



**TSE Industries, Inc.**  
**Millathane® Millable Polyurethane Division**  
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## Millathane® CM Molding Compounds

40616-	A	B	C	D
Millathane® CM	100	100	100	100
Zinc Stearate	0.5		0.5	
Stearic Acid		0.25		0.25
HiSil 233	30	30		
N330 Black			30	30
Silquest A189	0.5			
Silquest A172-50%		1		
TP-95	10	10	10	10
Vanfre AP-2	0.5	0.5	0.5	0.5
DiCup 40C		1.5		1.5
MBTS	4		4	
MBT	2		2	
Thanecure® ZM	1		1	
Sulfur	2		2	
	150.5	143.25	150	142.25

### Mooney Viscosity

ML(1+4)/100°C	66	74	58	67
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### MDR, 30'/160°C

ML, lb-in	2.3	3.1	1.4	2.2
MH, lb-in	33.4	29.0	31.3	9.9
ts1, minutes	2.6	0.5	2.0	1.0
t50, minutes	5.2	2.9	4.1	2.8
t90, minutes	8.5	9.0	7.1	7.3

### Press Cure 10'/160°C

Hardness, Shore A	65	68	68	62
100% Modulus, psi	330	280	460	185
MPa	2.3	1.9	3.2	1.3
300% Modulus, psi	1480	1050	2030	850
MPa	10.2	7.2	14.0	5.9
Tensile Strength, psi	5750	4360	4990	3530
MPa	39.7	30.1	34.4	24.3
Elongation, %	600	560	530	680

### Press Cure 15'/160°C

Hardness, Shore A	65	65	66	57
100% Modulus, psi	365	335	445	165
MPa	2.5	2.3	3.1	1.1
300% Modulus, psi	1820	1410	2080	780
MPa	12.6	9.7	14.3	5.4
Tensile Strength, psi	5090	4450	4610	3280
MPa	35.1	30.7	31.8	22.6
Elongation, %	520	490	500	680

Ref: 20070426\_tlj\_40616.xls

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