



# F-25 A/B

## 25 SHORE A POLYURETHANE ELASTOMER

### RATIO: 60/100

#### **PRODUCT HIGHLIGHTS:**

- Short demold time permitting good mold turn over
- Ideal for intricate and flexible mold production
- Does not contain MOCA, MDA, or TDI
- Exceptionally tough and resilient
- Very easy to use

#### **PRODUCT DESCRIPTION:**

The F-25 A/B is a production oriented material system, that features a one to two hour demold time depending on part size and configuration. F-25 A/B has a 20-minute gel time, which allows ample time to mix, vacuum de-gas and pour air-free parts.

#### **TYPICAL PRODUCT USES:**

- ◆ Molds for plaster and concrete
- ◆ Potting and encapsulation
- ◆ Molds for epoxies, polyurethanes and polyesters
- ◆ Small molds
- ◆ Impact absorbing pads or linings

#### **PHYSICAL PROPERTIES:**

Hardness, Shore A ASTM D-2240.....	25
Specific Gravity, (g/cc) cured ASTM D-792 .....	1.03
Color/Appearance.....	Light Yellow
Tensile Strength, (psi) ASTM D-412.....	345
Tensile Modulus, (psi) ASTM D-412:	
Modulus @ 100% Strain.....	52
Modulus @ 200% Strain.....	93
Modulus @ 300% Strain.....	132
Elongation, (%) ASTM D-412.....	1,100
Tear Strength, (pli) ASTM D-624 .....	45
Shrinkage, (in./in.) Linear ASTM D-2566 .....	0.009
Compression Set, (%) ASTM D-395.....	36

**HANDLING PROPERTIES:**

Mix Ratio (by weight):  
 Part A ..... 60 parts by weight  
 Part B ..... 100 parts by weight

Mix Ratio (by volume):  
 Part A ..... 55 parts by volume  
 Part B ..... 100 parts by volume

Viscosity, (cps) @ 77°F (25°C) ASTM D-2393:  
 Part A ..... 5,000  
 Part B ..... 250  
 Mixed ..... 1,200

Work Time, (100-gram mass) @ 77°F (25°C) ..... 10 - 12 minutes  
 Gel Time ..... 15 - 17 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 - 6 hours

**NOTE:**

F-25 Part A is moisture sensitive. Open containers of material should be purged with dry nitrogen 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. **The cure will be inhibited if cast against a tin catalyzed silicone RTV.**

**STORAGE:**

Store at room temperature in a dry area. Unopened containers will have a shelf life of six months, from date of shipment, when properly stored under normal conditions at 75°F (24°C).

**PACKAGING:**

1 Quart kits ..... 1.2 lbs. A, 2 lbs. B  
 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.**

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."