POLYCOAT PRODUCTS
A Division of American Polymers Corp.

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PRODUCT DATA SHEET

PCF 2416-5-N-NATURAL

Typical Properties PCF 2416 A-COMP (ISO)

Viscosity, mPa·s @ 25°C:	600-800
Specific Gravity @ 25°C :	1.19
Appearance @ 25°C:	liquid

Typical Properties PCF 2416 B-COMP(polyol blend)

Viscosity, mPa·s @ 80°C:	300-500
Specific Gravity @ 25°C :	1.02
Appearance @ 25°C:	liquid

Typical Physical Properties @ 74 ° f		
Cream Time	Seconds	30-40
Rise Time	Seconds	100-120
Demold Time	Minutes	5-15
Density	Lb/cubic foot	4.7-5.4

Product Description: The PCF 2416 polyurethane self-skinning, HCF-245fa, 1,1,1,3,3-Pentafluopropane blown, flexible foam system is designed for self-skinning applications. The product can be pigmented to match most colors. The PCF 2416 system can be formulated in a range of densities from 5.0 to 15.0 pounds per cubic foot. The system can also be formulated with fire retardants on request to meet customer requirements. The unique handling characteristics of the PCF 2416 system provide ease of mixing, by hand or by machine, and produce a uniform product with excellent cell structure.
APPLICATIONS: The PCF 2416 system has been formulated for use in the manufacturing of furniture, seat cushions, spa pillows, seat backs, arm rests and automotive applications. It is excellent in any applications requiring flexible, tough-skinned foam.

Processing Characteristics		
Mix ratio by weight A/B		38/62
Temperature A		90 F
Temperature B		60 F

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 yours Polycoat Products representative.