



SHORE A POLYURETHANES

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

F-25 A/B
25 SHORE A POLYURETHANE ELASTOMER
RATIO: 60/100

PRODUCT DESCRIPTION:

The F-25 A/B is a production oriented material system, that features a one to two hour demold time depending on part size and configuration. F-25 A/B has a 10-minute work time, which allows ample time to mix, vacuum de-gas, and pour air-free parts.

PRODUCT HIGHLIGHTS:

- Short demold time permitting good mold turn over
- Ideal for intricate and flexible mold production
- Exceptionally tough and resilient
- Very easy to use

PHYSICAL PROPERTIES:

Hardness, Shore A ASTM D2240	25 ± 5
Density, (g/cc) ASTM D792	1.03
Cubic Inches per Pound.....	26.9
Color/Appearance.....	Pale yellow/translucent
Tensile Strength, (psi) ASTM D412.....	345
Elongation, (%) ASTM D412	1,100
Tear Strength, (pli) ASTM D624.....	45
Shrinkage, (in/in) linear ASTM D2566	0.009
Compression Set, (%) ASTM D395	36

HANDLING PROPERTIES:

Mix Ratio (by weight):

Part A	60 parts by weight
Part B	100 parts by weight

Mix Ratio (by volume):

Part A	58 parts by volume
Part B	100 parts by volume

Specific Gravity @ 77°F (25°C):

Part A	1.05
Part B	1.02

Viscosity, (cps) @ 77°F (25°C) Brookfield:

Part A	3,700
Part B	550
Mixed.....	1,200

HANDLING PROPERTIES (continued):

Color:

Part APale yellow
Part BAmber

Work Time, (100-gram mass) @ 77°F (25°C).....10 - 12 minutes

Gel Time15 - 17 minutes

Demold Time @ 77°F (25°C).....1 - 2 hours

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 130-160°F (54-71°C).

NOTE:

F-25 Part A is moisture sensitive. Open containers of material should be purged with dry nitrogen prior to replacing lids or caps to prevent moisture contamination. 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 temperature. Purge opened containers with dry nitrogen before re-sealing.

PACKAGING:

Gallon kits4.8 lbs. A, 8 lbs. B
5 Gallon kits24 lbs. A, 40 lbs. B
55 Gallon kits240 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 laundry 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.