



F-160 REV 1 A/B

60 SHORE A POLYURETHANE ELASTOMER



BJB’s “F-1 Series”, with its 3 to 10 minutes of work time, addresses the need for faster part production. These 5 to 95 Shore A products exhibit excellent physical properties and easily process at room temperature. You’ll also find the easy mix ratio to be extremely convenient and cartridge dispense friendly. For longer work times consider our M Series (10 to 20 min) or L Series (20 min plus) of elastomers.

- RoHS/REACH Compliant
- Popular for Parts & Molds
- High Tensile & Tear Strength
- Special Effects & Props
- Over Molding
- Mercury/Phthalate Free

PHYSICAL PROPERTIES	TEST METHOD	ELEVATED TEMPERATURE CURE*
Hardness, Shore A	ASTM D2240-04e1	60 ± 5
Density (g/cc)	ASTM D792-00	1.07
Cubic Inches per Pound	N/A	26.3
Color/Appearance	Visual	Translucent Amber
Tensile Strength (psi)	ASTM D412-98a(2002)e1	1,260
Tensile Modulus (psi)	ASTM D412-98a(2002)e1	520
Elongation (%)	ASTM D412-98a(2002)e1	625
Tear Strength (pli)	ASTM D624-00e1	150
Shrinkage (in/in) linear	ASTM D2566 @ 1" depth	0.0016 [†]
Dielectric Constant, 1 MHz	ASTM D150-87	5.376
Dissipation Factor, 1 MHz	ASTM D150-87	0.064

*Note: Reported physical properties are based on test specimens cured 1-3 hours at room temperature then 16 hours at 160°F (71°C).

[†]Shrink test specimens are cured for 24 hours at room temperature and then 16 hours at 160°F (71°C).

HANDLING PROPERTIES	Part A	Part B
Mix Ratio by weight	50	100
Mix Ratio by volume (cartridge dispense friendly)	47	100
Specific Gravity @ 77°F (25°C)	1.10	1.03
Color	Pale Yellow	Amber
Viscosity (cps) @ 77°F (25°C) Brookfield	1,140	1,090
Mixed Viscosity (cps) @ 77°F (25°C) Brookfield	1,310	
Work Time, 100g mass @ 77°F (25°C)	5 – 6 minutes	
Gel Time	7 – 8 minutes	
Demold Time @ 77°F (25°C)	2 – 3 hours	

Properties above are typical and not for specifications.

CURE SCHEDULE/HEAT CURING:

Most of the physical properties can be achieved in 5-7 days at 77°F (25°C). You may use your own post-cure schedule but the physical properties may vary from BJB’s cure schedule of 1-3 hours at 77°F (25°C) followed by 16 hours at 160°F (71°C). Do not exceed curing temperature of 200°F (93°C). **The cure may be inhibited if cast against a Tin Catalyzed Silicone RTV.**

ACCESSORIES:

BJB offers silicone RTV mold making materials along with a wide range of accessory items. These include de-airing agents, pigments, mold releases, and Jiffy® Mixers. Visit BJB’s website at www.bjbenterprises.com or consult a BJB representative for more information.

COLOR VARIATIONS:

The color of the base material may vary slightly from batch to batch due to raw ingredients. Color variations will not affect the cured physical properties. Exposing the material to various conditions such as heat and UV light will alter the color of the cured system. Color stability is not guaranteed. This product can be pigmented, but you may see more color shift when using lighter pigments.

UV RESISTANCE:

This product is not classified as UV resistant. BJB offers an additive called UV-100, a UV inhibitor and anti-oxidant blend that will help slow down the effects of UV degradation and color change. The level of effectiveness varies from product to product.

STORAGE:

Store at ambient temperatures, 65-80°F (18-27°C). Unopened containers will have a shelf life of 6 months from date of shipment when properly stored at recommended temperatures. Purge opened containers with dry nitrogen before re-sealing.

PACKAGING	Part A	Part B	Cubic Inches per Kit
Quart Kits	1 lb.	2 lbs.	79
Gallon Kits	4 lbs.	8 lbs.	316
5-Gallon Kits	20 lbs.	40 lbs.	1,578
55-Gallon Drum Kits	220 lbs.	440 lbs.	17,358

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.

⚠WARNING: This product can expose you to chemicals including Methyloxirane, which is known to the State of California to cause cancer. For more information, go to www.P65Warnings.ca.gov.

NOTE:

Refer to the Safety Data Sheet before using this product. For processing tips and guides, please visit: learn.bjbmaterials.com to discover additional information.

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."