

Vacuum Cast V-825 A/B

Polyurethane Thermoset Elastomer

BJB Enterprises, Inc.

Message:

V-825 A/B is a rigid 84 Shore D polyurethane system that exhibits exceptional physical properties. It is a high performance material that features high heat deflection capability and a low shrink factor. V-825 is a transparent, virtually colorless casting material that allows for unrestricted tinting and precise color matching. This product is ideal for producing intrinsically colored parts requiring a non-painted finish. This product can be easily processed with meter-mix-dispense, pressure or vacuum cast equipment.

General Information			
Features	Low viscosity		
	Impact resistance, high		
	Heat resistance, high		
	The smell is low to none		
	Low shrinkage		
Appearance	Yellow		
	Clear/transparent		
Forms	Liquid		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792
Molding Shrinkage - Flow (12.7 mm)	0.10	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	84		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2280	MPa	ASTM D638
Tensile Strength	69.4	MPa	ASTM D638
Tensile Elongation (Break)	11	%	ASTM D638
Flexural Modulus	2480	MPa	ASTM D790
Flexural Strength	94.5	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	61	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	87.8	°C	ASTM D648
1.8 MPa, not annealed	76.7	°C	ASTM D648
Thermoset	Nominal Value	Unit	Test Method
Thermoset Mix Viscosity (25°C)	450	cP	ASTM D2393
Demold Time (25°C)	120 - 180	min	
Post Cure Time (52°C)	2.0 - 4.0	hr	

Additional Information

Mix ratio by weight: 100/60 Mix ratio by volume: 100/66 Work time, 100 g, 77°F: 6-8 min Gel Time: 7-9 min

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