

HAPFLEX 500 SERIES

PHYSICAL PROPERTIES		TEST METHOD	540 540-3	541 541-3	543	560 560-6	561 561-6	564
Mix Ratio by volume A:B	Calculation		100:50	100:50	100:50	100:50	100:50	100:50
			100:50	100:50	100:50	100:55	100:55	100:55
			100:50	100:50	100:50	100:55	100:55	100:55
Gel time 100 grams @ 25°C	ASTM D-2971		20 min.	20 min.	20 min.	45 min.	45 min.	45 min.
			3 min.	3 min.		6 min.	6 min.	
Color (cured)	Visual		Black	Clear Amber	Green	Black	Clear Amber	Grey
Hardness Shore	ASTM D-2240		45 A	45 A	45 A	60 A	60 A	60 A
Viscosity mixed @ 25°C cps	ASTM D-4878		1,280	1,280	1,280	2,250	2,250	2,250
Specific Gravity mixed @ 25°C	ASTM D-4669		1.01	1.01	1.01	1.06	1.06	1.06
Shrinkage inch/inch See shrinkage paragraph	ASTM D-2566		.002-.003	.002-.004	.002-.003	.002-.004	.002-.004	.002-.003
Demold time @ 70°F 1/8" thick	HAPCO TEST		18-24 hrs.	18-24 hrs.	18-24 hrs.	16-24 hrs.	16-24 hrs.	16-24 hrs.
			1-2 hrs.	1-2 hrs.		1-2 hrs.	1-2 hrs.	
Weight per cubic inch (lbs.)	Calculation		0.0365	0.0365	0.0365	0.0383	0.0383	0.0383
PRODUCT PROPERTIES	Tensile Strength (psi)	ASTM D-638	500	500	500	1300	1300	1300
	Elongation %	ASTM D-638	610	610	610	600	600	600
	Tear Strength (pli)	ASTM 624 Die C	70	70	70	86	86	86
	Modulus of Elasticity psi (000)	ASTM D-638	0.30	0.30	0.30	0.43	0.43	0.43
	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 psi (000)	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 41-42.

HAPFLEX 500 SERIES

PHYSICAL PROPERTIES		TEST METHOD	565 565-3	566 566-3	570 570-6	571 571-6	573
PHYSICAL PROPERTIES	Mix Ratio by volume A:B	Calculation	100:100	100:100	100:40	100:40	100:40
	by weight A:B		100:100	100:100	100:40	100:40	100:40
	Gel time 100 grams @ 25°C	ASTM D-2971	20 min. 3 min.	20 min. 3 min.	40 min. 6 min.	40 min. min. 6 min.	40 min.
	Color (cured)	Visual	Black	Clear Amber	Black	Clear Amber	Orange
	Hardness Shore	ASTM D-2240	65 A	65 A	70 A	70 A	70 A
	Viscosity mixed @ 25°C cps	ASTM D-4878	670	670	3,900	3,900	3,900
	Specific Gravity mixed @ 25°C	ASTM D-4669	1.05	1.05	1.07	1.07	1.07
	Shrinkage inch/inch See shrinkage paragraph	ASTM D-2566	.002-.004	.002-.004	.002-.003	.002-.003	.002-.003
	Demold time @ 70°F 1/8" thick	HAPCO TEST	4-6 hrs. 30- 60 min.	4-6 hrs. 30- 60 min.	8-12 hrs. 2-4 hrs.	8-12 hrs. 2-4 hrs.	8-12 hrs.
	Weight per cubic inch (lbs.)	Calculation	0.0379	0.0379	0.0386	0.0386	0.0386
PRODUCT PROPERTIES	Tensile Strength (psi)	ASTM D-638	900	900	1,900	1,900	1,900
	Elongation %	ASTM D-638	500	500	575	575	575
	Tear Strength (pli)	ASTM 624 Die C	82	82	142	142	142
	Modulus of Elasticity psi (000)	ASTM D-638	0.60	0.60	0.60	0.60	0.60
	Izod Impact (ft.lbs/in.) notched unnotched	ASTM D-256	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
	Flexural Strength (psi)	ASTM D-790	NA	NA	NA	NA	NA
	Flexural Modulus psi (000)	ASTM D-790	NA	NA	NA	NA	NA

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PHYSICAL PROPERTIES	TEST METHOD	580	581-3	595-	596	598	599	
		580-3	581-3	595-3	596-3	598-3		
PHYSICAL PROPERTIES	Mix Ratio by volume A:B	Calculation	100:74	100:74	100:50	100:50	100:50	100:50
	by weight A:B		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	83 A	83 A	95 A	95 A	95 A	95 A
	Viscosity mixed @ 25°C cps	ASTM D-4878	1,120	1,120	1,850	1,850	1,850	1,850
	Specific Gravity mixed @ 25°C	ASTM D-4669	1.07	1.07	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. 20- 40 min.	5-8 hrs. 20- 40 min.	5-8 hrs. 20- 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	1,540	1,540	2,700	2,700	2,700	2,700
	Elongation %	ASTM D-638	475	475	375	375	375	375
	Tear Strength (pli)	ASTM 624 Die C	275	275	236	236	236	236
	Modulus of Elasticity psi (000)	ASTM D-638	2.2	2.2	4.3	4.3	4.3	4.3
	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 psi (000)	ASTM D-790	NA	NA	NA	NA	NA	NA	

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