



F-64 A/B

65 SHORE A POLYURETHANE ELASTOMER

PRODUCT HIGHLIGHTS:

- Rapid demolds
- Ideal for part production
- Does not contain MOCA, MDA, or TDI
- Very easy to use
- Excellent physical properties

PRODUCT DESCRIPTION:

The F-64 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-64 A/B is a 100% reacted material system which produces an oil-free dry surface and can be demolded in as little as two hours depending on part size and configuration.

TYPICAL PRODUCT USES:

- ◆ Shock absorbent bumpers and pads
- ◆ Potting and encapsulation
- ◆ Tires for models of all kinds
- ◆ Small molds
- ◆ Cable connector sealer

PHYSICAL PROPERTIES:

| | |
|---|---------------------|
| Hardness, Shore A ASTM D-2240 | 65 ± 2 |
| Specific Gravity, (g/cc) cured ASTM D-792 | 1.07 |
| Cubic Inches Per Pound | 26.2 |
| Color/Appearance..... | Translucent Neutral |
| Tensile Strength, (psi) ASTM D-412 | 1,200 |
| Elongation, (%) ASTM D-412 | 515 |
| Tear Strength, (pli) ASTM D-624 | 125 |
| Modulus of Elasticity, (psi): | |
| @ 100% Strain | 377 |
| @ 200% Strain | 575 |
| @ 300% Strain | 764 |
| Shrinkage, (in./in.) linear ASTM D-2566 | 0.005 |

HANDLING PROPERTIES:

| | |
|--|--|
| Mix Ratio (by weight): | |
| Part A..... | 70 parts by weight |
| Part B..... | 100 parts by weight |
| Mix Ratio (by volume): | |
| Part A..... | 64 parts by volume |
| Part B..... | 100 parts by volume |
| Specific Gravity, (g/cc): | |
| Part A..... | 1.11 |
| Part B..... | 1.03 |
| Viscosity, (cps) @ 77°F (25°C) Brookfield: | |
| Part A..... | 2,170 |
| Part B..... | 886 |
| Initial Mixed Viscosity..... | 1,390 |
| Work Time, (100g mass) @ 77°F (25°C)..... | 7 minutes |
| Gel Time..... | 9 minutes |
| Demold Time @ 77°F (24°C)..... | 2 - 3 hours |
| Cure Schedule..... | Full cure in 3 - 5 days or post cure at 150° F (66° C) for 4 hours |

NOTE:

The F-64 B, in liquid form, will darken with age. Opened containers of material should be purged with dry nitrogen prior to replacing lids or caps to prevent moisture contamination.

STORAGE:

Store containers at room temperature in a dry place. Unopened containers will have a shelf life of 6 months, from date of shipment, when properly stored under normal conditions at 77°F (25°C).

PACKAGING:

| | |
|---------------------|------------------------|
| 1 Gallon kits..... | 5.6 lbs. A, 8 lbs. B |
| 5 Gallon kits..... | 28 lbs. A, 40 lbs. B |
| 55 Gallon kits..... | 280 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. 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.

NON-WARRANTY "Except for a warranty that materials substantially comply with the data presented in Manufacturer's latest bulletin describing the product (the basis for this substantial compliance is to be determined by the standard quality control tests generally performed by Manufacturer), all materials are sold "AS IS" and without any warranty express or implied as to merchantability, fitness for a particular purpose, patent, trademark or copyright infringement, or as to any other matter. In no event shall Manufacturer's liability for damages exceed Manufacturer's sale price of the particular quantity with respect to which damages are claimed."