900	1300	1506	1713	2242	2772	3504	4237
Ultimate Elongation (%)	450	460	405	350	359	367	414	460	430	582	556	531	594	657	705	679
DIE 'C' Tear (pli.)	31	35	50	65	72	78	104	130	145	186	218	250	285	320	370	420
Split tear (pli.)	8	8	9	10	12	13	16	18	28	30	35	40	62	84	112	140
Gel 200gr @22C (min)	40	40	38	30	28	25	20	16	15	11	9	7	6	6	5	5

**NOTES:**

1. Time to reach 100 poise (Brookfield)
2. 200grm mixed @ 22°C
3. Machine mixed and cured 16 Hrs @ 60° C

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