

Basis	Casting Foam
Resin	PU 20 Casting Foam Comp. A
Hardener	PU 20 Casting Foam Comp. B
Colour	beige

Applications

- Styling models
- Laminate molds
- Base constructions
- Negatives

Properties

- density 200 g/l
- good milling
- very good surface structure
- easy to machine
- very good flowability
- good heat resistance

Processing data

Product		Mixture PU 20 Casting Foam /Comp. A+B	Resin PU 20 Casting Foam Comp. A	Hardener PU 20 Casting Foam Comp. B
Colour		beige	beige	brown transparent
Mixing ratio	p. b. w.		100	80
Viscosity at 25°C	mPas	-	3100 ± 300	50 ± 5
Density at 20°C	g / cm ³	ca. 1,20	1,34 ± 0,2	1,06 ± 0,2

Physical data

Properties	Inspect. requirem.	Unit	Value
Density cured	-	g / cm ³	0,20 ± 0,02
Compressive strength	EN ISO 604	MPa	2,4 ± 0,1
Coefficient of linear expansion	DIN 53752	10 ⁻⁶ K ⁻¹	77
Shore hardness	DIN 53505	Shore A	70 - 75
Shore hardness	DIN 53505	Shore D	18 - 22
Heat resistance (HDT)	DIN EN ISO 75 B	°C	52 ± 1

Sales units (packages)

Units	Comp. A	PU 20 Casting Foam Comp. A	5,000 kg; 15,000 kg
	Comp. B	PU 20 Casting Foam Comp. B	4,000; 12,000 kg

Processing instructions

For optimum mould release we recommend our release agent T1-1, which can easily be applied with brush or be sprayed.

Apply the release agent 2 – 3 times and evaporate for about 20 min. after each application.

Before processing stir up comp. A carefully. Stirred-in air improves the foaming result.

The system can be casted manually or mechanically.

In case of manual casting mix the components carefully for about 30 – 45 secs. with a star-shaped mixing rod.

Foaming for all thicknesses up to 300 mm possible. In order to get a dense surface we recommend to paint the mould with a brush in advance.

Inition time (expansion): about 60 - 90 sec.

Upflow time incl. follow-up pressure (expansion): about 5 – 6 min.

Example for calculation of mixture quantity:

Volume of part: 3 ltrs.

Density of expanding foam: 0,2 kg/l

$3 \text{ ltrs.} \times 0,2 \text{ kg/ltr.} = 0,6 \text{ kg mixture quantity}$

Please add about 10% - 20% additional material for losses in mixing and casting.

In General

This product is a polyurethane system.

If required special formulations for density between 0,1 g/cm³ and 0,5 g/cm³ possible.

Storing

Storage at room temperature 18-25 °C.

Opened containers should be closed immediately after use and should be used up as soon as possible.

Information about the expiration date you find on the sales packages.

Safety measure

Please follow the precaution instructions of the Government Safety Organisation of the chemical industry when working with this material. Please follow safety advices !

Waste Disposal

According to arrangement with local authorities cured material can be disposed as domestic or commercial waste. Non-cured products are waste which is subject to inspection and has to be disposed accordingly. In case of further questions please do not hesitate to contact our Department for Product Safety.

The instructions and recommendations are given in good faith and are based on long experience and careful tests. Since the conditions of use are beyond our control, and due to versatility of applications and working methods, we can't give any guarantee. All information are non-binding and are no guarantee for special characteristics or properties of the product. Despite information given from **ebalta** the customer has to make his own tests regarding applications and processing. If any special warranty is requested, written agreement on this subject is essential.

ebalta UK Limited . B2 Langham Park, Trent Lane . Castle Donington . Derbyshire DE74 2UT
t: +44 1332 814700 . f: +44 1332 814775 . e: info@**ebalta**.co.uk . w: www.**ebalta**.co.uk