



F-32 A/B

32 SHORE A POLYURETHANE ELASTOMER

PRODUCT DESCRIPTION:

F-32 A/B has been designed to provide vastly improved tensile and tear strengths in comparison to the F-30 A/B system it supersedes. The F-32 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-32 A/B can be demolded in 2 - 3 hours at ambient temperature, depending on part size and configuration

PRODUCT HIGHLIGHTS:

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

PHYSICAL PROPERTIES:

Hardness, Shore A ASTM D2240	32 ± 5
Density, (g/cc) ASTM D792	1.06
Cubic Inches per Pound	27.1
Color/Appearance	Pale yellow/translucent
Tensile Strength, (psi) ASTM D412	675
Elongation, (%) ASTM D412	950
Tear Strength, (pli) ASTM D624	85
Shrinkage, (in/in) linear ASTM D2566-	0.004

Note: Reported physicals based on elevated temperature cured test specimens.

HANDLING PROPERTIES:

Mix Ratio (by weight):

Part A	100 parts by weight
Part B	94 parts by weight

Mix Ratio (by volume):

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

Specific Gravity:

Part A	1.09
Part B	1.03

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

Part A	500
Part B	1400
Initial Mixed Viscosity	1300

HANDLING PROPERTIES (continued):

Color:

Part A Pale yellow
Part B Amber
Work Time (100g mass) @ 77°F (25°C).....15 minutes
Demold Time, (mass dependant) @ 77°F (25°C) 2 - 3 hours

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). **The cure will be inhibited if cast against a tin catalyzed silicone RTV.**

NOTE:

F-32 Part A is moisture sensitive. Open containers of material should be purged with dry nitrogen or an equivalent dry air purge prior to replacing lids or caps to prevent moisture contamination. Prolonged direct exposure to sunlight can affect the surface of this product. Cover molds or other products when storing outdoors.

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:

1 Gallon kits..... 8 lbs. A, 7.5 lbs. B
5 Gallon kits..... 40 lbs. A, 37.6 lbs. B
55 Gallon kits..... 400 lbs. A, 376 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.