

**IMUTHANE**
CASTABLE POLYURETHANE
ELASTOMERS
22-93A**IMUTHANE**
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IMUTHANE 22-93A is a TDI / PTMG based prepolymer which yields a 93 Shore-A elastomer when cured with 4, 4' methylene bis ortho chloroaniline (MBOCA).

Typical Prepolymer Properties

% NCO	5.3 – 5.7
Brookfield Viscosity @ 100° C	2.0 – 5.0
Specific Gravity @ 77° F (25° C)	1.06
@ 212° F (100° C)	1.01

Typical Process Conditions

IMUTHANE 22-93A °F (°C)	180 (82)
MBOCA, °F (°C)	240 (115)
Mold, °F (°C)	212 (100)
% Theory	90
Pot Life, min	7
Cure Time, min @ °F (°C)	60 @ 212 (100)
Post Cure, hrs @ °F (°C)	16 @ 212 (100)

Typical Physical Properties

Shore Hardness	93A
100% Modulus, psi (MPa)	1600 (11.0)
300% Modulus, psi (MPa)	3300 (22.7)
Tensile, psi (MPa)	6000 (41.3)
Elongation, %	400
Tear Strength, Die C, pli (kN/m)	550(96.3)
Tear Strength, (D470), pli (kN/m)	110 (19.2)
Bashore Rebound, %	48
Compression Set, Method B, 22 hrs @ 158°F (70°C), %	32
Specific Gravity	1.13

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.