

**DALCHEM HRF 60 Flexible Polyurethane Foam**

Dalchem HRF 60 is a high resilience flexible (sponge) polyurethane foam, typical applications are for the manufacture of seat cushions, or for filling of cavities where a lightweight flexible filling is desired. It is also used in the manufacture of moulded components and for theatre props and costumes. HRF 60 is a CFC free product.

<b>Colour:</b>	Yellow
<b>Mix Ratio:</b>	100:45 (Polyol:Iso) by weight
<b>Viscosity:</b>	<1600 cps mixed
<b>Specific Gravity:</b>	Polyol 1.06, Iso 1.20
<b>Mix Time:</b>	8 seconds
<b>Cream Time:</b>	13 seconds
<b>Gel Time:</b>	65 seconds, Tack Free 210 seconds (4 minutes)
<b>Free Rise Density:</b>	60 kg/ m <sup>3</sup> . Volume expansion approx 15x





HRF 60 Flexible PU 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.*