



# CF-80AM A/B

## 80 SHORE A POLYURETHANE ELASTOMER



CF-80AM polyurethane elastomer is a 80 shore A, low odor, tough, Mercury Free system perfect for a variety of cast parts or mold making applications. Its unique ability to accept pigments ranging from light to dark colors and color stability when exposed to moderate UV light makes it a great system for prototype or production parts.

- RoHS/REACH Compliant
- Mercury Free
- Tough, Tear Resistant
- Phthalate Free
- Low Odor
- Good Rebound & Abrasion
- Good Color Stability
- Easy to Pigment

PHYSICAL PROPERTIES	TEST METHOD	ELEVATED TEMPERATURE CURE*
Hardness, Shore A	ASTM D2240-04e1	80 ± 5
Density (g/cc)	ASTM D792-00	1.117
Cubic Inches per Pound	N/A	25.5
Color/Appearance	Visual	White Cream
Tensile Strength (psi)	ASTM D412-98a(2002)e1	1,600
Tensile Modulus (psi)	ASTM D412-98a(2002)e1	1,500
Elongation (%)	ASTM D412-98a(2002)e1	210
Tear Strength (pli)	ASTM D624-00e1	150
Shrinkage (in/in) linear	ASTM D2566 @ 1" depth	0.005†
Dielectric Constant, 1 MHz	ASTM D150-87	4.668
Dissipation Factor, 1 MHz	ASTM D150-87	0.0867

\*Note: Reported physical properties are based on test specimens cured 2-3 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	45	100
Specific Gravity @ 77°F (25°C)	1.16	1.05
Color	Pale Yellow	White
Viscosity (cps) @ 77°F (25°C) Brookfield	400	900
Mixed Viscosity (cps) @ 77°F (25°C) Brookfield	650	
Work Time, 100g mass @ 77°F (25°C)	14 – 16 minutes	
Gel Time	16 – 18 minutes	
Demold Time @ 77°F (25°C)	3 – 4 hours	

Properties above are typical and not for specifications.

**IMPORTANT MIXING DIRECTION:**

It is important to remix the “A” component thoroughly prior to each use before combining with the “B” side.

**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).

**PREPARATION AND RELEASING:**

When CF-80AM A/B is used to produce molds or parts from plaster, wood or other porous substrates, we would first recommend that they be sealed. Release agents may then be applied over the sealed surface.

**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](http://www.bjbenterprises.com) or consult a BJB representative for more information.

**STORAGE:**

Store 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.	77
Gallon Kits	4 lbs.	8 lbs.	306
5-Gallon Kits	20 lbs.	40 lbs.	1,530
55-Gallon Drum Kits	225 lbs.	450 lbs.	17,213

**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. 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.

**NOTE:**

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

**⚠️WARNING:** This product can expose you to chemicals including Styrene, which is/are known to the State of California to cause cancer and birth defects or other reproductive harm. For more information, go to [www.P65Warnings.ca.gov](http://www.P65Warnings.ca.gov).