

# Machine Cast MC-90 A/B

Polyurethane Thermoset Elastomer

BJB Enterprises, Inc.

## Message:

The MC-90 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.

### PRODUCT HIGHLIGHTS:

Designed for meter-mix dispense machine casting

Does not contain MOCA, MDA or TDI

Provides very rapid production cycle

Convenient 1:1 by volume mix ratio

General Information			
Features	Fast Molding Cycle		
Appearance	Translucent		
	Yellow		
Forms	Liquid		
Processing Method	Casting		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			ASTM D792
-- <sup>1</sup>	1.06	g/cm <sup>3</sup>	
--	1.11	g/cm <sup>3</sup>	
-- <sup>2</sup>	1.12	g/cm <sup>3</sup>	
Specific Volume	0.918	cm <sup>3</sup> /g	
Gel Time	1.8	min	
Work Time <sup>3</sup> (25°C)	1.3	min	
Molding Shrinkage - Flow	0.65	%	ASTM D2566
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A)	85 to 95		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ASTM D412
100% Strain	3.87	MPa	
200% Strain	5.18	MPa	
300% Strain	6.35	MPa	
Tensile Strength (Yield)	19.7	MPa	ASTM D412
Tensile Elongation (Break)	550	%	ASTM D412
Tear Strength	52.5	kN/m	ASTM D624
Thermoset	Nominal Value	Unit	Test Method
Thermoset Components			
Part A	Mix Ratio by Weight: 100, Mix Ratio by Volume: 100		
Part B	Mix Ratio by Weight: 95, Mix Ratio by Volume: 100		

Shelf Life	26	wk	
Thermoset Mix Viscosity			ASTM D2393
25°C <sup>4</sup>	1500	cP	
25°C <sup>5</sup>	2300	cP	
25°C <sup>6</sup>	1900	cP	
Demold Time (25°C)	10	min	
Post Cure Time (25°C)	120 to 170	hr	

#### NOTE

- |    |                    |
|----|--------------------|
| 1. | Part B             |
| 2. | Part A             |
| 3. | 100g mass          |
| 4. | Part B, Brookfield |
| 5. | Part A, Brookfield |
| 6. | Mixed, Brookfield  |

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