



VFI®-1678 80 D Injectible Plastic

VFI®-1678 80 D Injectible Plastic is a fast setting, 80 D hardness, high strength plastic with a quick demold time to increase part production. A high amine content gives good temperature stability and chemical resistance to be used in a variety of applications. VFI-1678 is fully paintable when primed or sanded before paint application. A low mixed viscosity between two similar viscosity parts allows this product to be injected into a mold with little air entrapment or waste. VFI-1678 Injectible Plastic can produce a smooth glossy finish or matte finish depending upon the need.

→ Technical Usage

VFI®-1678 80 D Injectible Plastic has been used in the following applications and may be used in many more applications. Contact Volatile Free, Inc. for more information on any specific applications.

- Industrial Part Making
- Molding and Casting

→ Color

Standard colors available are neutral and black. For additional premium colors or color matching services contact Volatile Free, Inc.

→ UV Stability

This product is **NOT** UV color stable and has no long-term UV testing. For additional information contact Volatile Free, Inc.

→ Coverage/Thickness Requirement

Contact Volatile Free, Inc. for thickness requirements and specifications.

→ Storage Stability/Shelf Life

12 month shelf life from date of manufacture when stored and sealed in unopened containers between 40°F - 75°F. Opened containers may be resealed with a nitrogen purge, but shelf life will be significantly shortened. Material should be brought to a minimum temperature of 65°F before use.

→ Equipment

For specific instructions and equipment requirements, contact Volatile Free, Inc.

→ Surface Preparation

All surfaces should be cleaned, prepped and free of any oils, dirt or debris. To demold, material must be non-porous or sealed with a chemical sealant. A release agent should be used on all products intended to be demolded. Contact Volatile Free, Inc. with any additional questions.

→ Mixing

Pre-mixing Poly (B) components until uniform is required before combining Poly (B) and Iso (A). It is recommended the material be injected as the primary application method. If pouring material by hand pre-weighed Poly (B) must be poured into pre-weighed Iso (A) and then mixed until uniform and transferred to a new container to mix until uniform again before use. Product must be fully mixed and used before the duration of the pot life. Mix times may vary depending on volume and mixing method. Please contact Volatile Free, Inc. for more information on any specific mixing questions and requirements.

→ Material Application

Temperature should be between 50°F - 100°F when the product is being used. The pot life will shorten with any increases in temperature beyond 72°F. Ensure surfaces in contact with the material are properly sealed and released before mixing to prevent any unwanted adhesion. Contact Volatile Free, Inc. for more information on recommended release agents or sealants.

→ Primers

Contact Volatile Free, Inc. with any primer questions.

→ Cleanup Solvent

Preferred cleanup solvent is xylene or MEK. Please contact Volatile Free, Inc. for more information on cleanup of equipment and tools.

→ Thinning

Do not thin prior to application.

→ Precautions

Contains isocyanate that may be irritating to the skin and is toxic if inhaled as particulate matter. See Safety Data Sheet for complete safety data. Do not add any foreign material to this product. Avoid prolonged breathing of vapors and prolonged or repeated skin contact. Use only with adequate ventilation.

VFI®-1678 80 D INJECTABLE PLASTIC

Application Method

SPRAY	QWIK SPRAY	BRUSH	TROWEL	ROLLER	INJECTABLE	POUR
-	-	-	-	-	X	-

Physical Properties

Hardness Shore D	81
Tensile Strength	5,800 psi
Flexural Strength	4,700 psi
Notched Izod	17.7 ft. lb/in

Liquid Properties

Solids by Weight	100%
Solids by Volume	100%
Mixed Liquid Density	9.58 lbs/gal
Specific Gravity A Side	1.21 g/mL
Specific Gravity B Side	1.09 g/mL
Specific Gravity Mixed	1.15 g/mL
Ratio by Volume (A:B)	1A:1B
Ratio by Weight (A:B)	100A:88.49B
Viscosity A Side	550 cps
Viscosity B Side	750 cps
Gel Time	1 minute
Tack Free	4 minutes
De-mold Time	5 minutes
Full Cure	7 days
Flash Point	A=370° F/ B=240° F
Boiling Point (A/B)	A=400° F/B=530° F
VOC	0

Packaging



TOTE

DRUM

5 GALLON

1 GALLON

VOLATILE FREE, INC.

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