

BJB Polyurethane F-60 A/B

Polyurethane Thermoset Elastomer

BJB Enterprises, Inc.

Message:

The F-60 A/B system is a production oriented fast gel and fast de-mold material. It features a work life which allows sufficient time to vacuum de-gas and pour air-free parts. F-60 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

General Information			
Features	Rapid solidification crystal point		
	Good demoulding performance		
Uses	Mold/Mold/Tool		
RoHS Compliance	RoHS compliance		
Appearance	Translucent		
	Yellow		
Forms	Liquid		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
-- ¹	1.03	g/cm ³	ASTM D792
--	1.06	g/cm ³	
-- ²	1.13	g/cm ³	
Specific Volume	0.939	cm ³ /g	ASTM D2566
Shrinkage	0.30	%	
Gel Time	8.0 - 9.0	min	
Work Time ³ (25°C)	6.0 - 7.0	min	
Cure Time (25°C)	5.0 - 7.0	day	
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A)	55 - 65		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ASTM D412
100% strain	2.15	MPa	ASTM D412
200% strain	3.43	MPa	ASTM D412
300% strain	4.30	MPa	ASTM D412
Tensile Strength (Yield)	4.72	MPa	ASTM D412
Tensile Elongation (Break)	300	%	ASTM D412
Tear Strength	9.98	kN/m	ASTM D624

Thermoset	Nominal Value	Unit	Test Method
Thermoset Components			
Component a	Mixing ratio by weight: 50, mixing ratio by capacity: 46		
Component B	Mixing ratio by weight: 100, mixing ratio by capacity: 100		
Shelf Life (25°C)	26	wk	
Thermoset Mix Viscosity			Brookfield
-14°C ⁴	850	cP	Brookfield
25°C	930	cP	Brookfield
25°C ⁵	550	cP	Brookfield
Demold Time (25°C)	60 - 120	min	
Additional Information	Nominal Value	Unit	Test Method

Note: Reported physical properties based on elevated temperature cured test specimens. 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

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

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