



F-85 A/B

85 SHORE A POLYURETHANE ELASTOMER

RATIO: 60/100

PRODUCT HIGHLIGHTS:

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

PRODUCT DESCRIPTION:

The F-85 A/B system is a production oriented fast gel and fast de-mold material. It features a working time which allows time to mix, vacuum de-gas, and pour air-free parts. F-85 A/B can be demolded in as little as one hour 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
- ◆ Many types of urethane parts
- ◆ Cable connector sealer

PHYSICAL PROPERTIES:

Hardness, Shore A ASTM D-2240	85 ± 2
Specific Gravity, (g/cc) cured ASTM D-792	1.08
Cubic Inches Per Pound	25.7
Color/Appearance.....	Buff Opaque
Tensile Strength, (psi) ASTM D-412	2,500
Elongation, (%) ASTM D-412	275
Tear Strength, (pli) ASTM D-624	180
Shrinkage, (in./in.) linear ASTM D-2566	0.003

HANDLING PROPERTIES:

Mix Ratio (by weight):	
Part A.....	60 parts by weight
Part B.....	100 parts by weight
Mix Ratio (by volume):	
Part A.....	57 parts by volume
Part B.....	100 parts by volume
Specific Gravity, (g/cc):	
Part A.....	1.12
Part B.....	1.06
Viscosity, (cps) @ 75°F (24°C) Brookfield:	
Part A.....	500
Part B.....	2,800
Initial Mixed.....	2,000
Work Time, 100g mass @ 77°F (25°C).....	4 minutes
Gel Time.....	5 minutes
Demold Time @ 77°F (25°C).....	1 - 2 hours
Cure Schedule.....	Full cure in 3 days or post cure at 150°F (66°C) for 4 hours.

STORAGE:

Store 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). The F-85 Part 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.

NOTE:

Prolonged direct exposure to sunlight can affect the surface of this product. Cover molds or other products when storing outdoors.

PACKAGING:

1 Gallon kits.....	4.8 lbs. A, 8 lbs. B
5 Gallon kits.....	24 lbs. A, 40 lbs. B
55 Gallon kits.....	240 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.