



PRODUCT DATA SHEET

UrePac® Flex 22 390

Product Description

UrePac® Flex 22 390 is a two component semi-rigid integral skin foam based on polyether polyol and MDI isocyanate. The system has been developed to produce a resilient foam with an elastomeric skin for products such as automotive bump stops. The foam is 100% water blown with zero GWP and ODP properties.

UrePac Flex ES618-0611 (Polyol) Specification:

210kg per 205lt Open top drum.

Specific Gravity (22°C):	1.04 +- 0.02 g/ml
Viscosity (Brookfield) (22°C):	800 +- 100 m.Pas
Appearance:	Black liquid

UrePac 2104 (Isocyanate) Specification:

240kg per 205lt Closed top drum.

Specific Gravity (22°C):	1.21 +- 0.02 g/ml
Viscosity (Brookfield) (22°C):	150 +- 20 m.Pas
Appearance:	Clear Amber liquid

Processing Conditions:

Temperature

The temperature of both components should be heated in the day tanks to at least 25-30°C to ensure that a sufficient mix and reaction speed is obtained. The optimal temperature of the moulds should be between 55-65°C to achieve optimal skin definition and repeatable results of the finished product.

Application

The mould should be clean, dry and free from oil and grease to prevent skin imperfections or foam collapse. It is recommended that regular calibration shots are conducted to ensure that the correct mix ratio is being achieved. An in mould paint is recommended for external applications exposed to UV radiation.

Cured Foam Properties

Mix Ratio	100 Polyol (Part A): 63 Isocyanate (Part B) (w/w)
Cream Time (22°C):	22+-3 seconds
String time (22°C):	33+-3 seconds
Rise time (22°C):	43+-5 seconds
Free Rise Density (22°C):	390+-20 Kg/m ³

Obtained from Laboratory cup test

Moulded Core Density:	450 +-20 Kg/m ³
Tensile Strength:	350+-10 N/cm ²
Elongation:	100+-10 %
Tear Strength:	150 N/cm
Skin Hardness:	85+-5'A

Storage and Handling

Component A	should be stored under dry conditions out of direct sunlight between 18 and 25°C.
Component B	should be stored separately from <i>Component A</i> , but under the same conditions.

Both products will have a minimum shelf life of six months when stored under these conditions.

It is recommended that **Component A** be mixed prior to use.

If **Component A** is held in storage tanks, the contents must be mixed at least once per day.

Please refer to the Material Safety Data Sheet (MSDS) for further advice on the safe handling of these products.

Transport Classification

Component A:	None
Component B:	None