

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 feature  
 The final set condition is similar to hard rubber and is suitable for measurement by projection  
 Samples can be easily removed from the component area and if required sectioned with a sharp knife

Packed Weight and Dimensions

Code	Description	Weight g	W mm	H mm	L mm
52-016-129	Reprorubber Putty: 220ml (trial size)	320	63	95	125
52-016-130	Reprorubber Putty: 1.75lb./520ml	825	100	145	100
52-016-131	Reprorubber Putty: 7lb./2150ml	3045	145	125	280



Mix time	0.5 – 1 minute
Working time	2 minutes
Cure strength	6 minutes
Strength	105 lbs/sq. in
Hardness	Shore 50 in 7 minutes
Molten metal	600 degrees F
Colour	Blue

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Instructions:

Take equal quantities of the Blue Putty (base) and the Grey Putty (catalyst) and roll each into a ball.  
 Put the 2 balls together and knead them together until there is no grey showing.  
 This should take about 45 seconds.  
 You will then have approximately 2 minutes of work time to apply the putty to the workpiece  
 After the mixture is complete, simply push the Putty into the cavity or onto the component and wait for it to cure.  
 Cure time takes approximately 6 to 7 minutes  
 Ensure that the cast has completely cured before removing from the component.  
 When taking large impressions, especially in deep cavities.  
 Cover the open area with a piece of plastic and put a weight on it whilst curing.  
 This will eliminate voids in the surface of the final casting

Never store impression material above 80 deg.F (27 Celcius)  
 Only mix base and catalyst in 1 to 1 ratio. Knead until colour is uniform (light blue)  
 Work with material only at room temperature 70 – 75 deg.F (21 24 deg. C)  
 Wear protective gloves when kneading the putty:

- 1 Polyethylene gloves are best
- 2 Latex gloves (mostly OK)
- 3 Do not use polysulphide gloves, as the prevent curing of the material
- 4 First try your “in house gloves” with a sample mix to test if the putty cures correctly, if so they can be used
- 5 **Never put grey putty into blue putty jar**
- 6 **Never put blue putty into grey putty jar**
- 7 **Accidental mixing of base and catalyst will inactivate the catalyst and void the warranty**
- 8 **Do not interchange lids and jars**

## Reprorubber Putty

## Material Safety Data:

## SECTION 1

- 1.1 Product Trade Name: FLEXBAR REPRORUBBER® THIN POUR MATERIAL CATALYST PASTE  
 1.2 Part (item) Number: 16135, 16137  
 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

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

## SECTION III – Physical/Chemical Characteristics

- 3.1 Boiling Point:  $\geq 200^{\circ}\text{C}$   
 3.2 Vapour Pressure: N.E.  
 3.3 Vapour Density: N.A.  
 3.4 Solubility in Water: Not soluble  
 3.5 Appearance and odour: Coloured paste with faint sweet odour  
 3.6 Specific Gravity: 1.1 g/cm<sup>3</sup>  
 3.7 Melting Point: N.A.  
 3.9 Evaporation Rate:  $\geq 1$

## SECTION IV – Fire and Explosion Hazard

- 4.1 Flash Point (method used):  $\geq 415^{\circ}\text{F}$  (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 gasses and aerosols  
 May be present from the decomposition/combustion by-products

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## SECTION V – Reactivity Data

5.1	Stability:	Unstable:	Stable: X
5.2	Conditions to Avoid (stability):	Heat greater than 60°C	
5.3	Incompatibility (materials to avoid):	Condensation silicones, tin and sulphur compounds, amines and peroxides	
5.4	Hazardous decomposition of by-products:	N.E.	
5.5	Hazardous polymerisation:	May occur:	Will not occur: X
5.6	Conditions to avoid (polymerisation)	Extreme heat	

## SECTION VI – Health Hazard Data

6.1	Route(s) of entry:	Inhalation: No	Skin: Yes	Ingestion: Possible
6.2	Health hazards (acute 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	Carcinogenicity:	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 Substances Inventory		
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 a Doctor Skin Contact: Wash thoroughly with soap and water. Ingestion: Consult a Doctor immediately		

SECTION VII – Precautions for safe  
Handling and Use

7.1	Steps to be taken in case material is Released or Spilled:	Cover with sand or sawdust or other absorbent material Scoop up and put into a suitably marked container
7.2	Waste Disposal Methods:	Dispose of in accordance with National 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:	Non required during normal use of this product
8.2	Ventilation:	Local exhaust
8.3	Protective Gloves	Vinyl, Latex, and 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/Hygienic Practices:	Observe normal care when working with chemicals