

L-3540 REV 1 A/B

40 SHORE A POLYURETHANE ELASTOMER



BJB's "L Series", with its 20 to 35 minute work time, is perfect for manufacturing larger or more complex parts and molds. The L-3540 is a 40 Shore A material offering exceptional physical properties. You'll find the 1:1 ratio to be extremely convenient whether you're hand mixing or cartridge-dispensing with our CPE handheld dispense equipment. For faster work times consider BJB's F-1 or M Series of urethane elastomers.

- RoHS/REACH compliant
- Vibration Dampening
- Industrial Rollers
- Plaster and Concrete Molds
- Over Molding
- Strain Reliefs

PHYSICAL PROPERTIES	TEST METHOD	7 DAY AMBIENT CURE	ELEVATED TEMPERATURE CURE*
Hardness, Shore A	ASTM D2240-04e1	40 ± 5	40 ± 5
Density (g/cc)	ASTM D792-00	1.035	1.035
Cubic Inches per Pound	N/A	26.92	26.92
Color/Appearance	Visual	Clear Amber	Clear Amber
Tensile Strength (psi)	ASTM D412-98a(2002)e1	TBD	960
Tensile Modulus (psi)	ASTM D412-98a(2002)e1	TBD	175
Elongation (%)	ASTM D412-98a(2002)e1	TBD	1,100
Tear Strength (pli)	ASTM D624-00e1	TBD	120
Shrinkage (in/in) linear	ASTM D2566 @ 1" depth	0.0010 [†]	TBD
Dielectric Constant, 1 MHz	ASTM D150-87	5.198	5.198
Dissipation Factor, 1 MHz	ASTM D150-87	0.0512	0.0512

***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	100
Mix Ratio by volume	100	100
Specific Gravity @ 77°F (25°C)	1.028	1.032
Color	Pale Yellow	Amber
Viscosity (cps) @ 77°F (25°C) Brookfield	1,475	1,350
Mixed Viscosity (cps) @ 77°F (25°C) Brookfield	1,600	
Work Time, 100g mass @ 77°F (25°C)	25 – 30 minutes	
Gel Time	45 – 50 minutes	
Demold Time @ 77°F (25°C)	8 – 14 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).

PREPARATION AND RELEASING:

When L-3540 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:

Prolonged direct exposure to sunlight can affect the surface of this product. Cover molds or other products when storing outdoors. **The cure may be inhibited if cast against a relatively new tin catalyzed (condensation cure) 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.

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.	2 lbs.	108
Gallon Kits	8 lbs.	8 lbs.	431
5-Gallon Kits	40 lbs.	40 lbs.	2,154
55-Gallon Drum Kits	440 lbs.	440 lbs.	23,690

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 is known to the State of California to cause cancer. For more information, go to www.P65Warnings.ca.gov.



Handling Guide



L-3540 REV 1 Part A SDS



L-3540 REV 1 Part B SDS