

# BJB Polyurethane F-42 A/B

Polyurethane Thermoset Elastomer

BJB Enterprises, Inc.

Message:

The F-42 A/B system is a production oriented fast gel and fast de-mold material. It features a working time which allows time to mix, vacuum de-gas, and pour air-free parts. F-42 A/B can be demolded in 2-3 hours at ambient temperature, depending on part size and configuration. F-42 A/B contains UV stabilizers to provide added protection when used in outdoor applications.

Product Highlights:

- Rapid demolds
- Ideal for part production
- Does not contain MOCA, MDA, or TDI
- Very easy to use

General Information			
Additive	UV stabilizer		
Features	Good UV resistance		
	Rapid solidification crystal point		
	Good demoulding performance		
RoHS Compliance	RoHS compliance		
Appearance	Translucent		
	Yellow		
Forms	Liquid		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.09	g/cm <sup>3</sup>	ASTM D792
Specific Gravity			
Part A	1.11		
Part B	1.02		
Gel Time	15.0 - 17.0	min	
Work Time (25°C) <sup>1</sup>	10.0 - 12.0	min	
Cure Time (25°C)	5.0 - 7.0	day	
Molding Shrinkage - Flow	0.10	%	ASTM D2566
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A)	37 - 47		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Strength (Break)	5.03	MPa	ASTM D412
Tensile Elongation (Break)	660	%	ASTM D412
Tear Strength	13.3	kN/m	ASTM D624
Thermoset	Nominal Value	Unit	Test Method
Thermoset Components			
Component a	Mixing ratio by weight: 100, mixing ratio by capacity: 92		

Component B	Mixing ratio by weight: 100, mixing ratio by capacity: 100		
Shelf Life (24°C)	26	wk	
Thermoset Mix Viscosity			Brookfield
25°C	850	cP	Brookfield
25°C <sup>2</sup>	750	cP	Brookfield
25°C <sup>3</sup>	550	cP	Brookfield
Demold Time (25°C)	120 - 180	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.	100g mass		
2.	Part B		
3.	Part A		

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