

| Polyurethane System | Andur® 7 APLM | Andur® 7-3 APLF | Andur® 8 APLM | Andur® 8 APLM | Andur® 8 APFLM | Andur® 8-5 APLS |
|--|--|--|---|--|---|---|
| Prepolymer | | | | | | |
| Curative (ratio by weight %) | Curene® 93 | Curene® 442/ TMP *** (50/50) | Curene® 49 | Curene® 100 XPF | Curene® 49 | Curene® 49 |
| Recommended Plasticizer % Plasticizer † | Andurflex 9-88SG 5% | | | | Andurflex 9-88SG 10% | Andurflex 9-88SG 5-10 % |
| Processing Characteristics | | | | | | |
| Stoichiometry | 1.1 | 0.95 | 1.1 | 1.0 | 0.95 | 1.0 |
| Recommended Catalyst | Dabco® T-12 | | Dabco® T-12 | | Dabco® T-12 | Dabco® T-12 |
| REFER TO INDIVIDUAL PREPOLYMER DATASHEETS FOR CASTING GUIDELINES. TEMPERATURE ADJUSTMENTS MAY BE AVAILABLE OR NECESSARY WHEN ADDING PLASTICIZERS. | | | | | | |
| Elastomer Properties | | | | | | |
| Shore Hardness | 46-52A | 50-55A | 45-55A | 50-55A | 50-55A | 48-54A |
| Tensile, psi | 2280 | 5060 | 1870 | 2800 | 1040 | 2740 |
| 100% Modulus, psi | 190 | 250 | 250 | 225 | 215 | 245 |
| 300% Modulus, psi | 340 | 475 | 490 | 395 | 440 | 555 |
| Elongation, % | 610 | 530 | 480 | 580 | 455 | 440 |
| Die C Tear (D624), pli | 140 | 205 | 160 | 165 | 115 | 155 |
| Split Tear (D1938), pli: AVG. | 21 | 29 | 17 | 22 | 10 | 12 |
| D395 Comp. Set, % (22 hrs @ 70°C) | 2 | 2 | 1 | 3 | 0 | 0 |
| D2632 Rebound, % | 60 | 55 | 46 | 51 | 53 | 34 |
| Attributes / Comments | Good solvent resistance; ultra low compression set | Good solvent resistance; fairly tough; ultra low compression set; curative EW ~67 | Dry food contact approved; good solvent resistance; fairly tough; ultra low compression set | Good solvent resistance; fairly tough; ultra low compression set | Good solvent resistance; ultra low compression set | Good solvent resistance; ultra low compression set |
| Disadvantages | Viscosity may cause processing difficulties; poor water/acid/base resistance; may be susceptible to microbes | Poor water/acid/base resistance; may be susceptible to microbes | Poor water/acid/base resistance; may be susceptible to microbes | Poor water/acid/base resistance; may be susceptible to microbes | Poor water/acid/base resistance; may be susceptible to microbes | Poor water/acid/base resistance; may be susceptible to microbes |
| FDA Approvable Composition | | | Yes; Dry ^{††} | | | |

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 | TDI - PTMEG | | | TDI - PPG Ether | | |
|--|---|---|---|--|--|---|
| | Andur® 80 APLF | Andur® 80-5 AP | Andur® 85 APLF | Andur® 8000 AP | Andur® 8000 AP | Andur® 8500 AP |
| Prepolymer | | | | | | |
| Curative (ratio by weight %) | Curene® 100 XPF | Curene® 100 XPF | Curene® 100 XPF | Curene® 93 | Curene® 100 XPF | Curene® 185 |
| Recommended Plasticizer % Plasticizer † | | | Andurflex 9-88SG 10% | | | |
| Processing Characteristics | | | | | | |
| Stoichiometry | 1.05 | 1.05 | 1.05 | 0.95 | 0.95 | 1.0 |
| Recommended Catalyst | | | Oleic acid | Dabco® T-12 | | |
| REFER TO INDIVIDUAL PREPOLYMER DATASHEETS FOR CASTING GUIDELINES. TEMPERATURE ADJUSTMENTS MAY BE AVAILABLE OR NECESSARY WHEN ADDING PLASTICIZERS. | | | | | | |
| Elastomer Properties | | | | | | |
| Shore Hardness | 48-52A | 46-52A | 48-52A | 50-60A | 48-54A | 48-52A |
| Tensile, psi | 465 | 1700 | 1700 | 290 | 575 | 785 |
| 100% Modulus, psi | 210 | 230 | 160 | 275 | 235 | 180 |
| 300% Modulus, psi | 405 | 395 | 280 | *** | *** | 370 |
| Elongation, % | 335 | 500 | 590 | 140 | 245 | 480 |
| Die C Tear (D624), pli | 125 | 155 | 105 | 40 | 45 | 75 |
| Split Tear (D1938), pli: AVG. | 8 | 18 | 15 | 5 | 6 | 20 |
| D395 Comp. Set, % (22 hrs @ 70°C) | 3 | 4 | 3 | 0 | 0 | 9 |
| D2632 Rebound, % | 72 | 62 | 66 | 21 | 19 | 14 |
| Attributes / Comments | Easy to process; good water/acid/base resistance; ultra low compression set; high rebound | Good water/acid/base resistance; fairly tough with good dynamics; ultra low compression set | Good water/acid/base resistance; fairly tough with good dynamics; ultra low compression set | Good water/acid/base resistance; ultra low compression set | Good water/acid/base resistance; ultra low compression set | Easy to process; good water/acid/base resistance; low compression set; low rebound (good energy absorber) |
| Disadvantages | Poor solvent resistance; low tensile strength | Poor solvent resistance | Poor solvent resistance | Low tensile & tear strength | Low tensile & tear strength | Low tensile strength |
| FDA Approvable Composition | | | | | | |

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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