



F-15 A/B

15 SHORE A CASTABLE 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 D-2240.....	15 ± 2
Density, (g/cc) ASTM D-792.....	1.00
Cubic Inches Per Pound.....	27.7
Color/Appearance.....	Light amber, transparent-clear
Tensile Strength, (psi) ASTM D-412.....	240
Elongation, (%) ASTM D-412.....	850
Tear Strength, (pli) ASTM D-624.....	25
Shrinkage, (in./in.) linear ASTM D-2566.....	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.....	42 parts by volume
Part B.....	100 parts by volume

Specific Gravity:

Part A.....	1.05
Part B.....	0.98

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

Part A.....	3,700
Part B.....	70
Mixed.....	275

Work Time, (100-gram mass) @ 77°F (25°C)..... 20-25 minutes

Demold Time @ 77°F (25°C)..... 2-3 hours (See NOTE)

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).

MOLD PREPARATION AND RELEASING:

When F-15 A/B is used to reproduce molds from plaster, wood or other porous substrates, we would first recommend that they be sealed. Release agents may then be applied over the sealed surface.

MIXING:

Mix thoroughly, being sure to scrape sides and corners of containers so no unmixed material remains. Vacuum degassing is important to achieving an air free product. To aid the evacuation of air, the use of a surface tension reducing agent, such as BJB's AF-4, is necessary. Refer to BJB polyurethane handling guide and data on AF-4 for additional information.

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:

Maintain at 77° ± 15°F (25° ± 10°C) and use a dry inert gas prior to sealing containers. Shelf life is 6 months from date of shipment in unopened containers.

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 and 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.