

DALCHEM GPF 32 General Purpose Polyurethane Foam

Dalchem GPF 32 is a general-purpose rigid polyurethane foam product for pour in place applications. The formulation contains fire-retardants and has a free-rise density of 33 g/m^3 . This product contains no CFC's or HCFC's and is environmentally friendly foam that has no ozone depleting potential. This product can be hand mixed or processed through polyurethane foam dispensing equipment. This closed cell foam has been designed for use in a wide range of insulation, buoyancy and cavity filling applications.

Colour:	Yellow
Mix Ratio:	100:100 (Polyol:Iso) by weight
Viscosity:	<950 cps mixed
Specific Gravity:	Polyol 1.15, Iso 1.22
Mix Time:	20 seconds
Cream Time:	35 seconds
Gel Time:	145 seconds, Tack Free 230 seconds (4 minutes)
Thermal Conductivity:	0.0256 W/mK, closed cell content >90%
Free Rise Density:	33 kg/ m ³ . Volume expansion approx 26:1





GPF 32 Rigid Foam

Mixing & Application Guidelines

To produce a high quality foam it is important to follow the mixing procedure carefully.

Accurately weigh each component into the same clean dry container. The reaction will essentially begin to take place now the products are together.

Mix the products with an electric drill /paint mixer. It is important to mix at a minimum of 2000 rpm to produce good quality foam.

Mix for 8-10 seconds typically. Note: Be aware that cream time of the foam will vary depending on batch size, ambient temperature and original chemical storage temperature.

Product should be fully mixed and poured before the cream time is reached.

Moulds

Always use a release agent on the mould. We recommend a wax based release.

Ensure release is reapplied before each moulding.

If conditioning a new mould with a solvent based system, ensure no residual solvent remains in the mould.

Mould temperatures over 30°C will produce a foam with less skin.

As foam generates pressure within the mould, it is usually necessary to incorporate small venting holes in the mould to control ventilation. Excessive venting can cause large voids below the surface skin of the foam. Articulate the mould so vent points are at the high point on the mould if possible.

Please contact your Dalchem representative for specialist application advice.

Note all data given is based on laboratory testing at 20°C.