

**IMUTHANE**
CASTABLE POLYURETHANE
ELASTOMERS
33-91A**IMUTHANE**
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IMUTHANE 33-91A is a TDI / PPG based prepolymer which yields a 91 Shore-A elastomer when cured with 4, 4' methylene bis ortho chloroaniline (MBOCA).

Typical Prepolymer Properties

% NCO	4.5 – 4.9
Brookfield Viscosity @ 100° C	1.0 – 3.0
Specific Gravity @ 77° F (25° C)	1.07
@ 212° F (100° C)	1.01

Typical Process Conditions

IMUTHANE 33-91A, °F (°C)	160 (71)
MBOCA, °F (°C)	240 (115)
Mold, °F (°C)	212 (100)
% Theory	95
Pot Life, min	4
Cure Time, min @ °F (°C)	60 @ 212 (100)
Post Cure, hrs @ °F (°C)	16 @ 158 (70)

Typical Physical Properties

Shore Hardness	91A
100% Modulus, psi (MPa)	1150 (7.9)
300% Modulus, psi (MPa)	1550 (10.7)
Tensile, psi (MPa)	3400 (23.4)
Elongation, %	475
Tear Strength, Die C, pli (kN/m)	300 (52.5)
Tear Strength, (D470), pli (kN/m)	70 (12.2)
Bashore Rebound, %	34
Compression Set, Method B, 22 hrs @ 158°F (70°C), %	38
Specific Gravity	1.12

The data contained herein are believed to be reliable. However, there is no guarantee that the same results will be obtained under different conditions. Fit for use testing should be conducted by each user.