



F-70 A/B

70 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-70 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-70 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.....	70 ± 2
Specific Gravity, (g/cc) cured ASTM D-792	1.05
Color/Appearance.....	Translucent, yellow
Tensile Strength, (psi) ASTM D-412.....	940
Elongation, (%) ATM D-412	315
Tear Strength, (pli) ASTM D-624	87
Modulus, (psi) ASTM D-412:	
@ 100% Elongation	430
@ 200% Elongation	660
@ 300% Elongation	900
Shrinkage, (in./in.) linear ASTM D-2566.....	0.002

HANDLING PROPERTIES:

Mix Ratio (by weight):	
Part A	100 parts by weight
Part B	100 parts by weight
Mix Ratio (by volume):	
Part A	100 parts by volume
Part B	100 parts by volume
Specific Gravity, (g/cc):	
Part A	1.13
Part B	1.02
Viscosity, (cps) @ 77°F (25°C) ASTM D-2393:	
Part A	550
Part B	690
Initial Mixed	620
Work Time, 100g mass @ 77°F (25°C)	3.5 – 4 minutes
Gel Time	5 - 6 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

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 75°F (24°C).

NOTE:

The F-70 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. 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.**

PACKAGING:

1 Quart kits	2 lbs. A, 2 lbs. B
1 Gallon kits.....	8 lbs. A, 8 lbs. B
5 Gallon kits.....	40 lbs. A, 40 lbs. B
55 Gallon kits.....	400 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."