PRODUCT DATA SHEET

Urepac™ Rigid 90 105

Product Description

Urepac™ Rigid 90 105 is a two component, polyurethane rigid foam based on polyether polyol and MDI isocyanate. The system has been developed with excellent structural and fast reaction properties for use in machine moulding of structural components.

Part A (Polyol) Specification:

210kg per 205lt Open top drum.

Specific Gravity (22°C):	1.05 +- 0.02 g/ml
Viscosity (Brookfield) (22°C):	750 +- 100 m.Pas
Appearance:	Clear pale amber liquid

Part B (Isocyanate) Specification:

250kg per 205lt Closed top drum.

Specific Gravity (22°C):	1.23 +- 0.02 g/ml
Viscosity (Brookfield) (22°C):	210 +- 70 m.Pas
Appearance:	Clear Brown liquid

Processing Conditions:

Temperature

The temperature of both components should be heated in the day tanks to at least 25°C to ensure that a sufficient mix and reaction is obtained. The optimal temperature of the mould boxes should be between 35-45°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. For high pressure units a minimum pressure of 1500psi is required to get sufficient mixing of the components. The entire pour should be completed before the foam begins to rise to achieve the best foam structure.

Cured Foam Properties

Mix Ratio	**100 Polyol (Part A): 110 Isocyanate (Part B) (w/w)**
Cream Time (22°C):	90+-5 seconds
String time (22°C):	450+-20 seconds
Rise time (22°C):	720+-20 seconds
Free Rise Density (22°C):	105+- Kg/m^3

Obtained from Laboratory cup test

Core Density:	100+-5 Kg/m^3
Closed Cell Content:	90-95%
K Value:	0.0280 W/mK
Compressive Strength:	900+-50 kPa

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 *Component A*, 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