

**IMUTHANE**  
CASTABLE POLYURETHANE  
ELASTOMERS  
**33-85A****IMUTHANE**  
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IMUTHANE 33-85A is a TDI / PPG based prepolymer which yields an 85 Shore-A elastomer when cured with 4, 4' methylene bis ortho chloroaniline (MBOCA).

**Typical Prepolymer Properties**

% NCO	4.0 – 4.4
Brookfield Viscosity @ 100° C	2.0 – 5.0
Specific Gravity @ 77° F (25° C)	1.07
@ 212° F (100° C)	1.01

**Typical Process Conditions**

IMUTHANE 33-85A, °F (°C)	160 (71)
MBOCA, °F (°C)	240 (115)
Mold, °F (°C)	212 (100)
% Theory	90
Pot Life, min	10
Cure Time, min @ °F (°C)	60 @ 212 (100)
Post Cure, hrs @ °F (°C)	16 @ 158 (70)

**Typical Physical Properties**

Shore Hardness	85A
100% Modulus, psi (MPa)	850 (5.8)
300% Modulus, psi (MPa)	1550 (10.7)
Tensile, psi (MPa)	3500 (24.1)
Elongation, %	475
Tear Strength, Die C, pli (kN/m)	275 (48.2)
Tear Strength, (D470), pli (kN/m)	75 (13.1)
Bashore Rebound, %	30
Compression Set, Method B, 22 hrs @ 158°F (70°C), %	40
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.