

BJB Polyurethane WC-784 A/B

Polyurethane

BJB Enterprises, Inc.

Message:

WC-784 A/B is an impact resistant, rigid, 82 Shore D material that is commonly used to make clear or tinted castings of all kinds. When used at room temperature, castings 1/8" thick or larger can be readily cast. Castings that are less than 1/8" thick generally require a mild post-cure.

Features:

Exceptional clarity

Impact resistant

No odor

Good weatherability

General Information			
Features	Impact resistance, good		
	Good weather resistance		
	The smell is low to none		
	Definition, high		
	Medium hardness		
RoHS Compliance	RoHS compliance		
Appearance	Clear/transparent		
Forms	Liquid		
Processing Method	Casting		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			ASTM D792
-- ¹	1.03	g/cm ³	ASTM D792
-- ²	1.08	g/cm ³	ASTM D792
--	1.05	g/cm ³	ASTM D792
Molding Shrinkage - Flow ³	0.40	%	
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	80 - 84		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1790	MPa	ASTM D638
Tensile Strength (Yield)	45.9	MPa	ASTM D638
Tensile Elongation (Yield)	65	%	ASTM D638
Flexural Modulus	2210	MPa	ASTM D790
Flexural Strength	75.8	MPa	ASTM D790
Compressive Modulus	2410	MPa	ASTM D695
Compressive Strength	57.6	MPa	ASTM D695
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	53	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method

Deflection Temperature Under Load (0.45 MPa, Unannealed)	70.0	°C	ASTM D648
Thermoset	Nominal Value	Unit	
Thermoset Components			
Component a	Mixing ratio by weight: 100, mixing ratio by capacity: 100		
Component B	Mixing ratio by weight: 85, mixing ratio by capacity: 89		
Shelf Life	26	wk	
Demold Time (25°C)	120 - 180	min	
Gel Time	7.0 - 8.0	min	
Work Time (25°C) ⁴	6.0 - 7.0	min	
Brokfield Viscosity			
Mixed : 25°C	600 - 700	mPa · s	
Part A : 25°C	650	mPa · s	
Part B : 25°C	550	mPa · s	
Cure Time (25°C)	5.0 - 7.0	day	
Additional Information	Nominal Value	Unit	
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 180°F (82°C). Support of the part may be required to prevent part deformation during the heat curing process.			
NOTE			
1.	Part B		
2.	Part A		
3.	12"X1/2"X1/2"		
4.	100g mass		

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