

PU STRUCTURAL FOAM H75-AT

POLYURETHANE FOAM

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:: CHARACTERISTIC

H75-AT is a closed cell, 2 component hard foam that cures to a non porous surface when poured into a mould. It has a cup density of approx. 75 kg/m³ and can be mixed and poured by hand as it has a long start time. Mechanical mixing reduces the density and start time. If a large amount is poured into a closed mould, the density and pressure exerted on the mould increases. H75-AT is mixed with the B component Type II and is resistant to diluted acids, bases and water.

:: AREA OF APPLICATION

Hard and shapeable components with a non porous surface:

- Lids
- Shells
- Reliefs
- Figures
- Decorative parts
- Filling material for use in taxidermy
- Models
- Components for precision castings

:: PRODUCT DATA

| Material data of the liquid product | | |
|---------------------------------------|--|--------------------------------|
| | Component A | Component B |
| Colour | yellowish | brownish |
| Density at 20 °C | approx. 1.10 g/cm ³ | approx. 1.22 g/cm ³ |
| Viscosity at 20 °C | approx. 1900 mPa.s | approx. 300 mPa.s |
| Material data of the mixture at 20°C | | |
| Mixing ratio A : B | 100 : 145 pbw (parts by weight) | |
| Start time | approx. 60 seconds | |
| Setting time | approx. 150 seconds | |
| Rise time | approx. 220 seconds | |
| Material data of the cured product | | |
| Density | approx. 75-80 kg/m ³ (free-rise foamed) | |
| Expansion | approx. 1 : 13 | |
| Storage (at room temperature and dry) | minimum 6 month in the closed original container | |

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Qualitätsmanagement-System
zertifiziert von LLOYD'S nach
der Qualitätssicherungsnorm
DIN EN ISO 9001 : 2008



:: INSTRUCTION FOR USE

The volume of the cavity which is to be filled has to be approximately calculated. In order to ensure a continuous, high foam quality, it is necessary to maintain the following conditions:

- 1) Stir the A-component thoroughly before use.
- 2) Ensure that both components are kept at a minimum constant temperature of 18°C.

Weigh out both components using the stated mixing ratio and mix both thoroughly. When mixing large amounts use a mixing propeller on a drill with a speed of 1500 rpm to ensure thorough and rapid mixing. The foam is then poured into the cavity. When more than the calculated amount of foam is poured into the mould or cavity the pressure on the walls increases as does the specific gravity. This must be taken into account.

Long moulds must not be placed horizontally but at an angle of 10° to 15°. Inject the foam at the lowest point of the mould, making sure there is provision for air vents at the top of the mould. The surface temperature of the cavity or mould should be between 15°C and 25°C. Two component foams can also be applied by machine.

:: SAFETY ISSUES

The before mentioned technical data and information, especially the recommendations for applying and using our products, are based on our current knowledge and experience when applied under normal conditions. In practice, the materials, surfaces or site conditions are so different that no warranty regarding the working results or liability, arising out of any relationship, can be inferred neither from this information nor from a verbal consultation, except we are charged with intent or gross negligence. In this case the user is obliged to prove that he has informed us about all points required for a proper and promising judgement in writing, in time and completely. Patent rights of any third party are to be observed. Furthermore, our general sales and delivery Terms and Conditions and the latest Technical Data Sheet, which should be demanded, apply.

Directions for handling and waste disposal are in our Security Safety Data Sheet and the specifications of the Employers Liability Insurance Association for the chemical industry .

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