

FORSCH POLYMER CORP.

TECHNICAL DATA BULLETIN

HIGH DENSITY RIGID POLYURETHANE MOLDING SYSTEMS

DESCRIPTION

Forsch's Ridged Foam molding systems have been specifically designed for reproduction of decorative as well as structural parts in densities from 3 to 18 pcf. These systems are based on polymeric isocyanates and are characterized by their excellent flow characteristics and relative insensitivity to high humidity conditions, and they contain no CFC's.

TYPICAL HANDLING CHARACTERISTICS:

	<u>3#</u>	<u>6#</u>	<u>8#</u>	<u>10#</u>	<u>12#</u>	<u>16#</u>	<u>18#</u>
	POL5020B	POL5030B	POL5040B	POL5050B	POL5060B		POL5070B
POL5080B							
Mix ratio with ISO200A by wt.	100/100	100/100	100/100	100/100	100/100	100/100	100/100
Mix Time	20"	20"	20"	20"	20"	20"	20"
Cream Time	40"	44"	44"	40"	40"	54"	54"
Gel Time	2'00"	2'00"	2'00"	2'00"	2'00"	1'50"	1'50"
Rise Time	3'10"	3'00"	3'00"	3'10"	3'10"	2'40"	2'40"
Tack Free Time	3'20"	3'10"	3'10"	3'15"	3'20"	2'50"	2'50"
Density, Lbs/PCF	3.00	6.00	8.00	10.00	12.00	16.00	18.00
Specific Gravity @ 25 Deg. C	1.11	1.11	1.11	1.11	1.11	1.11	1.11
Mixed Viscosity 77 Deg. F, cps	875	875	875	875	875	875	875

NOTE: ALL HANDMIX REACTIVITIES RAN @ 25 DEG C