

**IMUTHANE**  
CASTABLE POLYURETHANE  
ELASTOMERS  
**23-75D****IMUTHANE**  
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IMUTHANE 23-75D is a TDI / PTMG based prepolymer which yields a 75 Shore-D elastomer when cured with 4, 4' methylene bis ortho chloroaniline (MBOCA).

**Typical Prepolymer Properties**

% NCO	9.3 – 9.7
Brookfield Viscosity @ 100° C	1.0 – 3.0
Specific Gravity @ 77° F (25° C)	1.13
@ 212° F (100° C)	1.06

**Typical Process Conditions**

IMUTHANE 23-75D °F (°C)	158(70)
MBOCA, °F (°C)	240 (115)
Mold, °F (°C)	212 (100)
% Theory	95
Pot Life, min	2
Cure Time, min @ °F (°C)	60 @ 212 (100)
Post Cure, hrs @ °F (°C)	16 @ 158 (70)

**Typical Physical Properties**

Shore Hardness	75D
100% Modulus, psi (MPa)	5000 (34.4)
300% Modulus, psi (MPa)	- ( - )
Tensile, psi (MPa)	6000 (41.4)
Elongation, %	200
Tear Strength, Die C, pli (kN/m)	1100 (192.6)
Tear Strength, (D470), pli (kN/m)	120 (21.0)
Bashore Rebound, %	55
Compression Set, Method A, 22 hrs @ 158°F (70°C), %	10
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.