



## Product Description

POLYCOAT PRE-POL® PC 15-94 is an MDI terminated polyester prepolymer that yields high property elastomers in the 94A hardness range, when cured with 1,4 Butanediol. This prepolymer exhibits excellent heat resistance. Some of its unique properties include:

- Excellent Dynamic Properties
- Excellent Flex Life
- FDA approved for wet and dry applications
- High Tear Strength
- Superior Abrasion Resistance
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Vulcanizates from PRE-POL® PC 15-94 are uniquely suited for a wide variety of applications. Prime examples are conveyor belting and sheet goods. As with all polyurethane products, application and field testing is recommended to determine suitability of the product combination for a specific application.

## PREPOLYMER SPECIFICATIONS

**NCO%** 8.1 – 8.4

**Viscosity, poise @ 212°F  
(100°C)** 4.0 – 10.0

**Storage Stability** 1.20

**Appearance @ 77°F (25°C)** Excellent in the absence of moisture and heat

**Color, Gardner** 0-3

**Flash Point, Cleveland Open Cup** >380°F (193°C)

**Solubility** Soluble in aromatic or chlorinated hydrocarbons, ketones and esters

**Storage Stability** Excellent in the absence of moisture and heat

## PROCESSING CONDITIONS

**Pre-Pol® PC 15-94 (8.32% NCO)** 100 pts

**1, 4 Butanediol (95% theory)** 8.46 pts

## MIXING AND CURING

**Prepolymer temperature** 200°F (93°C)

**1, 4 Butanediol temperature** 77–158°F (25–70°C)

**Mold temperature** 240°F (115°C)

**Cure, hours at** 1 at 240°F (115°C)

**Postcure, hours at 212°F  
(70°C)** 16

**Working Life, minutes** 5

## VULCANIZATE PROPERTIES

Test specimens conditioned one week at 75°F (24°C) and 50% RH before testing.

**Hardness, durometer A** 94

**100% Modulus, psi** 1390 ± 50 (9.58 ± 0.3 mPa)

**300% Modulus, psi** 3390 ± 200 (23.4 ± 1.4 mPa)

**Tensile Strength, psi** 8500 ± 300 (58.1 ± 2.1 mPa)

**Elongation at Break, %** 450 ± 50

**Tear Strength (ASTM D-470)  
psi** 160 ± 5 (1.1 ± 0.03 mPa)

**Tear Strength (Die C) psi** 670 ± 20 (4.62 ± 0.14 mPa)

**Compression Set  
(Method B), %  
After 22 h at 158°F (70°C)** 35

**Resilience (Rebound), %** 41

## Storage and Handling

Containers should be kept tightly closed to prevent moisture contamination. MDI will react with water to liberate CO<sub>2</sub> gas potentially causing containers to expand and rupture. Do not reseal if contamination is suspected.

Use of a dry nitrogen blanket for partial drums is recommended. Storage for PRE-POL® PC 15-94 should be maintained in a cool, dry place at ambient temperatures.

Exposure to temperatures over 350°F (177°C) can create excessive pressure potentially causing containers to rupture. Do not breathe aerosol or vapors and avoid contact with skin and eyes. Always use protective equipment including a respirator when handling heated prepolymers as exposure to vapors can be dangerous.

Devices such as melting ovens, thermostatically controlled warming blankets, or drum heaters can be used for pre-heating PRE-POL® PC 15-94.

Approximate preheat times at 158°F (70°C) are:

- 5 gallon pail (18.9 liters) 16 - 24 hours
- 55 gallon drum (208 liters) 36 - 48 hours

Containers should be rolled to ensure homogeneity prior to use.

## Health and Safety Information

Appropriate literature has been assembled which provides information concerning the health and safety precautions that must be observed when handling any of the products listed above. Before working with these products, it is your responsibility to read and become familiar with the available information on its hazards, proper use and handling. This is extremely important and cannot be overemphasized. Information is available in several forms, e.g. material safety data sheets and product labels. To obtain this information, contact your Polycoat Products representative

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