

FD-70 REV 1 A/B

70 SHORE D POLYURETHANE ELASTOMER



BJB's FD Series of semi rigid, fast reacting urethane elastomers exhibit great flexibility and excellent durability. These tough, abrasion resistant systems easily process at room temperature and range in hardness from 50 Shore D to 70 Shore D. The FD Series offers superior performance in many applications such as rollers, foundry tooling and high impact semi rigid parts. For longer work times consider BJB's MD Series of elastomers.

- RoHS/REACH compliant
- Production oriented
- Used for molds and cast parts
- High tensile and tear strength
- Exceptional abrasion resistance
- Easy processing

PHYSICAL PROPERTIES	TEST METHOD	ELEVATED TEMPERATURE CURE*
Hardness, Shore D	ASTM D2240-04e1	70 ± 5
Density (g/cc)	ASTM D792-00	1.169
Cubic Inches per Pound	N/A	24.64
Color/Appearance	Visual	Clear Amber
Tensile Strength (psi)	ASTM D412-98a(2002)e1	6,400
Tensile Modulus (psi)	ASTM D412-98a(2002)e1	90,000
Elongation (%)	ASTM D412-98a(2002)e1	350
Tear Strength (pli)	ASTM D624-00e1	695
Flexural Strength (psi)	ASTM D790-03	3,200
Flexural Modulus (psi)	ASTM D790-03	79,000
Shrinkage (in/in) linear	ASTM D2566 @ 1" depth	0.0064 [†]
Izod Impact (ft-lb/in) notched	ASTM D256-05	>16.5
Dielectric Constant, 1 MHz	ASTM D150-87	4.119
Dissipation Factor, 1 MHz	ASTM D150-87	0.036

***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	100	40
Mix Ratio by volume	100	38
Specific Gravity @ 77°F (25°C)	1.105	1.178
Color	Pale Yellow	Amber
Viscosity (cps) @ 77°F (25°C) Brookfield	3,700	415
Mixed Viscosity (cps) @ 77°F (25°C) Brookfield	2,200	
Work Time, 100g mass @ 77°F (25°C)	5 – 6 minutes	
Gel Time	7 – 8 minutes	
Demold Time @ 77°F (25°C)	60 – 90 minutes	

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).

PREPARATION AND RELEASING:

When FD-70 REV 1 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.

NOTE:

Cure times are subject to part size. Smaller parts may need additional time in the mold or add mild heat (100-120°F) to decrease demold time. **Heat will also increase toughness of parts upon demold.**

Prolonged direct exposure to sunlight can affect the surface of this product. Cover molds or other products when storing outdoors.

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.

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	2 lbs.	0.8 lbs.	69
Gallon Kits	8 lbs.	3.2 lbs.	276
5-Gallon Kits	40 lbs.	16 lbs.	1,380

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.

Refer to the Material Safety Data Sheet before using this product.

⚠WARNING: This product can expose you to chemicals including Toluene diisocyanate, which 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.



Handling Guide