

TP-4004 – SPECIFICATIONS



This casting material is a tough, impact resistant polyurethane formulated for vacuum casting and short mold cycle times. It simulates high impact Thermoplastic Olefin (TPO) materials for a range of prototyping and production applications. It can be easily colored with a wide range of colors.

CURED PROPERTIES

	CURE 1: 1 HOUR @ 150°F + 24 HOURS @ 77°F	CURE 2: 1 HOUR @ 150°F + 7 DAYS @ 77°F
Hardness ASTM D-2240	65 ± 5 Shore D	70 ± 5 Shore D
Flexural modulus ASTM D-790	85,000 psi	115,000 psi
Flexural strength, Ultimate ASTM D-790	4,000 psi	5,000 psi
Tensile strength ASTM D-638	4,000 psi	5,500 psi
Elongation at break ASTM D-638	70%	55%
Impact strength, Notched Izod ASTM D-256	7.0 ft.- lb./in.	6.0 ft.-lb./in.
Heat deflection temperature ASTM D-648 @66 psi	212°F	250°F
Heat deflection temperature ASTM D-648 @264 psi	181°F	207°F
Specific gravity	1.17 g/cm3	1.17 g/cm3
Linearshrink ASTM D-2566	0.005	0.005

APPLICATIONS

Commercial producttesting
Functional assembly
Public surveys
Field testing
Visual evaluation
Aesthetic evaluation