

Machine Cast MC-70 A/B

Polyurethane Thermoset Elastomer

BJB Enterprises, Inc.

Message:

The MC-70 A/B system is a production oriented fast gel and fast de-mold system. It features a working time ideal for machine dispensing and rapid part mold cycling, for production applications.

PRODUCT HIGHLIGHTS:

Non-mercury based catalyst system

Designed for meter-mix dispense machine casting

Does not contain MOCA, MDA or TDI

Provides very rapid production cycle

General Information			
Features	Fast Molding Cycle		
Appearance	Off-White		
	Translucent		
Forms	Liquid		
Processing Method	Casting		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			ASTM D792
-- ¹	1.05	g/cm ³	
--	1.10	g/cm ³	
-- ²	1.13	g/cm ³	
Specific Volume	0.918	cm ³ /g	
Gel Time	1.1	min	
Work Time ³ (25°C)	45.0	sec	
Molding Shrinkage - Flow	0.76	%	ASTM D2566
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A)	60 to 70		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1.99	MPa	ASTM D412
Elastomers	Nominal Value	Unit	Test Method
Tensile Strength (Break)	11.3	MPa	ASTM D412
Tensile Elongation (Break)	380	%	ASTM D412
Tear Strength ⁴	24.2	kN/m	ASTM D624
Electrical	Nominal Value		Test Method
Dielectric Constant (1 MHz)	5.68		ASTM D150
Dissipation Factor (1 MHz)	0.11		ASTM D150
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: 93, Mix Ratio by Volume: 100	
Shelf Life	26	wk
Thermoset Mix Viscosity		ASTM D2393
25°C ⁵	300	cP
25°C ⁶	300	cP
25°C ⁷	300	cP
Demold Time (25°C)	5.0 to 10	min
Post Cure Time (25°C)	120 to 170	hr

NOTE

1. Part B
2. Part A
3. 100g mass
4. Die C
5. Part B, Brookfield
6. Part A, Brookfield
7. Mixed, Brookfield

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