



# F-80 A/B

## 80 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-80 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-80 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 .....	80 ± 5
Specific Gravity, (g/cc) cured ASTM D-792 .....	1.08
Cubic Inches Per Pound .....	25.7
Color/Appearance.....	Opaque/white
Tensile Strength, (psi) ASTM D-412 .....	1,900
Elongation, (%) ASTM D-412 .....	377
Tear Strength, (pli) ASTM D-624 .....	131
Shrinkage, (in./in.) linear ASTM D-2566 .....	0.005

### HANDLING PROPERTIES:

Mix Ratio (by weight):

Part A.....	45 parts by weight
Part B .....	100 parts by weight

Mix Ratio (by volume):

Part A.....	43 parts by volume
Part B .....	100 parts by volume

### HANDLING PROPERTIES:

Specific Gravity, (g/cc):	
Part A.....	1.13
Part B.....	1.06
Viscosity, (cps) @ 77°F (25°C) Brookfield:	
Part A.....	550
Part B.....	2,000
Mixed.....	1,800
Work Time, 100g mass @ 77°F (25°C).....	5 - 6 minutes
Gel Time.....	7 - 8 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-80 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. **The cure will be inhibited if cast against a tin catalyzed silicone RTV.**

**PACKAGING:**

1 Gallon kits.....	3.6 lbs. A, 8 lbs. B
5 Gallon kits.....	18 lbs. A, 40 lbs. B
55 Gallon kits.....	180 lbs. A, 400 lbs. B

**SAFETY PRECAUTIONS:**

Use in a well-ventilated area. Avoid contact with skin using protective gloves and protective clothing. Repeat 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.**