



**MC-90 A/B  
MACHINE CASTABLE  
90 SHORE A POLYURETHANE ELASTOMER  
RATIO: 100/100 PBV**

**PRODUCT DESCRIPTION:**

The MC-90 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.

**PRODUCT HIGHLIGHTS:**

- 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 A ASTM D 2240-04e1 .....	90±5
Density, (g/cc) ASTM D 792-00 .....	1.11
Cubic Inches Per Pound .....	25.4
Color/Appearance.....	Pale Yellow/Transparent
Tensile Strength, (psi) ASTM D 412-98a(2002)e1 .....	2,853
Tensile Modulus, (psi) ASTM D 412-98a(2002)e1:	
100% .....	561
200% .....	752
300% .....	921
Elongation, (%) ASTM D 412-98a(2002)e1 .....	550
Tear Strength, (pli) ASTM D 624-00e1 .....	300
Shrinkage, (in/in) linear ASTM D 2566- .....	0.0065

**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 .....	95 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..... 1.12  
 Part B ..... 1.06  
 Viscosity, (cps) @ 77°F (25°C) Brookfield:  
 Part A.....2,300  
 Part B .....1,500  
 Mixed.....1,900  
 Color:  
 Part A..... Pale yellow  
 Part B ..... Amber\*  
 Work Time, (100 gram mass) @ 77°F (25°C)..... 75 seconds  
 Gel Time ..... 105 seconds  
 Demold Time @ 77°F (25°C)..... 10 minutes  
 \*Note: Part B darkens with age.

**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).

**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, 38 lbs. B  
 55 Gallon Kits ..... 400 lbs. A, 380 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 glassed 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 attentions 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."