



Northstar Polymers (Div. of Tandem Products, Inc.)  
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## MGB-A80AQ

Prepolymer (Part-A): MGA-018

Curative (Part-B): GBA-042

MGB-A80AQ high-performance quasi-polyether system is one of a family of polymer systems developed by Northstar Polymers for demanding work environments. Urethane elastomers molded with this system exhibit an excellent slide-abrasion resistance, high rebound, and excellent water resistance. This combination of features makes elastomers molded from MGB-A80AQ perfect for many applications including many other custom applications.

### Physical/Mechanical Properties

Durometer Hardness	ASTM# D 2240
Tensile Strength	D 412
Ultimate Elongation	D 412
Tear Resistance: Die C	D 624
Tear Resistance: Split	D 624
Taber Abrasion	D 4060
Bashore Rebound	D 2632

### Typical Value

80 A
4000 psi
750 %
450 pli
250 pli
8.0 mg loss
68 %

Prepolymer	MGA-018
Specific Gravity	1.139
Viscosity at 77 °F	900 -1200 cps
% NCO	23.00
Amine Equivalents	182.7
Appearance at 77 °F	Pale Yellow Liquid

Curative	GBA-042
Specific Gravity	0.978
Viscosity at 180 °F	250 – 300 cps
Equivalent Weight	416
OH Value	134.9
Appearance at 77 °F	White waxy solid

### Processing Conditions

Prepolymer Temperature	Ambient (72 °F)
Curative Temperature	180 °F
Mold Temperature	160 - 200 °F
Post Cure Temperature	180 – 200 °F

### Cure Pattern

Pot-Life	2-1/2 to 3 minutes
Gel Time	4 - 9 minutes
De-molding Time	30 – 40 minutes
Post Cure @180 °F	8 – 20 hours

### Recommended Release Agent

100% solid silicone mold release (non-water base)

### Ratio Calculation

	Prepolymer (A)	Curative (B)
Product Code	MGA-018	GBA-042
<b>Weight Ratio</b>	<b>1.000</b>	<b>2.230</b>
<b>Volume Ratio</b>	<b>1.000</b>	<b>2.641</b>
<i>Stoichiometric Ratio</i>	<i>NCO</i>	<i>OH</i>
	<i>100</i>	<i>98</i>





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Storage:

#### Part-A Component

Part-A component (MGA-018) contains isocyanate material(s), which are very much sensitive to moisture. If it is left in air, part-A will react with atmospheric moisture and will be ruined. This reaction is non-reversible. Soon after opening a can and dispensing the content, nitrogen gas or negative-40-degree-dew-point dry air needs to be injected to the can to blanket the material. Store it in an air-tight container such as steel drums, sealed pails, or totes. Silica gel or calcium chloride desiccant filter should be installed to 55 gallon drum-vent for your drum feeding system.

The storage temperature should be at a room temperature between 72 °F and 96 °F. Do not store in heated storage above 104 °F (40 °C) as it induces adverse reaction within the material, which could degrade the material.

Note:

This isocyanate prepolymer (MGA-018) may freeze during the transportation and storage in the cold seasons. Frozen state of isocyanate prepolymer can be indicated by solid, gel, or high viscosity liquid state and cloudy color. This material may freeze just below room temperature. This product makes unwanted byproducts if it is kept frozen. It may ruin the material if it is store frozen for a long time. The frozen material must be thawed immediately. Please consult Northstar Polymers if isocyanate prepolymer is suspected to be frozen. Northstar Polymers will not refund or replace the material damaged from cold temperature and mishandling.

If a large amount of water mixes with a large amount of isocyanate base materials, the chemical reaction may produce a large amount of CO2 gas and heat to create a hazardous condition. Keep the storage area free of water.

Under a certain combination of heat, catalyst (basic chemicals), amounts of reactive materials, and some other favorable conditions for the reaction, the water (or alcohol/glycol) to isocyanate reaction can reach a dangerous state of accelerated reaction. The accelerated reaction may create a very high temperature condition. The thermal decomposition of isocyanate based material by extremely high temperature or fire can produce toxic gasses and smokes. Please be sure that the containers are stored in dry indoor storage, away from source of large amount of water.

If a leak is found in a drum, please place the drum in such a position that the leaking part is at a higher part of drum so that the content no longer leaks out. Cover the leaking area with dry towel to prevent air from entering. If possible, transfer the material into new container(s) with nitrogen purge. If moisture enters into an isocyanate container from a small leakage, CO2 gas may be produced to gradually pressurize the container. If pressure built up is suspected, open the bung (or cap) very slowly to release the pressure before you change the drum position.

#### Part-B (Curative) Component

Part-B component (SBA-036) is hygroscopic. If the material is exposed to ambient air, it absorbs moisture. Part-B component contaminated by moisture can become a source excessive bubbles in the product after mixed with part-A. Avoid exposure of the material to moisture in air.





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Purging the empty space in the container with dry nitrogen gas, argon gas, or negative-40-degree-dew-point dry air is also recommended to prevent moisture contamination of part-B as well. (However, simply keeping the material in an airtight container may also be sufficient depending on the moisture level of the work place.)

Store it in a dry indoor storage at a room temperature between 65 and 90 °F. Avoid direct sunlight.

Note: Moisture contamination of part-B material can be reversed by heating material to 160 - 180 °F and vacuuming it at about 29" Hg negative pressure for several hours.

If this material is stored for a long time, the material may absorb air or gas inside the container, which may cause excess bubbles after while it is cast and/or molded. The material may need to be heated to 180 - 200 F range and degassed for 30 to 60 minutes above 29" Hg vacuum to eliminate infused air/gas from long term storage.

#### Safety:

The component materials are industrial-grade chemicals. Please keep them in a secure place and prevent access from any unauthorized individual. The personnel who handle these materials need to read the Material Safety Data Sheet (MSDS) for detail information on safety and handling of the material. The MSDS for each component is sent with the shipment of the material.

When using this material, be sure to operate in a wide-open area with good air movement, or in a well-ventilated area. Wear rubber gloves, long sleeves, and protective eyeglasses to prevent skin/eye contact of the material. When your operation involves heating or spraying of the material, and if you expect the isocyanate content level in the work place atmosphere may become above the threshold regulated by OSHA or by other appropriate working place safety standard, we recommend, in addition to the above, installation of a proper hooded dynamic ventilation system and/or using an appropriate type of respirator (such as a full-face respirator equipped with OSHA approved HEPA filters for particulate and organic vapor) to prevent inhalation of the fume.

Direct contact of polyurethane raw materials to skin/eye, as well as ingestion may lead to health problems. No eating or smoking should be permitted at the working area. The operator should wash hands well with soap and water after handling the materials and follow the other procedures of the Standard Industrial Hygiene Practices. Please refer to the MSDS for each component for the detailed health information.

For any questions, please contact Northstar Polymers.

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