

DATA - SHEET 1025

No. 1025

Page. 1 of 4

Date. 01 / 08 / 2005

METROLOGY CASTING MATERIALS

Reprorubber Putty

This product produces a mix of putty consistency and is suitable for moulding onto either internal or external component features where liquid mixes would be difficult to apply.

When set, Reprorubber Putty provides an exact replica of the form and size of the original component.

The final set condition is similar to hard rubber and is suitable for measurement by projection.

Samples can be easily removed from the master component and sectioned with a sharp knife required.

* Mix time	0.5 to 1 Min
* Working time	2 Minutes
* Cure Strength	6 Minutes
* Strength	105 lbs/sq.in
* Hardness	Shore 50 in 7 Minutes
* Molten Metal	600 degree. F
* Colour	Blue

Order Code	Description/ Size
52-016-129	Trial Size 220ml
52-016-130	Reprorubber Putty 1.75lb./520ml
52-016-131	Reprorubber Putty 7lbs./2150ml

QUICK SETTING PUTTY

INSTRUCTIONS: (Blue Final Clour)

Take equal quantities of blue putty (base) and gray putty (catalyst), and roll each into a ball. Put the two balls together and start kneading them together until there is no gray showing. This should take about 45 seconds. You will then have about 2 minutes work time to apply the putty to your workpiece. Cure time is about 6 to 7 minutes there after.

APPLYING:

After mixture is complete, simply push the putty into or onto the cavity or specimen and wait for it to cure; then remove.

When taking large impressions, especially in deep cavities, you could cover the open area with a piece of plastic and put a weight on it while curing. This will eliminate voids in the surface of the final casting.

DATA - SHEET 1025

No. 1025

Page. 2 of 4

Date. 01 / 08 / 2005

IMPORTANT:

- * Never store impression material above 80°F (27°).
- * Only mix base and catalyst in 1 to 1 ratio. Knead until color is uniform (light blue).
- * Work with material only at room temperature 70°-75°F (21°-24°C).
- * Wearing gloves while kneading putty:
 1. Polyethylene gloves are perfect.
 2. Latex gloves (mostly o.k.)
 3. Do not use polysulfide gloves. It prevents cure of material.
 4. First try your "in house gloves" with a small mix of putty and see if it sets firm. If so, you may use such gloves.

WARNING:

NEVER PUT BLUE PUTTY INTO GRAY PUTTY JAR!

NEVER PUT GREY PUTTY INTO BLUE PUTTY JAR!

ACCIDENTAL MIXING OF BASE AND CATALYST WILL INACTIVATE THE CATALYST AND VOID OUT WARRANTY.

DO NOT INTERCHANGE LIDS AND JARS.

MATERIAL SAFETY DATA SHEET

1.1 Product Trade Name: FLEXBAR REPRORUBBER® THIN POUR MATERIAL CATALYST PASTE

1.2 Part (Item) Number: 16135, 16137

SECTION I

1.3 Division Name: Flexbar Machine Corporation

1.4 Address: 250 Gibbs Road
Islandia N.Y. 11722-2697

1.5 Emergency phone number: (800) 879-7575

1.6 Phone number for information: (516) 582-8440

1.7 Date prepared: June 1, 1997

SECTION II - Hazardous Ingredients/Identity Information

<u>Hazardous Components</u>	<u>OSHA PEL</u>	<u>ACGIH TLV</u>	<u>Other limits</u>
Vinyl dimethyl terminated polydimethylsiloxane	N.E.	N.E.	
Silica (Amorphous)		10 mg/m ³	
Silica (Crystalline)		0.05mg/m ³	
Organo platinum complex	N.E.	N.E.	

SECTION III - Physical/Chemical Characteristics

3.1 Boiling point:	>200°C
3.2 Vapour pressure:	N.E.
3.3 Vapour density:	N.A.
3.4 Solubility in water:	Not Soluble
3.5 Appearance and odor:	Colored paste with faint sweet odor
3.6 Specific Gravity:	1.1 g/cm ³
3.7 Melting Point:	N.A.
3.8 Evaporation rate:	>1

SECTION IV - Fire and Explosion Hazard Data

4.1 Flash Point (method used):	>415°F (Pensky Martin CC ASTM 093)
4.2 Flammability (explosive limits):	LEL: N.E. UEL: N.E
4.3 Extinguishing media:	Sand, foam, carbon dioxide, dry chemical
4.4 Special fire fighting procedure:	Fire fighter should wear full protective clothing including a self contained breathing apparatus. Cool containers exposed to flame with water.
4.5 Unusual fire and explosion hazards:	During a fire, irritating and/or toxic gases and aerosols may be present from the decomposition/combustion byproducts.

SECTION V - Reactivity Data

5.1 Stability:	Unstable:	Stable: X
5.2 Conditions to avoid (stability):	Heat greater than 60°C (140°F)	
5.3 Incompatibility (material to avoid):	Condensation silicones, tin and sulfur compounds, amines and peroxides	
5.4 Hazardous decomposition or byproducts:	N.E.	
5.5 Hazardous polymerization:	May occur:	Will not occur: X
5.6 Conditions to avoid (polymerization):	Extreme heat	

SECTION VI - Health Hazard Data

6.1 Route(s) of entry:	Inhalation?: No Skin?: Yes Ingestion?: Possible
6.2 Health Hazards (accute and chronic):	In susceptible persons, skin reactions may occur. This is short term and should go away after washing with soap and water.
6.3 Carinogenicity:	NTP?: Not listed IARC monographs: Not listed OSHA regulated?: No All components of this product are in compliance with the inventory listing requirements of the U.S. Toxic Substances Control Act (TSCA) Chemical Substance Inventory.

No. 1025

Page. 4 of 4

Date. 01 / 08 / 2005

- 6.4 Signs and symptoms of exposure:** Product may irritate the eyes and skin.
Reddish rashes may be seen on the skin.
- 6.5 Medical Condition generally aggravated by exposure:** Possible skin rashes.
- 6.6 Emergency first aid procedures:** EYE CONTACT: flush with copious amounts of water for at least 15 minutes. Consult with an physician. SKIN CONTACT: Wash thoroughly with soap and water. INGESTION: Consult a physician immediately.

SECTION VII - Precautions for sale Handling and Use:

- 7.1 Steps to be taken in case material is released or spilled:** Cover with sand or sawdust or other adsorbent material: scoop up and place in a appropriately marked container.
- 7.2 Waste disposal methods:** Dispose of in accordance with Federal, State and Local regulations.
- 7.3 Precautions to be taken in handling and storage:** Store away from food and beverages.
- 7.4 Other precautions:** Store away from extreme heat.

SECTION VIII - Control Measures

- 8.1 Respiratory protection:** None required during normal use of this product.
- 8.2 Ventilation:** Local exhaust.
- 8.3 Protective gloves:** Vinyl gloves. Latex or rubber gloves may inhibit setting of this product.
- 8.4 Eye protection:** Protective goggles.
- 8.5 Other protective clothing or equipment:** Apron.
- 8.6 Work/Hygenic practices:** Observe normal care when working with chemicals.