

## Rigid Open-Cell 4-5 Pound Foam

Rigid 4-5 pound polyurethane foam

### Key Properties

- Excellent physical properties after RT cure
- Free of mercury, MOCA or TDI

### Applications

- For hand-batch and meter-mix processing
- Safety helmet inserts, structural castings and taxidermy blanks

### Processing Properties

			Resin (Isocyanate)	Hardener (Polyol)
Mix ratio		pbw	100	97
		pbv	100	100
Density	ASTM D-792	g/cm <sup>3</sup>	ca. 1.20	ca. 1.16
Viscosity at 77°F (25°C)	ASTM D-2393	cP	ca. 100	ca. 675

			Mixture
Mix viscosity at 77°F (25°C)	ASTM D-2393	cP	ca. 250
Cream time at 77°F (25°C)		sec	35-45
Rise time at 77°F (25°C)		sec	120-150
Tack Free time at 77°F (25°C)		sec	180-240
Demold time at 77°F (25°C)		min	10-20

### Cured Properties

Cure 1: 7 days at 77°F			Cure 1
Aspect	visual		Light Tan
Density	ASTM D-792	g/cm <sup>3</sup>	0.064-0.080
Density	ASTM D-792	lb/in <sup>3</sup>	0.0023-0.0029
Density	ASTM D-792	lb/ft <sup>3</sup>	4-5

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### Processing

**The processing and material temperature should be between 68-77°F (20-25°C).**

FM-7045 can be dispensed using drill mixing methods. Use a high speed drill with a paint mixer attached and mix for ten seconds before pouring directly into the mold. Do not hand mix only, as the material does not receive the required shear and will not form the proper cell structure. To obtain quicker cycle times, preheat the mold to 120°F. Also the use of wax to release the foam from the mold is recommended.

\* Although a volumetric ratio of 100:100 is listed above and can be used without deterring from the listed cured properties, the volumetric ratio using our standard stoichiometry is 95:100.

**Agitate the hardener before use to ensure that the formula is homogeneous.**

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### Packaging

FM-7045 Quart Kit	3.94 lbs.
FM-7045 1 Gal. Kit	15.76 lbs.
FM-7045 5 Gal. Kit	78.8 lbs.
FM-7045 Drum Kit	886.5 lbs.

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### Storage

Original containers should be kept tightly sealed and stored at ambient temperatures 59-86°F (15°C to 30°C). If properly stored the products have the shelf-life indicated on the product label.

Partly used containers should always be sealed appropriately and used up as soon as possible.

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### Handling Precautions

Good workplace ventilation is to be ensured during processing. At the same time, the employer's liability insurance association's industrial hygiene safety regulations regarding the handling of reaction resins and their hardeners are to be observed. Please take heed of the appropriate safety data sheets.

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