



MC-165 A/B MACHINE CASTABLE 65 SHORE D POLYURETHANE ELASTOMER RATIO: 100/100 PBV

PRODUCT DESCRIPTION:

The MC-165 A/B system is a production oriented fast gel and fast de-mold system. It features a mix ratio and working time ideal for machine dispensing and rapid part mold cycling, for production applications. It also features excellent adhesion to metal, plastics, wood, and is ideal for many potting 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
- Convenient 1:1 by volume mix ratio

PHYSICAL PROPERTIES:

Hardness, Shore D ASTM D 2240-04e1	65±2
Density, (g/cc) ASTM D 792-00	1.1
Cubic Inches Per Pound	25.9
Color/Appearance.....	Pale Yellow/Translucent
Tensile Strength, (psi) ASTM D 638-03	2,710
Tensile Modulus, (psi) ASTM D 638-03	36,840
Elongation, (%) ASTM D 638-03	35
Flexural Strength, (psi) ASTM D 790-03	1,360
Flexural Modulus, (psi) ASTM D 790-03.....	42,470
Tear Strength, (pli) ASTM D 624-00e1	267
Shrinkage, (in/in) linear (12" x 1/2" x 1/2").....	0.007
Izod Impact, (ft-lb/in) ASTM D 256-05.....	1.5

Note: Physical properties obtained from test specimens post cured per recommended procedure.

HANDLING PROPERTIES:

Mix Ratio (by weight):

Part A.....	100 parts by weight
Part B	87 parts by weight

Mix Ratio (by volume):

Part A.....	100 parts by volume
Part B	100 parts by volume

HANDLING PROPERTIES (continued):

Specific Gravity:
Part A..... 1.14
Part B 0.99

Viscosity, (cps) @ 77°F (25°C) Brookfield:
Part A..... 330
Part B 1,360
Mixed..... 770

Color:
Part A..... Pale Yellow
Part B Pale Yellow

Work Time, (100-gram mass) @ 77°F (25°C) 2 minutes
Gel Time 2.25 minutes
Demold Time @ 77°F (25°C)..... 1.5 - 2 hours at 3/8" thick

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 180°F (82°C). Support of the part may be required to prevent part deformation during heat cure.

NOTE:

It is important to remix Part B thoroughly before use, making sure the material is within a temperature range of 75° - 85°F (24° - 29°C). Continue mixing until the material is uniform in appearance.

STORAGE:

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

PACKAGING:

5-Gallon Kits.....40 lbs. A, 35 lbs. B
55-Gallon Drum Kits 450 lbs. A, 392 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.

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."