POLYCOAT PRODUCTS
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TECHNICAL DATA SHEET

PCF 425-4-50S-BLACK

Semi Rigid Foam

Typical Properties PCF 425-4-50S (ISO)

Viscosity, mPa·s @ 25°C: 150-250
Specific Gravity @ 25°C : 1.21
Appearance @ 25°C: liquid

Typical Properties PCF 425-4-50S (polyol blend)

Viscosity, mPa·s @ 80°C: 1500-2000
Specific Gravity @ 25°C : 1.06
Appearance @ 25°C: viscous liquid

Typical Physical Properties		
Cream Time	seconds	45-55
Rise Time	seconds	160-220
Demold Time	minutes	5-10
Density	Lbs/ft³	3.8-4.3

Processing Characteristics		
Mix ratio by weight A/B		44/56

Product Description:

The PCF 425-4-50S-BLACK polyurethane semi-flexible foam system is designed for use in molding flexible foam pieces with a stiff feel.

Application:

The PCF 425 series systems have been formulated for use in the manufacturing of Archery Targets, Movie set and prop displays. It can be formula from the density 4 to 20 pcf.

Storage and Handling:

Containers for both A and B components should be kept tightly closed to prevent moisture contamination. Do not reseal if contamination is suspected. Use of a dry nitrogen blanket for partial drums is recommended. Component B may be stored at ambient temperatures. Storage for Component A should be maintained between 77°F (25°C) and 95°F (35°C). For best results, this product should not be allowed to freeze, although it may be re-heated in a well ventilated oven for a period of time to re-liquefy solid particles. To avoid product degradation, product temperature during re-heating should not exceed 140°F (60°C). An additional note of caution is that exposure to temperatures over 400°F (204°C) can create excessive pressure potentially causing containers to rupture. Do not breathe aerosol or vapors and avoid contact with skin and eyes. Exposure to vapors of heated MDI can be dangerous. To heat product properly, use well ventilated convection ovens or other methods that distribute heat evenly. Avoid using drum heaters or other heat sources that may cause excessive local heating.

Health and Safety Information:

Appropriate literature has been assembled which provides information concerning the health and safety precautions that must be observed when handling any of the products listed above. Before working with these products, it is your responsibility to read and become familiar with the available information on its hazards, proper use and handling. This is extremely important and cannot be overemphasized. Information is available in several forms, e.g. material safety data sheets and product labels. To obtain this information, contact your Polycoat representative.