

BJB Polyurethane F-70 A/B

Polyurethane Thermoset Elastomer

BJB Enterprises, Inc.

Message:

The F-70 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-70 A/B can be demolded in as little as one hour 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	Rapid solidification crystal point		
Uses	Mold/Mold/Tool		
RoHS Compliance	RoHS compliance		
Appearance	Translucent		
	Yellow		
Forms	Liquid		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
-- ¹	1.02	g/cm ³	
-- ²	1.13	g/cm ³	
--	1.11	g/cm ³	ASTM D792
Shrinkage	0.20	%	ASTM D2566
Gel Time	4.0 - 5.0	min	
Work Time ³ (25°C)	3.0 - 4.0	min	
Cure Time (25°C)	5.0 - 7.0	day	
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A)	65 - 75		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ASTM D412
100% strain	2.96	MPa	ASTM D412
200% strain	4.55	MPa	ASTM D412
300% strain	6.21	MPa	ASTM D412
Tensile Strength (Break)	6.48	MPa	ASTM D412
Tensile Elongation (Break)	320	%	ASTM D412
Tear Strength	15.2	kN/m	ASTM D624
Thermoset	Nominal Value	Unit	Test Method
Thermoset Components			

Component a	Mixing ratio by weight: 100, mixing ratio by capacity: 90		
Component B	Mixing ratio by weight: 100, mixing ratio by capacity: 100		
Shelf Life	26	wk	
Thermoset Mix Viscosity			Brookfield
25°C ⁴	550	cP	Brookfield
25°C ⁵	690	cP	Brookfield
25°C	620	cP	Brookfield
Demold Time (25°C)	60 - 120	min	
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°F (71°C).

NOTE

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

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