

PC-3219 Urethane Filter Sealant

Lt. Amber Elastomer ideal for Rotational Molding

PC-3219 is a two component, room temperature cured, unfilled, tough elastomeric urethane adhesive designed for facemask rotational molding. The combination of low viscosity and unique gelling characteristics of the material at moderate processing temperatures (125°-150°F) yields a fast de-mold time that is ideal for filter manufacturing.

Key Features

- Low Initial Mixed Viscosity with Ample Flow / Working Time, Followed by a Quick Gel Transition
- Excellent Adhesion to Various Substrates
- Good Thermal Stability with Very Low Shrinkage
- Translucent, Light Amber Product Possessing Excellent Toughness

Typical Uncured Properties

| | |
|---|-------------|
| Color | |
| PC-3219 Resin (Polyol Component) | Light Straw |
| PC-3219 Hardener (Isocyanate Component) | Clear Amber |
| PC-3219 Mixed | Light Amber |
| Viscosity (Brookfield) @ 25°C ± 1°C (77°F ± 2°F); cPs | |
| PC-3219 Resin | 700 |
| PC-3219 Hardener | 1,450 |
| PC-3219 Initial Mixed | 950 |
| Density @ 25°C ± 1°C (77°F ± 2°F); Lbs./Gal. (g/cm ³) | |
| PC-3219 Resin | 8.01 (0.96) |
| PC-3219 Hardener | 9.65 (1.16) |
| PC-3219 Mixed | 8.56 (1.03) |

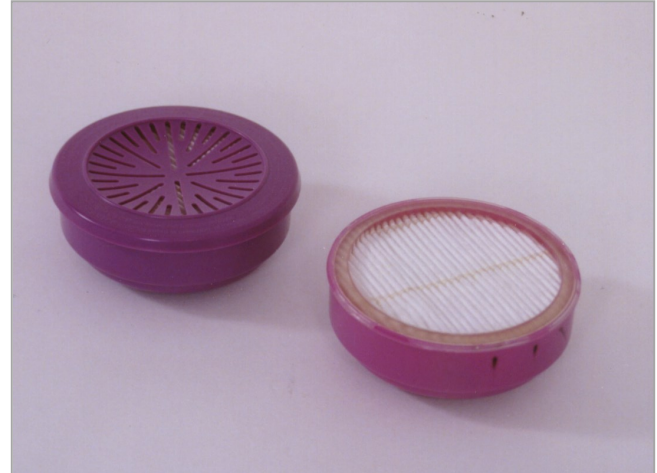
Mixing Specifications & Characteristics

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|---|---------------------------------------|
| Mix Ratio | |
| Parts by Weight | 100 parts Resin : 60.6 parts Hardener |
| Parts by Volume | 2.00 parts Resin : 1.00 part Hardener |
| Processing Times @ 25°C ± 1°C (77°F ± 2°F); min:sec | |
| Gel Time (153 gram mass; 400 mL beaker) | 1:10 |
| Gel Time (7 grams; 6mm thickness) | 1:20 |
| Full Cure Cycle | 7 Days |

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Typical Cured Properties

| | |
|--|--------------|
| Color | Light Amber |
| Hardness; Shore A | 50 |
| Maximum Operating Temperature; °F (°C) | |
| Continuous Operation | 180° (82.2°) |
| Intermittent Operation | 212° (100°) |

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 Information

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 PC-3219 Resin and PC-3219 Hardener is 6 months @ 25°C (77°F) in unopened containers.

Storage temperatures for PC-3219 Hardener (isocyanate) should be maintained at 18-35°C at all times. Under these storage conditions, the hardener will remain clear for periods of up to six months. If solidification and/or crystallization should occur because of exposure to temperatures below 18°C, please contact Polyset for guidance and recommendations.

Safety Information

Refer to product Safety Data Sheets for further information.