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AUSTRALIA
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Erapol XLS85A

POLYESTER TDI PREPOLYMER –
LOW FREE TDI CONTENT

TECHNICAL DATASHEET

Erapol XLS85A is a new generation of isocyanate-terminated polyester based polyurethane prepolymer with the added benefit of extremely low monomer content. It is formulated for use with MOCA curative and gives a final hardness of 85 Shore A.

Additionally, **Erapol XLS85A** has a very low free TDI content (less than 0.1%). The low viscosity and long pot-life allow for greater processing flexibility.

Application

Typical uses of this polymer include forklift truck tyres, roles and gears, die pads etc.

Product Specification

% NCO	3.50 ± 0.20
Specific Gravity at 70°C (g/cm ³)	1.19
Viscosity at 80°C (cps)	1500 - 1700
Colour	Clear, light amber

Mixing and Curing Conditions

	XLS85A / MOCA	XLS85A /Ethacure 300	XLS85A /Eracure 110
Erapol XLS85A (pph)	100	100	100
MOCA Level (pph)	10.6	-	-
Ethacure 300 Level (pph)	-	8.5	-
Ethacure 110 Level (pph)	-	-	9.0
Recommended % Theory	95	95	95
Erapol Temperature (°C)	75 - 85	75 - 80	75 - 80
Curative Temperature (°C)	110 - 120	20 - 30	20 - 30
Pot Life (mins)	14	10	9
Demould Time at 100°C (mins)	35	20	25
Post Cure Time at 100°C (hrs)	16	16	16



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Physical Properties

Properties presented below are to be used as a guide and not intended for specification purposes.

		XLS85A / MOCA	XLS85A / E300*	XLS85A / E110**	TEST METHOD
Hardness	(Shore A)	85 ± 3	85 ± 3	83 ± 3	AS1683.15
Tensile Strength	MPa (psi)	40 (5801)	43.6 (6324)	46.2 (6701)	AS1683.11
100% Modulus	MPa (psi)	5.3 (769)	5.4 (783)	5.6 (812)	AS1683.11
200% Modulus	MPa (psi)	8.6 (1247)	7.9 (1146)	8.8 (1276)	AS1683.11
300% Modulus	MPa (psi)	13.9 (2016)	12.4 (1798)	14.3 (2074)	AS1683.11
Elongation	(%)	535	615	635	AS1683.11
Angle Tear Strength, Die C	kN/m (pli)	79.6 (455)	87.8 (501)	83.0 (474)	AS1683.12
Trouser Tear Strength	kN/m (pli)	36.9 (211)	38.6 (220)	35.3 (202)	AS1683.12
DIN Resilience	(%)	38	39	42	DIN 53512
DIN Abrasion Resistance 10N	(mm ³)	59	67	48	AS1683.21
Compression Set / 22 hr at 70°C	(%)	36	31	24	AS1683.13
Cured Specific Gravity	(g/cm ³)	1.26	1.24	1.24	AS1683.4

*Ethacure 300 **Eracure 110

Processing Procedure

1. **Erapol XLS85A** should be heated to 80 ± 5°C and thoroughly degassed at -95 kpa of vacuum until excessive foaming stops.
2. The curative should be added to **Erapol XLS85A**, the MOCA must first be melted at 110 – 120°C and Ethacure 300 and Eracure 110 processed at room temperature. After adding the curative, mix thoroughly being careful not to introduce air into the mixture.
3. Pour mixed materials into moulds, which have been preheated to 100°C and pre-coated with release agent.

Adhesion

Adhesion of Erapol based elastomers to various substrates it at best marginal if a primer is not used. Please consult Era Polymers for specific recommendations to improve adhesion.

Handling Precautions

Erapol XLS85A contains small amounts of free TDI. Therefore the product should be used in well-ventilated areas. Avoid breathing in vapours and protect skin and eyes from contact.

In case of skin contact, immediately remove excess, wash with soap and water. For eye contact, immediately flush with water for at least 15 minutes. Call a physician.

If nose, throat or lungs become irritated from breathing in vapours, remove exposed person to fresh air. Call a physician.



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