



Technical Data Sheet

POLYMARK P534

POLYURETHANE DOMING SYSTEM

Features:

- Fast Curing at 25°C
- Tough and Self-healing
- Low User Sensitivity
- Low Moisture Gassing
- UV and Weathering Resistant
- Shore D-33 Hardness

Product Description:

Polymark P534 is a two component, fast room temperature curing polyurethane doming system. It is designed for covering of emblems and decals to produce an attractive 3-D product. Cured P534 is a very tough, transparent elastomer with high gloss.

P534 is a DOT non-hazardous material and conforms to RoHS and REACH restrictions. P534 has special processing for lower isocyanate sensitivity compared to other polyurethanes on the market. P534 does not produce gas bubbles from substrate moisture during cure.

Typical Product Handling Properties:

<u>CHARACTERISTIC</u>	<u>VALUE</u>
RESIN:	
Color	Clear
Viscosity, 25°C	500 cps.
HARDENER:	
Color	Clear
Viscosity, 25°C	1000 cps.
MIXING RATIO (Resin to Hardener):	
by weight	93.3 to 100
by volume	1 to 1
Gel Time, 25°C	10-12 minutes
Tack-free Time, 25°C	45-60 minutes

Typical Cured Physical Properties

<u>CHARACTERISTIC</u>	<u>VALUE</u>
Cured Appearance	Clear, High Gloss
Cured Density (g/cc)	1.12
Cured Hardness (Shore D)	D-33
Time to Full Cure, 25°C*	24-48 hours

*Determined by durometer hardness.

Polymark P534 can be proportioned by weight or volume. These ratios are stoichiometrically calculated and should be closely followed. Automated meter-mix dispensing equipment may be used for high volume production

While mixed P534 will not produce gas bubbles while curing, each component is hygroscopic and can slowly react with moisture in the air. The Resin and Hardener must be kept away from atmospheric moisture during storage. After opening a sealed container, thoroughly purge the remaining air space with dry nitrogen (or equivalent inert gas) before closing the container. Ask your Polymark representative for proper storage recommendations.

Handling Safeguards:

Closely follow instructions on the labels of Polymark materials containing information on the hazards associated with each particular product. Most polyurethane resin systems are skin and eye irritants. Other problems, such as skin sensitization and more serious health hazards may exist. Consult the Material Safety Data Sheet for further information.

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Important Notice to Users: Typical properties are shown in this technical bulletin and should not be used or taken as specifications. Contact Polymark prior to establishing specifications. The information given for product description, handling properties and cured physical properties are offered solely to assist the purchaser's own testing. Polymark, its sales agents and distributors make NO WARRANTY OF MERCHANTABILITY OF THE PRODUCT OR THE FITNESS OF THE PRODUCT FOR ANY PARTICULAR PURPOSE. This product and all information supplied in connection with it is used at the purchaser's own risk, conditions of use being beyond Polymark's knowledge or control. The purchaser assumes all risk of use or handling of the product, whether in accordance with directions or not.