

Polyurethane System Prepolymer	TDI - PolyCaprolactone		TDI - PolyEster			
	Andur® CL 6-0 APLF	Andur® 6 APLM	Andur® 7 APLM	Andur® 8 APFLM	Andur® 8 APFLM	Andur® 9-5 APLF
Curative (ratio by weight %)	Curene® 442	Curene® 442	Curene® 442	Curene® 442	Curene® 100 XPF	Curene® 49
Recommended Plasticizer % Plasticizer †			Andurflex 9-88SG 20%	Andurflex 9-88SG 50%		
<b>Processing Characteristics</b>						
Stoichiometry	0.95	0.95	0.95	0.95	0.95	1.05
Recommended Catalyst	oleic acid					Dabco® T-12
<b>REFER TO INDIVIDUAL PREPOLYMER DATASHEETS FOR CASTING GUIDELINES. TEMPERATURE ADJUSTMENTS MAY BE AVAILABLE OR NECESSARY WHEN ADDING PLASTICIZERS.</b>						
<b>Elastomer Properties</b>						
Shore Hardness	57-63A	58-62A	62-66A	63-67A	55-65A	60-64A
Tensile, psi	4500	4200	3600	3360	3700	4560
100% Modulus, psi	240	260	300	340	250	380
300% Modulus, psi	430	430	430	480	450	2470
Elongation, %	540	510	810	900	560	320
Die C Tear (D624), pli	180	185	215	220	180	130
Split Tear (D1938), pli: AVG.	25	35	115	110	27	26
D395 Comp. Set, % (22 hrs @ 70°C)	10	5	58	49	3	0
D2632 Rebound, %	9	34	47	47	50	7
<b>Attributes / Comments</b>	Good solvent resistance; improved hydrolytic stability; fairly tough; low compression set; very long potlife without catalyst	Good solvent resistance; improved hydrolytic stability; fairly tough; ultra low compression set	Good solvent resistance; very tough	Good solvent resistance; very tough	Good solvent resistance; fairly tough; ultra low compression set	Dry food contact approved; good solvent resistance; fairly tough; ultra low compression set; low rebound (good energy absorber)
<b>Disadvantages</b>	Fair water/acid/base resistance; may be susceptible to microbes	Fair water/acid/base resistance; may be susceptible to microbes	Fair water/acid/base resistance; may be susceptible to microbes; poor compression set	Fair water/acid/base resistance; may be susceptible to microbes; poor compression set	Fair water/acid/base resistance; may be susceptible to microbes	Fair water/acid/base resistance; may be susceptible to microbes
<b>FDA Approvable Composition</b>						Yes; Dry <sup>††</sup>

EW = Equivalent Weight \* Triethanolamine (TEA) \*\* Dioctyl Adipate (DOA) \*\*\*Trimethylolpropane (TMP) † % Plasticizer based on prepolymer weight

††† This system is approvable for FDA applications involving † wet food contact per 21 CFR 177.2600 & †† dry food contact per 21 CFR 177.1680

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11/2/2022**

Polyurethane System	Andur® 80-5 AP	Andur® 80-5 AP	Andur® 85 APLF	Andur® 2-90 AP	Andur® 2-95 AP	Andur® 95 APLF
Prepolymer	Curene® 185	Curene® 93	Curene® 100 XPF	Curene® 93	Curene® 100 XPF	Curene® 100 XPF
Curative (ratio by weight %)						
Recommended Plasticizer % Plasticizer †						
<b>Processing Characteristics</b>						
Stoichiometry	0.95	0.95	0.95	1.05	0.95	1.05
Recommended Catalyst		Dabco® T-12		Dabco® T-12		
REFER TO INDIVIDUAL PREPOLYMER DATASHEETS FOR CASTING GUIDELINES. TEMPERATURE ADJUSTMENTS MAY BE AVAILABLE OR NECESSARY WHEN ADDING PLASTICIZERS.						
<b>Elastomer Properties</b>						
Shore Hardness	60-65A	58-62A	58-62A	58-62A	60-64A	58-62A
Tensile, psi	2550	460	765	480	2100	4000
100% Modulus, psi	335	460	315	310	330	320
300% Modulus, psi	535	330	690	***	800	900
Elongation, %	555	170	300	170	350	400
Die C Tear (D624), pli	220	97	145	65	120	145
Split Tear (D1938), pli: AVG.	40	4	8	6	15	15
D395 Comp. Set, % (22 hrs @ 70°C)	13	0	2	0	0	2
D2632 Rebound, %	63	75	74	63	28	32
<b>Attributes / Comments</b>	Good water/acid/base resistance; fairly tough with good dynamics; low compression set; high rebound	Good water/acid/base resistance; good dynamics; ultra low compression set; high rebound	Good water/acid/base resistance; good dynamics; ultra low compression set; high rebound	Good water/acid/base resistance; ultra low compression set; high rebound	Easy to process; good water/acid/base resistance; fairly tough; ultra low compression set	Easy to process; good water/acid/base resistance; fairly tough; ultra low compression set
<b>Disadvantages</b>	Poor solvent resistance	Poor solvent resistance; low tensile & tear strength	Poor solvent resistance; low tensile strength	Poor solvent resistance; low tensile & tear strength	Poor solvent resistance	Poor solvent resistance
<b>FDA Approvable Composition</b>						

EW = Equivalent Weight \* Triethanolamine (TEA) \*\* Dioctyl Adipate (DOA) \*\*\*Trimethylolpropane (TMP) † % Plasticizer based on prepolymer weight

‡‡ This system is approvable for FDA applications involving †wet food contact per 21 CFR 177.2600 & ‡dry food contact per 21 CFR 177.1680

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Polyurethane System	Andur® 6000 AP	Andur® 6000 AP	Andur® 9000 AP	Andur® 9200 AP	Andur® 9500 AP	Andur® 9500 AP
Prepolymer	Curene® 442	Curene® 442	Curene® 185	Curene® 185	Curene® 93	Curene® 185
Curative (ratio by weight %)	Curene® 442	Curene® 442	Curene® 185	Curene® 185	Curene® 93	Curene® 185
Recommended Plasticizer % Plasticizer †						
<b>Processing Characteristics</b>						
Stoichiometry	1.05	1.1	0.95	0.95	0.95	0.95
Recommended Catalyst					Dabco® T-12	
REFER TO INDIVIDUAL PREPOLYMER DATASHEETS FOR CASTING GUIDELINES. TEMPERATURE ADJUSTMENTS MAY BE AVAILABLE OR NECESSARY WHEN ADDING PLASTICIZERS.						
<b>Elastomer Properties</b>						
Shore Hardness	55-65A	53-63A	54-60A	55-65A	58-66A	60-70A
Tensile, psi	525	625	1460	1975	790	1520
100% Modulus, psi	260	260	265	330	350	310
300% Modulus, psi	460	450	580	775	***	670
Elongation, %	340	420	465	435	230	455
Die C Tear (D624), pli	90	85	120	130	65	135
Split Tear (D1938), pli: AVG.	15	17	20	22	15	24
D395 Comp. Set, % (22 hrs @ 70°C)	18	22	10	9	0	13
D2632 Rebound, %	53	48	14	13	15	13
<b>Attributes / Comments</b>	Easy to process; good water/acid/base resistance	Easy to process; good water/acid/base resistance	Easy to process; good water/acid/base resistance; fairly tough; low compression set; low rebound (good energy absorber)	Easy to process; good water/acid/base resistance; fairly tough; low compression set; low rebound (good energy absorber)	Easy to process; good water/acid/base resistance; ultra low compression set; low rebound (good energy absorber)	Easy to process; good water/acid/base resistance; fairly tough; low compression set; low rebound (good energy absorber)
<b>Disadvantages</b>	Poor solvent resistance; low tensile & tear strength	Poor solvent resistance; low tensile & tear strength	Poor solvent resistance	Poor solvent resistance	Poor solvent resistance; low tensile & tear strength	Poor solvent resistance
<b>FDA Approvable Composition</b>						

EW = Equivalent Weight \* Triethanolamine (TEA) \*\* Dioctyl Adipate (DOA) \*\*\*Trimethylolpropane (TMP) † % Plasticizer based on prepolymer weight

‡‡ This system is approvable for FDA applications involving † wet food contact per 21 CFR 177.2600 & ‡ dry food contact per 21 CFR 177.1680

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Polyurethane System	MDI - PolyEster		MDI - PTMEG	
	Andur® M 8-5 AP Curene® 45/ Curene® BA 1000 (8.25/91.75)	Andur® BA-M 9-3 AP Curene® 45/ Curene® BA 1000 (5.7/94.3)	Andur® M 80 AP Curene® 45T6/ Curene® PTMG 1000 (8.3/91.7)	Andur® M 93 AP Curene® 45/ Curene® PTMG 1000 (3.7/96.3)
Prepolymer				
Curative (ratio by weight %)				
Recommended Plasticizer % Plasticizer †				
<b>Processing Characteristics</b>				
Stoichiometry	0.95	0.95	0.95	0.95
REFER TO INDIVIDUAL PREPOLYMER DATASHEETS FOR CASTING GUIDELINES. TEMPERATURE ADJUSTMENTS MAY BE AVAILABLE OR NECESSARY WHEN ADDING PLASTICIZERS.				
<b>Elastomer Properties</b>				
Shore Hardness	60-65A	64-68A	58-62A	60-65A
Tensile, psi	4800	5600	1220	1900
100% Modulus, psi	240	370	230	215
300% Modulus, psi	460	660	370	290
Elongation, %	640	510	590	720
Die C Tear (D624), pli	240	255	185	165
Split Tear (D1938), pli: AVG.	95	90	26	25
D395 Comp. Set, % (22 hrs @ 70°C)	32	22	24	15
D2632 Rebound, %	50	64	80	82
<b>Attributes / Comments</b>	Dry food contact approved; good solvent resistance; very tough; curative EW is ~273	Wet & dry food contact approved; good solvent resistance; very tough; low compression set; curative EW ~318	Wet & dry food contact approved; good water/acid/base resistance; fairly tough with good dynamics; high rebound; curative EW ~273	Wet & dry food contact approved; easy to process; good water/acid/base resistance; fairly tough with good dynamics; low compression set; high rebound; curative EW ~363
<b>Disadvantages</b>	Moisture sensitive during processing; poor water/acid/base resistance	Moisture sensitive during processing; poor water/acid/base resistance	Moisture sensitive during processing; poor solvent resistance	Moisture sensitive during processing; poor solvent resistance
<b>FDA Approvable Composition</b>	Yes; Dry <sup>††</sup>	Yes; Wet <sup>†</sup> & Dry <sup>††</sup>	Yes; Wet <sup>†</sup> & Dry <sup>††</sup>	Yes; Wet <sup>†</sup> & Dry <sup>††</sup>

EW = Equivalent Weight \* Triethanolamine (TEA) \*\* Dioctyl Adipate (DOA) \*\*\*Trimethylolpropane (TMP) † % Plasticizer based on prepolymer weight

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