

ISF 136 Integral Skinning Foam

Dalchem ISF 136 is an integral skinning foam with a free rise density of 135kg/m³.

This product is suitable for producing moulded parts requiring the flexibility of foam with a skinned surface. Typical applications are the manufacture of bicycle or motor cycle seats, low impact bump pads, armrests or animatronic models.

Colour:	Whitish / Brown
Mix Ratio:	100:35 (Polyol:Iso) by weight
Viscosity:	<950 cps mixed
Specific Gravity:	Polyol 1.07, Iso 1.2
Mix Time:	10 seconds
Cream Time:	24 seconds
Gel Time:	49 seconds
Tack Free:	75 seconds
Free Rise Density:	135 kg/ m ³ . Volume expansion approx 9:1





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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 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.