



Product Datasheet BX-Amber Series General Molding & Casting Systems

Physical Properties of series with BX-Amber Iso

Property	XP2017-019	XP2017-020	XP2017-021	XP2017-022	XP2017-023	XP2017-024	XP2017-025
Shore A Hardness,	36 to 40	43 to 47	51 to 55	58 to 62	63 to 67	69 to 73	74 to 78
Ultimate Tensile, PSI	620*	454*	920	960	880	1240	1300
Elongation, %	>1100	>1100	1000	950	700	700	500
Tear, Die C, PLI	110	158	183	204	220	243	260
Split Tear PLI	27	39	45	54	54	58	59
Gel Time, Minutes	15 to 20						
Mix Ratio by Weight (Polyol:Prepolymer)	100:100	100:150	100:200	100:250	100:300	100 to 400	100 to 500
Color	Amber						

*At 1100 modulus

Preparation of Materials for Use

Prepare Master and Mold Housing

First, clean and dry your master thoroughly. If the master has a porous surface (clay, concrete, plaster, etc.) or is made of sulfur-based clay, you must seal it. You can use polyurethane varnish, polyurethane sealant, or paste wax to seal your master. Next, anchor your master and seal the base so that BX-Amber does not leak under your master. A hot glue gun works to anchor and seal the base at the same time. Also, you should seal all of your mold housing connections with sulfur-free clay or hot glue. Then, apply an appropriate release agent to the master and interior of the mold housing. A silicone-based release is recommended, but always test before use. Apply release agent sparingly, while coating all surfaces of the master. Too much release agent may cover the details of the master or pool in low spots. You should allow the release agent to dry thoroughly before pouring your mold.



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Measure Iso Side A and Curative Side B

Make sure that Iso and Curative are at room temperature before mixing them. Please note that in cold weather it may take up to 24 hours for the Iso and Curative to reach room temperature. Using two clean, dry, plastic containers, measure correct amount of the Iso Side A and Curative Side B.

Mix Iso and Curative

After you prepare the master and mold housing and measure the Iso and Curative, you are ready to pour the Iso and Curative into another clean, dry, plastic mixing container. Scrape the Iso and Curative containers to move all of the material into the mixing container. Combine the two ingredients for several minutes until no color striations are visible. Be sure to scrape the sides and bottom of the mixing container while mixing the two ingredients. You must mix the Iso and Curative completely so that BX-Amber will cure correctly. If air bubbles form during mixing, you should vacuum degas the mixture for 2 to 3 minutes to remove them.

Pour Mold

To ensure that no air bubbles form over the details of your master, you can brush a thin base coat onto the master and then pour the rest of the mixed BX-Amber. The best way to pour a mold is to tilt your mold slightly and pour into one spot at the corner of the mold, allowing the material to cover your master slowly like the flow of lava. When you have finished pouring the mold, you may lightly spray release agent on the top of BX-Amber to break any air bubbles that have risen to the surface.

Demold and Cure Mold

Once you have poured your mold, allow the mold to cure 16 hours before demolding. To prolong the life of the mold, allow it to cure for 3–5 days before use.

Storage and Handling

Keep the BX-Amber Side A and Side B containers tightly closed when not in use and store at temperatures between 70–80° F (21–26° C). Do not expose the Iso or Curative to moisture! If moisture contaminates BX-Amber components, it will not cure properly. If these storage requirements are met, BX-Amber carries a shelf life warranty of six months in original unopened containers.



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Be sure to read the *Material Safety Data Sheets* that come with BX-Amber.

When working with this material please observe the following safety precautions.

- Wear safety glasses, chemical-resistant rubber or plastic gloves and an apron.
- Avoid contact with skin.
- In the case of skin contact, wipe affected area with isopropyl alcohol, followed by thorough washing with soap and water.
- In the case of eye contact, flush eyes with water for 15 minutes and consult a physician.
- If swallowed, drink one to two glasses of water and seek medical attention immediately.



Authorized Distributor

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BX-Amber Product Datasheet

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