

## 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 2 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>2#</u>	<u>3#</u>	<u>4#</u>	<u>6#</u>
	<u>POL7030B</u>	<u>POL5020B</u>	<u>POL10080B</u>	<u>POL5030B</u>
Mix ratio with ISO200A by wt.	100/100	100/100	100/100	100/100
Mix Time	20"	20"	20"	20"
Cream Time	40"	40"	44"	44"
Gel Time	2'00"	2'00"	2'00"	2'00"
Rise Time	3'10"	3'10"	3'00"	3'00"
Tack Free Time	3'20"	3'20"	3'00"	3'10"
Density, Lbs/PCF	2.00	3.00	4.00	6.00
Specific Gravity @25 Deg. C	1.11	1.11	1.11	1.11
Mixed Viscosity	875	875	875	875

High Density Rigid Foam Cont'd

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

NOTE: ALL HANDMIX REACTIVITIES RAN @ 25 DEG C