



7400 Series Translucent Dyes

The 7400 Series liquid dyes are designed to be compatible with all BJB cast urethane systems. The following colors are currently available:

- 7401 - White
- 7402 - Red
- 7403 - Yellow
- 7404 - Orange
- 7405 - Blue
- 7406 - Green
- 7407 - Ruby Red
- 7408 - Black

APPLICATION

BJB translucent dyes are recommended when color is needed in a clear system without impacting the clarity of part. Some applications include taillight lenses, tinted glass replication and gem replicas. In some cases, adding too much pigment may cause the material to become opaque, especially with darker colors. We recommend testing a 100gr mass with loading of 0.5 - 1% of total weight of A and B to start and adjust as needed. This will be a good representation of the color tone and transparency that the resin will have before working on a larger scale.

BJB does not recommend using dyes in filled or systems that cure opaque. A translucent dye is not as efficient as an opaque pigment and will require a much higher loading to reach the desired color. BJB recommends the 6800 series pigments for use in opaque systems. Regardless of the system, it is always advisable to test a small sample of material to evaluate how it responds to coloration.

Please review the notes below PRIOR to adding dye to a urethane system:

- Liquid dyes may have a negative effect on a material's physical properties if too much dye is added.
- When working from large containers (5-gallons or drums) it is advisable to only dye the amount of material to be used, especially if more than 1% is added. Stored materials may have a shelf-life reduction due to pigmentation.
- The final hardness of a system may decrease due to pigmentation; the severity depends on dye loading. In some materials, the change is permanent (5-10 points), and in others the hardness slowly increases to the expected value over time.
- Dye may be added to the "B" component of the urethane system or the final A/B mixture. Adverse reactions may occur if a dye is added to the "A" component.

STORAGE

Store ambient temperatures, 65-80°F (18-27°C). Unopened containers will have a shelf life of 12 months from date of shipment when properly stored at recommended temperatures. Purge opened containers with dry nitrogen before re-sealing.