

Machine Cast MC-165 A/B

Polyurethane Thermoset Elastomer

BJB Enterprises, Inc.

Message:

The MC-165 A/B system is a production oriented fast gel and fast de-mold system. It features a mix ratio and working time ideal for machine dispensing and rapid part mold cycling, for production applications. It also features excellent adhesion to metal, plastics, wood, and is ideal for many potting applications.

General Information			
Features	Fast molding cycle		
	Good adhesion		
RoHS Compliance	RoHS compliance		
Appearance	Translucent		
	Yellow		
Forms	Liquid		
Processing Method	Casting		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
-- ¹	0.988	g/cm ³	ASTM D792
--	1.10	g/cm ³	
-- ²	1.14	g/cm ³	
Shrinkage ³	0.70	%	
Demold Time (25°C, 9.53 mm)	1.5 - 2.0	hr	
Gel Time	2.3	min	
Work Time ⁴ (25°C)	2.0	min	
Cure Time (25°C)	5.0 - 7.0	day	
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	63 - 67		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	254	MPa	ASTM D638
Tensile Strength (Yield)	18.7	MPa	ASTM D638
Tensile Elongation (Yield)	35	%	ASTM D638
Flexural Modulus	293	MPa	ASTM D790
Flexural Strength	9.38	MPa	ASTM D790
Elastomers	Nominal Value	Unit	Test Method
Tear Strength	46.8	kN/m	ASTM D624
Impact	Nominal Value	Unit	Test Method
Unnotched Izod Impact	80	J/m	ASTM D256
Electrical	Nominal Value		Test Method

Dielectric Constant (1 MHz)	3.57		ASTM D150
Dissipation Factor (1 MHz)	0.033		ASTM D150
Thermoset	Nominal Value	Unit	Test Method
Thermoset Components			
Component a	Mixing ratio by weight: 100, mixing ratio by capacity: 100		
Component B	Mixing ratio calculated by weight: 87, mixing ratio calculated by capacity: 100		
Shelf Life	26	wk	
Thermoset Mix Viscosity (25°C)	770	cP	Brookfield
Additional Information	Nominal Value	Unit	Test Method

Note: Physical properties obtained from test specimens post cured per recommended procedure. 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 160° - 180°F (71° - 82°C). Support of the part may be required to prevent part deformation during heat cure.

NOTE	
1.	Part B
2.	Part A
3.	12"x1/2"x1/2"
4.	100g mass

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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