



TECHNICAL DATA SHEET - IRATHANE 2855

Revised: 05/2018

PRODUCT DESCRIPTION

A high quality two component hot cast product based on PTMG and MDI possessing excellent abrasion and hydrolytic stability.

RECOMMENDED APPLICATIONS

Ideally suited to spin casting pipe linings
Used for casting entire parts with or without reinforcement for many abrasive applications.

FEATURES

- Excellent abrasion & Hydrolysis resistance
- Versatile and easy to process

PACKAGE SIZE

75 Litre Kit

PRODUCT DATA

PHYSICAL PROPERTIES	2855A	2855B-80
COLOUR	Milky white	Milky white
MIX RATIO BY WEIGHT	1	1.7
MIX RATIO BY VOLUME (FOR ESTIMATING ONLY)	1	2
VISCOSITY / MPA.S	1000 @ 30°C	750 @ 55°C
SG @ 20°C	1.14	0.98
PROCESSING TEMPERATURE / °C	30	55
POT LIFE / MINS (55°C)	5-7	

PERFORMANCE PROPERTIES

TENSILE STRENGTH, (MPA) BS6903 PART A2	30-35
MODULUS @ 100% (MPA) BS6903 PART A2	5.1
MODULUS @ 300% (MPA) BS6903 PART A2	13
ELONGATION AT BREAK (%) BS6903 PART A2	450-500
CURED HARDNESS (SHORE A) BS6903 PART A57	79-85
SPLIT TEAR (KN/M) BS6903 PART A3	12.5
DIE C TEAR (KN/M) BS6903 PART A3	55
COMPRESSION SET (%)BS6903 PART A4	24
ABRASION RESISTANCE, BS903, PART A9 METHOD 1, MM ³ (DIN 53516)	35
ABRASION RESISTANCE (TABER H 18 WHEELS 1000G WEIGHT, MG LOSS / 1000 CYCLES)	21
BASHORE RESILIENCE / % (ASTM D2632)	60

APPLICATION INFORMATION

SURFACE PREPARATION

Proper surface preparation is essential to a successful application. The following procedures should be considered:

- All surfaces must be dry and clean.
- If surface is oily or greasy, use MEK to degrease the surface. All metal surfaces must ideally be grit blasted to SA 2 ½ or better in accordance with SIS 055900 or NACE specification Number 2.. Where this is not possible then grinding with a coarse wheel or disc is a suitable alternative.

See relevant Method statement for comprehensive information on surface preparation required.

MIXING

Prior to use of the product ensure that both A and B components are thoroughly melted out, this may require that they are kept overnight in a warm room or oven at around 50°C. Once melted out ensure that the products are kept at the appropriate processing temperature prior to use. The B component should be mixed before use to ensure homogeneity.

Preweigh the required amounts of A and B components and whilst at the correct temperature degas them in a vacuum oven for 10-30 minutes as required.

Ensuring that products remain that their processing temperatures use a suitable drill and jiffy type mixer to mix the two components together taking care not to incorporate any air. The product is then ready to be cast or poured as desired.

Machine mixing is the recommended method, consult ITW Performance Polymers for further info.

APPLICATION

Once prepared and mixed the product is cast or poured into a mould as required. The moulds or other prepared parts must then be oven cured as specified in the product data section.

Specialist equipment is available to handle mix cast and cure this product, consult ITW Performance Polymers technical personnel for further guidance.

CURE

Cure times are stated in the product data section, remember that the cure time will be dependent on the DFT of the material applied and figures are for 2mm. For DFT's in excess of this the cure will require longer periods to enable material mass to reach the stated temperature.

CURE / DEMOULD TIME, 2mm thickness @ 90°C

3 Hours followed by 3 days at ~20°C

CLEAN UP

All equipment should be thoroughly cleaned directly after use using EC19 or MEK.

SHELF LIFE & STORAGE

A shelf life of 6 months from date of shipment can be expected when stored in dry conditions at room temperature (~22°C) in their original containers.

PRECAUTIONS

For complete safety and handling information, please refer to Material Safety Data Sheets prior to using this product.

WARRANTY

ITW Performance Polymers will replace any material found to be defective. Because the storage, handling and application of this material is beyond our control we can accept no liability for the results obtained.

DISCLAIMER

All information on this data sheet is based on laboratory testing and is not intended for design purposes. ITW Performance Polymers makes no representations or warranties of any kind concerning this data.

For further product information or technical assistance please call +353 61 771 500.