Technical
Datasheet

PU 20 Casting Foam /Comp. A+B

Basis	**Casting foam**
Resin	**PU 20 Casting Foam Comp. A**
Hardener	**PU 20 Casting Foam Comp. B**
Colour	beige

Applications

- Styling models
- Laminate molds
- Base constructions
- Negatives

Properties

- density 200 g/l
- good milling properties
- very good surface structure
- easy to machine
- very good flowability
- good heat resistance

Processing data

Product		**Mixture PU 20 Casting Foam /Comp. A+B**	**Resin PU 20 Casting Foam Comp. A**	**Hardener PU 20 Casting Foam Comp. B**
Colour		beige	beige	brown transparent
Mixing ratio	**p. b. w.**		**100**	**80**
Viscosity at 25°C	mPas	-	3100 ± 300	50 ± 5
Density at 20°C	g / cm^3	ca. 1,20	1,34 ± 0,2	1,06 ± 0,2

Physical data

Properties	**Inspect. requirem.**	**Unit**	**Value**
Density cured	-	g / cm^3	0,20 ± 0,02
Compressive strength	EN ISO 604	MPa	2,4 ± 0,1
Heat resistance (HDT)	DIN EN ISO 75 B	°C	52 ± 1
Shore hardness	DIN ISO 7619-1	Shore D	18 - 22
Shore hardness	DIN ISO 7619-1	Shore A	70 - 75
coefficient of thermal expansion	internal test / Dilatometer	$10^{-6}K^{-1}$	77

Sales units (packages)

Units	Comp. A	PU 20 Casting Foam Comp. A	5,000 kg; 15,000 kg
	Comp. B	PU 20 Casting Foam Comp. B	4,000; 12,000 kg

Processing instructions

For optimum mould release we recommend our release agent T1-1, which can easily be applied with brush or be sprayed.

Apply the release agent 2 – 3 times and evaporate for about 20 min. after each application.

Before processing stir up comp. A carefully. Stirred-in air improves the foaming result.

The system can be casted manually or mechanically.

In case of manual casting mix the components carefully for about 30 – 45 secs. with a star-shaped mixing rod.

Foaming for all thicknesses up to 300 mm possible. In order to get a dense surface we recommend to paint the mould with a brush in advance.

Inition time (expansion): about 60 - 90 sec.
Upflow time incl. follow-up pressure (expansion): about 5 – 6 min.

Example for calculation of mixture quantity:

Volume of part: 3 ltrs.
Density of expanding foam: 0,2 kg/l

3 ltrs. x 0,2 kg/ltr. = 0,6 kg mixture quantity

Please add about 10% - 20% additional material for losses in mixing and casting.

In General

This product is a polyurethane system.

If required special formulations for density between 0,1 g/cm³ and 0,5 g/cm³ possible.

Storing

Storage at room temperature 18-25 °C.

Opened containers should be closed immediately after use and should
be used up as soon as possible.

Shelf life is indicated on the labels.

Safety measure

Please follow the precaution isntructions of the Government Safety Organisation of the chemical industry when working with this material. Please follow safety advices !

Waste Disposal

According to arrangement with local authorities cured material can be disposed as domestic or commercial waste.
Non-cured products are waste which is subject to inspection and has to be disposed accordingly.
In case of further questions please do not hesitate to contact our Department for Product Safety.