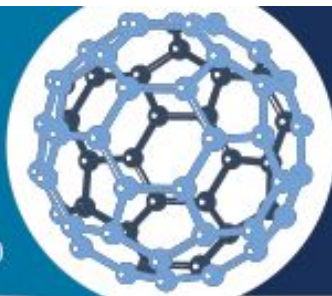


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Technical Data Sheet

Roto-Molding Resins

RotoMolding Resins are specifically formulated 2-component 100% solids hybrid polyurea-based material designed to produce dimensionally stable, structural hollow part moldings. This material is normally batch-mixed and poured into hollow room-temp mold. Solidification times may be tailored to accommodate large part or intricate moldings. Casting material is normally applied at room temperature. Resins may be colored-tinted as well as durometers may be formulated to range from 60A-75D. Resins may be neat or filled to meet material shrinkage requirements (1% to 0.5% respectively). Material formulations functional operation temperatures may be formulated to range from -20°F to 200°F.

Physical Properties

RotoMolding Resin 45D Physical Properties

Color/Clarity	Visual	Amber/Opaque
Flex Modulus	ASTM D790	150k psi
Tensile Strength	ASTM D412	3500 psi
Hardness ShoreD	ASTM D785	45D
Abrasion -TaberCS17	ASTM D4060	55 mg/1k cycles
Gel Time	Time	Formulated to spec.
Mix Ratio A:B	PBV	1:1

RotoMolding Resin 60 A Physical Properties

Color/Clearity	Visual	Clear
Flex Modulus	ASTM D790	200k psi
Tensile Strength	ASTM D412	1200 psi
Hardness ShoreD	ASTM D785	60 A

Abrasion -TaberCS17	ASTM D4060	50 mg/1k cycles
Gel Time	Time	6 min.
Mix Ratio A:B	PBV	1:1

Rotomolding Resin 70D Physical Properties

Color/Clarity	Visual	Amber/Opaque
Flex Modulus	ASTM D790	327k psi
Tensile Strength	ASTM D412	5470 psi
Hardness ShoreD	ASTM D785	70D
Abrasion -TaberCS17	ASTM D4060	75 mg/1k cycles
Gel Time	Time	Formulated to spec.
Mix Ratio A:B	PBV	1:1

Rotomolding Resin 75D Physical Properties

Color/Clarity	Visual	Amber/Opaque
Flex Modulus	ASTM D790	350k psi
Tensile Strength	ASTM D412	5700 psi
Hardness ShoreD	ASTM D785	75D
Abrasion -TaberCS17	ASTM D4060	75 mg/1k cycles
Gel Time	Time	Formulated to spec.
Mix Ratio A:B	PBV	1:1

Application Instructions

Rotomold Casting Resins must be mixed thoroughly prior to dispensing into roto-mold. It is very important not to induce air when mixing. Entrapped air will cause bubbles and micro porosity internally and on the exterior surface. For fiberglass molds use hi-temp paste wax. Resins may be dispensed using low pressure static mixer machine equipment. Please call our Technical Support Group or for any questions regarding material, application or direction of use.