



**SHORE A POLYURETHANES**

"Dedicated to QUALITY, SERVICE, SAFETY, and INNOVATION"

**F-15 A/B**  
**15 SHORE A POLYURETHANE ELASTOMER**

**PRODUCT HIGHLIGHTS:**

- Resists moisture absorption
- Very easy to use
- Cures at room temperature
- Highly resilient, tough, stretchy and tack free
- Quick demold time, low viscosity

**PHYSICAL PROPERTIES:**

Hardness, Shore A ASTM D2240-04e1 .....	15 ± 5
Density, (g/cc) ASTM D792-00 .....	1.02
Cubic Inches per Pound.....	27.3
Color/Appearance.....	Pale yellow/clear
Tensile Strength, (psi) ASTM D412-98a(2002)e1 .....	235
Elongation, (%) ASTM D412-98a(2002)e1 .....	600
Tear Strength, (pli) ASTM D624-00e1.....	24
Shrinkage, (in /in) linear ASTM D2566-.....	0.008

**HANDLING PROPERTIES:**

Mix Ratio (by weight):	
Part A .....	45 parts by weight
Part B .....	100 parts by weight
Mix Ratio (by volume):	
Part A .....	43 parts by volume
Part B .....	100 parts by volume
Specific Gravity:	
Part A .....	1.05
Part B .....	1.00
Viscosity, (cps) @ 77°F (25°C) Brookfield:	
Part A .....	4,000
Part B .....	250
Mixed.....	1,150
Color:	
Part A .....	Pale yellow
Part B .....	Amber
Work Time, (100-gram mass) @ 77°F (25°C).....	20 minutes
Gel Time .....	25 minutes
Demold Time @ 77°F (25°C).....	2-3 hours (See <u>NOTE</u> )

**CURE SCHEDULE/HEAT CURING:**

Most of the physical properties can be achieved in 5-7 days at ambient temperature, 77°F (25°C). 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:**

Demold times can be reduced with a mild post-cure at elevated temperatures of 130° - 160°F (54° - 71°C). Prolonged direct exposure to sunlight can affect the surface of this product. Cover molds or other products when storing outdoors. **The cure will be inhibited if cast against a tin catalyzed silicone RTV.**

**STORAGE:**

Store in a cool dry place. Unopened containers will have a shelf life of 6 months from the date of shipment when properly stored at room temperatures. Purge opened containers with dry nitrogen before re-sealing.

**PACKAGING:**

Gallon kits.....	3.6 lbs. A, 8 lbs. B
5 Gallon kits.....	18 lbs. A, 40 lbs. B
Drum kits .....	180 lbs. A, 400 lbs. B

**SAFETY PRECAUTIONS:**

Use in a well-ventilated area. Avoid contact with skin using protective gloves and protective clothing. Repeated or prolonged contact on the skin may cause an allergic reaction.

Eye protection is extremely important. Always use approved safety glasses or goggles when handling this product.

**IF CONTACT OCCURS:**

**Skin:** Immediately wash with soap and water. Remove contaminated clothing and launder before reuse. It is *not* recommended to remove resin from skin with solvents. Solvents only increase contact and dry skin. Seek qualified medical attention if allergic reactions occur.

**Eyes:** Immediately flush with water for at least 15 minutes. Call a physician.

**Ingestion:** If swallowed, call a physician immediately. Remove stomach contents by gastric suction or induce vomiting only as directed by medical personnel. Never give anything by mouth to an unconscious person.

**Refer to the Material Safety Data Sheet before using this product.**