



**Product Description**

PCF 25201-6 polyurethane foam systems are designed for molding and void filling applications. PCF 25201-6 can be designed to meet a variety of reactivity requirements without sacrificing product quality and can be formulated to a wide range of densities from 5 to 20 pounds per cubic foot. The unique handling characteristics of the PCF 25201 series systems provide ease of mixing by hand or machine to produce a uniform product with excellent cell structure. This product does not contain any CFC blowing agent or other Ozone Depleting chemical.

**Applications**

The PCF 25201 series systems have been formulated for use as a high compressive strength rigid foam for the manufacturing of molded picture frames, furniture parts, structural floats and other design applications.

**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. Side-B may be stored at ambient temperatures. Storage for Side-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.

**Typical Properties Side-A (ISO)**

<b>Viscosity @ 77°F (25°C)</b>	150-250 MPa
<b>Lbs/gal</b>	10.33
<b>Specific Gravity @ 77°F (25°C)</b>	1.24
<b>Appearance @ 77°F (25°C)</b>	liquid

**Typical Properties Side-B (POLYOL BLEND)**

<b>Viscosity @ 77°F (25°C)</b>	1300-1600 MPa
<b>Lbs/gal</b>	8.69
<b>Specific Gravity @ 77°F (25°C)</b>	1.04
<b>Appearance @ 77°F (25°C)</b>	viscous liquid

**Typical Physical Properties**

<b>Density, ASTM D1638</b>	6-6.5 pcf
<b>Compressive Strength, ASTM D1621</b>	130-160 psi
<b>Tensile strength, ASTM D1623</b>	140-160 psi
<b>Shear Strength, ASTM C273</b>	100-120 psi
<b>Compressive Modulus, ASTM D1621</b>	3000-3200 psi

**Processing Characteristics @74°F (23°C)**

<b>Ratio, by Weight A/B</b>	50/50
<b>Cream Time</b>	55-60 seconds
<b>Gel Time</b>	140-150 seconds
<b>Tack Free Time</b>	200-250 seconds
<b>Demold Time</b>	5-20 minutes

**HEALTH AND SAFETY**

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 Products representative.



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