



**F-25 A/B**  
**25 SHORE A POLYURETHANE ELASTOMER**  
**RATIO: 60/100**

**PRODUCT HIGHLIGHTS:**

- Short demold time permitting good mold turn over
- Ideal for intricate and flexible mold production
- Exceptionally tough and resilient
- Very easy to use

**PRODUCT DESCRIPTION:**

The F-25 A/B is a production oriented material system, that features a one to two hour demold time depending on part size and configuration. F-25 A/B has a 10-minute work time, which allows ample time to mix, vacuum de-gas and pour air-free parts.

**PHYSICAL PROPERTIES:**

Hardness, Shore A ASTM D-2240.....	25
Density, (g/cc) ASTM D-792.....	1.03
Color/Appearance.....	Light Yellow
Tensile Strength, (psi) ASTM D-412.....	345
Tensile Modulus, (psi) ASTM D-412:	
Modulus @ 100% Strain.....	52
Modulus @ 200% Strain.....	93
Modulus @ 300% Strain.....	132
Elongation, (%) ASTM D-412.....	1,100
Tear Strength, (pli) ASTM D-624.....	45
Shrinkage, (in./in.) linear ASTM D-2566.....	0.009
Compression Set, (%) ASTM D-395.....	36

**HANDLING PROPERTIES:**

Mix Ratio (by weight):	
Part A.....	60 parts by weight
Part B.....	100 parts by weight
Mix Ratio (by volume):	
Part A.....	55 parts by volume
Part B.....	100 parts by volume

**HANDLING PROPERTIES (Cont'd):**

Viscosity, (cps) @ 77°F (25°C) Brookfield:	
Part A .....	5,000
Part B .....	250
Mixed .....	1,200
Work Time, (100-gram mass) @ 77°F (25°C) .....	10 - 12 minutes
Gel Time .....	15 - 17 minutes
Demold Time @ 77°F (25°C) .....	1 - 2 hours

**CURE SCHEDULE/HEAT CURING:**

Most of the physical properties can be achieved in 5-7 days at ambient temperature, 77°F (25°C). In order to achieve maximum physical properties, a post cure with heat is required. BJB recommends 24 hours at ambient temperature, 77°F (25°C), followed by 16 hours at 160°F (71°C).

**NOTE:**

F-25 Part A is moisture sensitive. Open containers of material should be purged with dry nitrogen prior to replacing lids or caps to prevent moisture contamination. 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.**

**STORAGE:**

Store at room temperature in a dry area. Unopened containers will have a shelf life of six months from date of shipment when properly stored under normal conditions at 75°F (24°C).

**PACKAGING:**

Gallon kits .....	4.8 lbs. A, 8 lbs. B
5 Gallon kits .....	24 lbs. A, 40 lbs. B
55 Gallon kits .....	240 lbs. A, 400 lbs. B

**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.**

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."