

# BJB Polyurethane F-25 A/B

Polyurethane Thermoset Elastomer

BJB Enterprises, Inc.

Message:

The F-25 A/B is a production oriented material system, that features a one to two hour demold time depending on part size and configuration. F-25 A/B has a 10-minute work time, which allows ample time to mix, vacuum de-gas and pour air-free parts.

Product Highlights:

Short demold time permitting good mold turn over

Ideal for intricate and flexible mold production

Exceptionally tough and resilient

Very easy to use

General Information			
Features	Ultra high toughness		
	Elastic		
Uses	Mold/Mold/Tool		
Appearance	Translucent		
	Yellow		
Forms	Liquid		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
-- <sup>1</sup>	1.02	g/cm <sup>3</sup>	ASTM D792
--	1.03	g/cm <sup>3</sup>	
-- <sup>2</sup>	1.05	g/cm <sup>3</sup>	
Shrinkage	0.90	%	ASTM D2566
Gel Time	15.0 - 17.0	min	
Work Time <sup>3</sup> (25°C)	10.0 - 12.0	min	
Cure Time (25°C)	5.0 - 7.0	day	
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A)	20 - 30		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	2.38	MPa	ASTM D412
Tensile Elongation (Break)	1100	%	ASTM D412
Tear Strength	7.88	kN/m	ASTM D624
Compression Set	36	%	ASTM D395
Thermoset	Nominal Value	Unit	Test Method
Thermoset Components			
Component a	Mixing ratio by weight: 60, mixing ratio by capacity: 58		
Component B	Mixing ratio by weight: 100, mixing ratio by capacity: 100		
Shelf Life	26	wk	

Thermoset Mix Viscosity			Brookfield
25°C <sup>4</sup>	3700	cP	Brookfield
25°C <sup>5</sup>	550	cP	Brookfield
25°C	1200	cP	Brookfield
Demold Time (25°C)	60 - 120	min	
Additional Information	Nominal Value	Unit	Test Method

In order to achieve maximum physical properties, a post cure with heat is required. BJB recommends 24 hours at ambient temperature, 77°F (25°C), followed by 16 hours at 130-160°F (54-71°C).

#### NOTE

- |    |           |
|----|-----------|
| 1. | Part B    |
| 2. | Part A    |
| 3. | 100g mass |
| 4. | Part A    |
| 5. | Part B    |

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