

Here are the results of various cure schedules, to aid in selecting one to obtain the proper cured properties for the intended application:

Handling & Initial Cure Details	Post Cure Used	Izod	Tg	E'
** Pour into Mold Heated to 130°F, Cure 2-2¹/₂ hr @ 150°F, Cool, Demold	Overnight @ 180°F	2.1	213°F	193°F
Pour into Mold Heated to 130°F, Cure 2-2¹/₂ hr @ 150°F, Cool, Demold	After 7 Days @ Room Temp.	2.04	192°F	159°F
Pour into Mold Heated to 130°F, Cure 2-2¹/₂ hr @ 150°F, Cool, Demold	Overnight @ 150°F	1.72	205°F	186°F
Pour into Mold Heated to 130°F, Cure 2-2¹/₂ hr @ 150°F, Cool, Demold	2 hours @ 180°F	1.6	205°F	184°F
Pour into Mold Heated to 130°F, Cure 2-2¹/₂ hr @ 150°F, Cool, Demold	2 hours @ 150°F	1.5	195°F	174°F
Pour into Mold Heated to 160°F, Cure 1 hr @ 160°F, Cool, Demold	After 7 Days @ Room Temp.	2.1	197°F	175°F
Pour into Mold Heated to 160°F, Cure 2 hr @ 160°F, Cool, Demold	4 hr @ 160°F, then 7 Days @ R.T.	2.1	206°F	187°F

**** Recommended**

TYPICAL MECHANICAL PROPERTIES

	PT8902 A/B, B1 or B2	ASTM Method
Mix Ratio, By Weight	100 A : 50 B or B1 (100 A : 60 B2)	PTM&W
Color	White (w/Hardener B2 - Black)	Visual
Mixed Viscosity, centipoise	495 cps.	ASTM D2393
Working Time, 4 fl. Oz. Mass. @77°F	B:6-7 min., B1:10-12 min., B2:90 sec.	ASTM D2471
Cured Hardness, Shore D	85 Shore D	ASTM D2240
Specific Gravity, grams. cc	1.15	ASTM D1475
Density, lb./cu. Inch lb. / gallon	.0417 9.6 lb. / gallon	ASTM D792
Specific Volume, cu. in./lb.	24.0	ASTM D792
Tensile Strength, psi	10,010 psi	ASTM D638
Elongation at Break, %	21.6 %	
Tensile modulus, psi	371,155 psi	ASTM D790
Flexural Strength, psi	15,574 psi	
Flexural Modulus, psi	386,612 psi	ASTM D695
Compressive Strength, psi	11,943 psi	
Compressive Modulus, psi	357,510 psi	ASTM D256
Izod Impact Strength, ft.lbs./inch of Notch, Method A, Notched	2.1	
Glass Transition Temperature, DMA: Tg (Peak) E' (Onset)	213°F 193°F	ASTM D4065
Heat Deflection Temperature, @ 64 psi Load	190°F	ASTM D648
Coefficient of Thermal Expansion, Range 50°C to 100°C	6.09 x 10 ⁻⁵ in/in/°F	ASTM

PACKAGING WEIGHTS

	Gallon	Pail	Drum
PT8902 Part A	8 lb.	40 lb.	460 lb.
PT8902 Part B or B1	4 lb.	20 lb.	230 lb.
PT8902 Part B2	---	24 lb.	276 lb.