

HAPFLEX 500 SERIES

PHYSICAL PROPERTIES		TEST METHOD	580 580-3	581 581-3	595 595-3	596 596-3	598 598-3	599
PHYSICAL PROPERTIES	Mix Ratio by volume A:B	Calculation	100:60	100:60	100:50	100:50	100:50	100:50
	Mix Ratio by weight A:B	Calculation	100:70	100:70	100:50	100:50	100:50	100:50
	Gel time 100 grams @ 25°C	ASTM D-2971	40 min. 3 min.	40 min. 3 min.	45 min. 3 min.	45 min. 3 min.	45 min. 3 min.	45 min.
	Color (cured)	Visual	Black	Clear Amber	Black	Clear Amber	Clear Blue	Grey
	Hardness Shore	ASTM D-2240	85 A	85 A	95 A	95 A	95 A	95 A
	Viscosity mixed @ 25°C cps	ASTM D-4878	2,500	2,500	2,700	2,700	2,700	2,700
	Specific Gravity mixed @ 25°C	ASTM D-4669	1.08	1.08	1.06	1.06	1.06	1.06
	Shrinkage inch/inch See shrinkage paragraph	ASTM D-2566	.002-.003	.002-.003	.002-.003	.002-.003	.002-.003	.002-.003
	Demold time @ 70°F 1/8" thick	HAPCO TEST	7-10 hrs. 1-2 hrs.	7-10 hrs. 1-2 hrs.	5-8 hrs. -40 min.	5-8 hrs. -40 min.	5-8 hrs. -40 min.	5-8 hrs.
	Weight per cubic inch (lbs.)	Calculation	0.0383	0.0383	0.0383	0.0383	0.0383	0.0383
PRODUCT PROPERTIES	Tensile Strength (psi)	ASTM D-638	1,891	1,891	2,048	2,048	2,048	2,048
	Elongation %	ASTM D-638	289	289	227	227	227	227
	Tear Strength (pli)	ASTM 624 Die C	305	305	418	418	418	418
	Modulus of Elasticity (ksi)	ASTM D-638	6.3	6.3	12.1	12.1	12.1	12.1
	Izod Impact (ft.lbs/in.) notched unnotched	ASTM D-256	No Break	No Break	No Break	No Break	No Break	No Break
	Heat Distortion Temperature (°C) 66 psi 264 psi	ASTM D-648	NA	NA	NA	NA	NA	NA
	Flexural Strength (psi)	ASTM D-790	NA	NA	NA	NA	NA	NA
	Flexural Modulus (ksi)	ASTM D-790	NA	NA	NA	NA	NA	NA

NOTE: Post curing these materials is strongly recommended. Before use, reference material handling, processing, and safety notes located on pages 23-24.



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