

Table I**Liquid Resin Properties**

	PU Resin SH-15
Part A Viscosity @25°C	400cps
Part B Viscosity @25°C	550cps
Blend Viscosity @25°C	440cps
Pot Life @25°C	15-mins
Over Cure @60°C	3 hours
@75°C	1 hour
Processing Method	Manual/ Machine

Table II**Physical Properties of Cured Elastomers**

Hardness @25°C	30-40D
T-peels Strenth (kg/in)	2
(vs.aluminum)	
Tensile Strenth (kg/cm)	50
Tear Resistance (kg/mm)	0.12
% elongation	150
QUV hours passed	600 (Equal to 6 yrs)
Cold Harden	Slightly
(Hardness @10°C)	(45-50D)

Manual Processing Method

The Process of converting an A+B blend into casting elastomer consists of 4 basic steps:

1.Mixing	A 4-5-liter PE cylindrical beaker is suggested as a mixing container. Weight mixing ratio is A:B=1:1, with an acceptable 3% error. Don't let weight of A+B mixture exceed 3kgs. So that there would be sufficient head space for degassing. Mix thoroughly with a steel stirrer for at least 1 minute.
2.Degassing	Degassing under vacuum for at least 2 minutes.
3.Casting	Use up all A+B mixture within suggested pot life. The pot life under 20°C is about 20 minues. Minutes @25°C is about 15 minutes @30°C is about 10 minutes
4.Oven Cure	For metal base logo material, the curing condition is 75°C x 1 hours. For Plastic base material , the curing condition is 60°C x 3 hours.