

**DALCHEM GPF96 General Purpose Polyurethane Foam**

Dalchem GPF96 is a general-purpose strong rigid foam product for pour in place applications. The formulation contains Fire-Retardant and has a free rise density of 96kg/m<sup>3</sup>.

This product can be hand mixed or processed through polyurethane foam dispensing equipment. This product has been designed for use in a wide range of void filling applications or to improve the structural integrity of components..

<b>Colour:</b>	Iso- Brown Liquid    Polyol- Opaque Liquid
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<b>Mix Ratio:</b>	100:100 (Polyol:Iso) by weight
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<b>Viscosity:</b>	<2500 cps mixed
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<b>Specific Gravity:</b>	Iso   1.23, Polyol 1.06
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<b>Mix Time:</b>	20 seconds
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<b>Cure Time:</b>	Cream 60 sec, Gel 240 sec, Tack Free 420 sec
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<b>Free Rise Density:</b>	96 kg/ m <sup>3</sup> .
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## **GPF96**

### **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 200rpm to produce good quality foam.

Mix for 10-20 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.*

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