



Polytek® Polyurethane Plastics

Technical Reference Chart

Series	Product	Mix Ratio by Volume	Mix Ratio by Weight	Shore Hardness	Pot Life (1-lb mix)	Demold Time* @ 73°F <i>unless otherwise noted</i>	Cured Color	Mixed Viscosity (cP)	Specific Volume (in ³ /lb)	Specific Gravity	Linear Shrinkage (in/in)	Elongation (%)	Max Exotherm (°F)	Heat Deflection Temp.	Tensile Strength (psi)	Elastic Modulus (psi)	Flexural Modulus (psi)	Flexural Strength, 5% Strain (psi)
EASYFLO SERIES Fast-Setting, Low-Viscosity Polyurethane Plastics	EasyFlo 60	1A:1B	100A:90B	D65	2-2.5 min.	15-30 min.	White	60	26.9	1.03	0.0041	13.9	230	149	2,936	72,627	93,112	3,915
	EasyFlo 90	1A:1B	100A:90B	D70	5 min.	60-120 min.	White	200	26.1	1.06	<0.001	5.1	175	164	4,387	134,685	157,356	6,125
	EasyFlo 120	1A:1B	100A:90B	D65	2-2.5 min.	15-30 min.	Off-White	120	26.9	1.03	0.0065	10.3	200	146	3,534	85,149	133,765	4,845
	EasyFlo Black	1A:1B	1A:1B	D70	1.5-2 min.	10-15 min.	Black	200	26.4	1.05	0.008	6.3	245	197	3,835	76,056	120,904	5,521
	EasyFlo Clear	1A:1B	100A:85B	D72	2-2.5 min.	15-30 min.	Amber	110	25.5	1.08	0.0154	7.7	208	133	4,091	97,532	165,733	6,007
	EasyFlo 100 FR	1A:1B	1A:1B	D65	2-2.5 min.	15-30 min.	Off-White/Tan	120	25.2	1.10	0.0065	9	200	165	3,170	85,928	117,878	4,284
	EasyFlo Spray FR	1A:1B	100A:90B	D75	N/A (Spray)	5-10 min.	Off-White	250	23.9	1.16	ND	8.3	251	175	7,110	165,600	280,007	10,545
POLY 15-SERIES High-Strength Plastics	Poly 15-3	N/A	1A:1B	D80	15 min.	12-16 hr.	Tan	2,000	18	1.53	0.0006	2.6	125	ND	3,509	202,276	479,648	5,232
	Poly 15-3X	N/A	1A:1B	D80	5 min.	1-12 hr.	Tan	2,000	18	1.53	0.0015	2.6	160	149	3,890	ND	ND	ND
	Poly 1511	N/A	1A:1B	D71	10 min.	1-16 hr.	White	400	25.1	1.10	0.0044	5.4	251	142	6,712	118,352	241,223	10,046
	Poly 1512	N/A	1A:1B	D71	22 min.	1-16 hr.	White	400	25.1	1.10	0.0034	5.4	251	142	6,712	118,352	241,223	10,046
	Poly 1512X	N/A	1A:1B	D71	5 min.	0.5-4 hr.	White	400	25.1	1.10	0.0048	5.4	251	142	6,712	118,352	241,223	10,046
POLY-OPTIC 14-SERIES Water-Clear Plastics	Poly-Optic 1410	N/A	3A:2B	D80	15 min.	2 hr. (1" thick)	Water Clear	700	25.8	1.07	ND	27	265	100	4,566	96,830	144,158	4,893
	Poly-Optic 1411	1A:1B	100A:90B	D80	9 min.	30 min. (0.5" thick)	Water Clear	600	25.8	1.07	0.0018	7	228	138	6,083	133,956	250,992	8,478
	Poly-Optic 1411 ES7	1A:1B	100A:90B	D80	420 min.	48-96 hr.	Water Clear	600	25.8	1.07	ND	ND	100	ND	ND	ND	ND	ND
	Poly-Optic 1412	1A:1B	1A:1B	D80	8 min.	30 min. @ 175°F	Water Clear	750	25.8	1.07	0.0019	11.1	235	227	9,825	179,886	295,101	12,261
	Poly-Optic 1420	N/A	2A:1B	D85	15 min.	8 hr @ 150°F 30 min. @ 175°F	Water Clear	250	26.3	1.05	ND	5.3	311	168	7,900	171,500	250,000	12,600
	Poly-Optic 14-70	N/A	4A:5B	A70	15 min.	24-48 hr.	Water Clear	340	26.1	1.06	0.0016	234	190	N/A	564	N/A	N/A	N/A
	Poly-Optic 1490 [^] (MERCURY-FREE)	1A:1B	100A:90B	D80	9 min.	1 hr.	Water Clear	690	25.8	1.07	0.0070	7.7	235	165	6,605	96,260	324,248	10,847
SPECIALTY	Poly Plasti-Flex (FLEXIBLE PLASTIC)	N/A	35A:100B	A90	3 min.	15 min.	Tan	3,000	34	0.81	ND	81	190	N/A	1,330	29,450	N/A	N/A
	Poly LiteCast (LIGHTWEIGHT PLASTIC)	N/A	1A:1B	D55	5 min.	0.5 - 4 hr.	Tan	2,480	35	0.78	ND	3	251	ND	2,398	105,470	16,630	4,402

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*Demold time varies with thickness of casting and the amount of accelerator used. [^]Poly-Optic 1490 must be pressure cast or used with vacuum casting equipment (not degassing).

ND = Not Determined | N/A = Not Applicable