



F-60 A/B

60 SHORE A POLYURETHANE ELASTOMER

PRODUCT HIGHLIGHTS:

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

PRODUCT DESCRIPTION:

The F-60 A/B system is a production oriented fast gel and fast de-mold material. It features a work life which allows sufficient time to vacuum de-gas and pour air-free parts. F-60 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
- ◆ Cable connector sealer

PHYSICAL PROPERTIES:

Hardness, Shore A ASTM D-2240	60 ± 2
Specific Gravity, (g/cc) cured ASTM D-792	1.06
Cubic Inches Per Pound	26
Color/Appearance.....	Translucent Pale Yellow
Tensile Strength, (psi) ASTM D-412	685
Elongation, (%) ASTM D-412	300
Tear Strength, (pli) ASTM D-624	57
Modulus of Elasticity, (psi) ASTM D-412:	
@ 100% Strain	312
@ 200% Strain	497
@ 300% Strain	623
Shrinkage, (in./in.) linear ASTM D-2566	0.003

HANDLING PROPERTIES:

Mix Ratio (by weight):	
Part A.....	50 parts by weight
Part B.....	100 parts by weight
Mix Ratio (by volume):	
Part A.....	46 parts by volume
Part B.....	100 parts by volume
Specific Gravity, (g/cc):	
Part A.....	1.13
Part B.....	1.03
Viscosity, (cps) @ 77°F (25°C) Brookfield:	
Part A.....	550
Part B.....	800
Mixed Viscosity.....	1,050
Work Time, (100g mass) @ 77°F (25°C).....	6 - 7 minutes
Gel Time.....	8 - 9 minutes
Demold Time @ 77°F (25°C).....	1 - 2 hours
Cure Schedule.....	Full cure in 3 - 5 days or post cure at 150° F (66° C) for 4 hours

NOTE:

The F-60 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.

STORAGE:

Store containers 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).

PACKAGING:

1 Gallon kits.....	4 lbs. A, 8 lbs. B
5 Gallon kits.....	20 lbs. A, 40 lbs. B
55 Gallon kits.....	200 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.