



Northstar Polymers (Div. of Tandem Products, Inc.)
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MPP-D70D

Fast Curing, Room-Temperature-Cure Casting Resin System

MPP-D70D is specially made to meet fast production rate. The fast demolding time enables a very fast mold cycle time. The demolding time is approximately 5 minutes. The cured polyurethane polymer of MPP-D70D is highly cross-linked, and has a good load bearing property as well as cut-and-tear resistance property.

Processing Information

System Name: MPP-D70D
Part-A: MPB-025 (Prepolymer)
Part-B: PAB-011 (Curative)

Mixing Ratio: **2: 1 = part-A: part-B by volume** (1: 0.447 by weight)

Pot-Life: Approximately 1 Minute
Demolding Time: 5 Minutes (Tested with a ¼"-thick part in a plastic mold)

Notes:

*The pot life is about 1 minute. You can demold a ¼" thick part in about 5 minutes. The part gets very hot (above 220 °F), please wear a thick glove to handle when demolding. Thinner parts may take longer to develop the demolding strength.

**This material is made from highly reactive components, and it does not contain much of catalyst. So we cannot slow it down by reducing catalyst.

The viscosity of this part-B component is a little bit high: 3,000 cps at room temperature. If you see issues with mixing in the static mixing tube or if you are not getting the mold details because of the higher viscosity, you can heat the part-B material to about 90 – 100 °F range. In this range, the viscosity is down to 500 – 600 cps range, which is more desirable viscosity range. Pot life at 90 F is still close to 1 minute.

You won't have much time to degas when you mix manually. If you put it through your dispenser, you should have much less bubbles in the parts. The enclosed sample is made with part-B temperature around 90 °F. When the viscosity is lower, you mix in much fewer bubbles.





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Component Materials (Typical Properties)

Part-A: MPB-025 (Isocyanate)

General Description: Isocyanate Terminated Prepolymer based on MDI and polyether polyol
NCO: 17.0%
Equivalent Weight: 247
Specific Gravity (Theoretical at 77 °F): 1.131 grams/cm³
Viscosity: 450 cps at 72 °F

Storage/Handling: Store indoor at room temperature between 72 Ambient 72 - 82 °F and 105 °F. The ideal storage temperature is 90 °F. The container head space must be purged to blanket the material with dry nitrogen gas or argon gas.

Part-B: PAB-011 (Curative)

General Description: Curing Agent (Curative) based on polyether polyol, extender, and additives
Equivalent Weight: 111
Specific Gravity (Theoretical at 77 °F): 1.012 grams/cm³
Viscosity: 3,000 cps at 72 °F, 550 cps at 100 °F

Storage/Handling: Store indoor at room temperature between 72 and 105 °F. Avoid moisture entering the product. The constituents tend to separate in container.

Standard Packages:

5-gallon pails (40 pounds per pail)
55-gallon drums (450 pounds per drum)

Storage/Handling Information for the Component Materials

Storage:

Part-A (Isocyanate Prepolymer) Component

Part-A component (prepolymer) contains isocyanate component, which is highly 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 the container to dispense the content, dry nitrogen gas or argon gas needs to be injected to the container to purge and blanket the top space. Please consult Northstar Polymers for nitrogen gas set-up information.





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For gravity feeding system from a 55-gallon, silica gel or calcium chloride desiccant filter(s) should be installed to the vent-hole of the drum. A valve to inject dry nitrogen gas can be installed instead.

During transportation, there is a chance of freezing. The frozen material must be immediately thawed to avoid permanent damage from freezing. If the material color is opaque with the consistency of thick liquid, gel, waxy, or solid, the material requires immediate thawing. The container should be put into an industrial oven at 180 °F until the material temperature is 140 °F or the color of the material is clear with smooth liquid consistency. Storing frozen material at above 35 °F for more than a few days will cause a permanent damage to the material, and it will not be returnable or refundable.

Store the containers a dry indoor storage within the temperature range between 85 and 105 °F. Avoid direct sunlight.

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/amine) 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 the highest 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 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.

Purging the empty space in the container with dry nitrogen gas, argon gas, or negative-40-degree-due-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 72 and 90 °F. Avoid direct sunlight.

Note: Moisture contamination of part-B material can be reversed by heating material to 180 °F and vacuuming it at about 29" Hg or above negative pressure for 20 to 40 minutes.

Part-B material contains chemical constituents that can separate during the storage. Agitation of the part-B content before dispensing may be required for the system.





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Separation can be seen in a higher degree when the material is stored in cold temperature. You may need to heat to re-blend the separated material in some cases. Please consult Northstar Polymers when separation is suspected.

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 Safety Data Sheet (SDS) for detail information on safety and handling of the material. The SDS 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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5/30/2019

