



TSE Industries, Inc.
Millathane® Millable Polyurethane Division
 4370 112th Terrace North
 Clearwater, FL 33762 (USA)
 727-573-7676 or 800-237-7634 www.tse-industries.com



Mold Shrinkage of Millathane® 5004

Cure conditions:

Millathane 5004 lot 16F1		Millathane 5004 lot 13F1	
25'/171C	35'/160C	25'/171C	35'/160C

Doughnut/washer-shaped (ID/OD) Mold*

Dimensional Change (shrinkage), %

OD	2.3	2.1	2.4	2.0
ID	2.5	3.3	2.6	2.3
Depth	0.2	1.2	0.6	1.8

Bar Mold**

Dimensional Change (shrinkage), %

Length	2.3	2.2	2.2	2.5
Width	1.9	1.7	1.9	1.9
Depth	1.0	1.6	1.8	1.2

Formulation

Millathane 5004	100
Stearic Acid	0.25
N-330 Black	20
Di-Cup 40C	4
Total	124.25

Observations:

In the compound and molding conditions indicated, the two lots of Millathane 5004 had similar mold shrinkage of approximately 2 - 2 1/2%.

Other formulas and/or other mold configurations and molding conditions may yield different results.

*Outside Diameter = 2.998 in., Inside Diameter = 2.000 in., Depth = 0.503 in.

**Length = 4.000 in., Width = 0.752 in., Depth = 0.502 in.



Ref: XP3410 tlj 8/2004