

BJB Polyurethane F-64 A/B

Polyurethane Thermoset Elastomer

BJB Enterprises, Inc.

Message:

The F-64 A/B system is a production oriented fast gel and fast de-mold material. It features a work life which allows sufficient time to vacuum de-gas and pour air-free parts. F-64 A/B is a 100% reacted material system which produces an oil-free dry surface and can be demolded in as little as two hours depending on part size and configuration.

- Product Highlights:
- Rapid demolds
 - Ideal for part production
 - Does not contain MOCA, MDA, or TDI
 - Very easy to use
 - Excellent physical properties

General Information			
Features	Fast Gel		
Uses	Molds/Dies/Tools		
RoHS Compliance	RoHS Compliant		
Appearance	Translucent		
Forms	Liquid		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
-- ¹	1.03	g/cm ³	ASTM D792
--	1.07	g/cm ³	
-- ²	1.11	g/cm ³	
Shrinkage	0.50	%	ASTM D2566
Gel Time	9.0	min	
Work Time ³ (25°C)	7.0	min	
Cure Time	3.0 to 5.0	day	
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A)	63 to 67		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			
100% Strain	2.60	MPa	
200% Strain	3.96	MPa	
300% Strain	5.27	MPa	
Tensile Strength (Break)	8.27	MPa	ASTM D412
Tensile Elongation (Yield)	520	%	ASTM D412
Tear Strength	21.9	kN/m	ASTM D624
Thermoset	Nominal Value	Unit	Test Method
Thermoset Components			
Part A	Mix Ratio by Weight: 70, Mix Ratio by Volume: 64		
Part B	Mix Ratio by Weight: 100, Mix Ratio by Volume: 100		

Shelf Life (25°C)	26	wk
Thermoset Mix Viscosity		Brookfield
25°C ⁴	2170	cP
25°C ⁵	886	cP
25°C	1390	cP
Demold Time (25°C)	120 to 180	min
Post Cure Time (66°C)	4.0	hr

NOTE

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

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