

PC-3231 Urethane Casting System

Orange Pool/Spa filter with Shore A 85 hardness

Technical Bulletin

Rev. Date: 06/05/2014

PC-3231 is a product that is a two component, room temperature cured, flexible urethane molding system designed for pool filters. The combination of medium viscosity and quick gelling characteristics of the material yields fast turnover time for filter manufacturing. The system contains a biocide that inhibits microbial growth.

Key Features

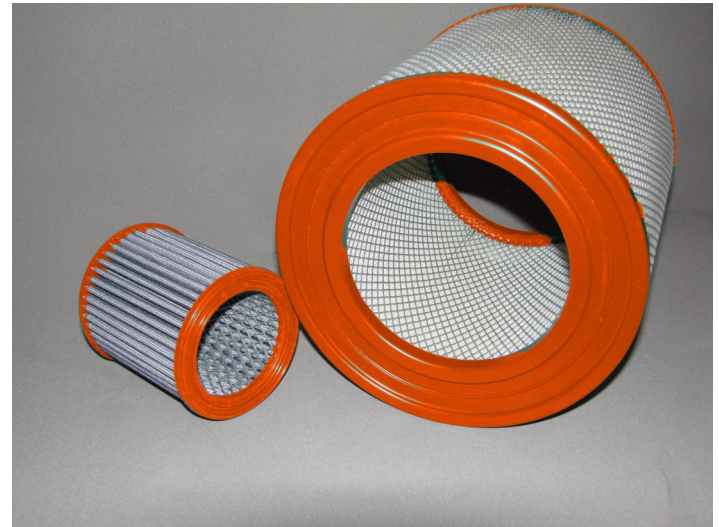
- Medium Mixed Viscosity
- Very good thermal stability
- Very good hydrolytic stability
- Low stress cure
- Fast gel with ample flow/working time
- Very good chemical resistance
- Excellent chlorine resistance

Typical Uncured Properties

Color	
Resin	Orange
Hardener	Clear Light Yellow
Mixed	Orange
Viscosity, cps @ 77°F +/- 3°F	
Resin (Brookfield Spindle #3 @ 20 RPM)	2400–3000
Hardener	700
Mixed	2100-2700
Density, Lbs/Gal (Sp. Gr.) @ 77°F +/- 3°F	
Resin	11.10 (1.33)
Hardener	10.0(1.20)
Mixed	10.85 (1.30)

Mixing Specifications & Characteristics

Mix Ratio:	
By Weight	100 parts resin to 27.5 parts hardener
By Volume	3.3 parts resin to 1 part hardener
Gel Time, min:sec @ 77° +/- 3°F	
100 Gram Mass	1:75–2:25
Cure Cycle (Full Cycle)	7 Days



Typical Cured Properties

Color	Orange
Hardness (Shore A)	85
Tensile Strength (psi)	1260
Elongation %	318
Tear (DIEC), pli	175

Processing Instructions

For good results, automatic mixing and dispensing equipment should be used. Please consult with Polyset technical staff before making final processing decisions.

Storage

Keep away from flames. Material should be used once container is opened. Long term storage of opened material should be under nitrogen. Shelf life of both resin and hardener is 6 months @ 25°C (77°F) in unopened containers.

Safety Information

Avoid direct contact. Use gloves when handling resin and hardener, if skin contact occurs, wash with soap and water. If resin or hardener enters the eyes, flush with cool water for at least 15 minutes and call a physician immediately. Refer to SDS on PC-3231 for further details.

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