

PE-3801 / PH-3905, PH-3980

Polyurethane Foam System

Flexible molding foam, liquid

Key Properties

- Soft – flexible and compressible
- Very fast reactivity, short demold time
- Good flow properties
- Low density foam

Applications

- Foam system for seat upholstery

Processing Properties

		Unit	PE-3801	PH-3905	PH-3980
Color	visual		yellowish	light brown	light brown
Mix ratio		pbw	100	37,5	-
Mix ratio		pbw	100	-	50
Mix ratio		pbv	100	30,5	-
Mix ratio		pbv	100	-	40,5
Density	ISO 1183	g/cm ³	ca. 1.00	ca. 1.23	ca. 1.22
Viscosity at 25 °C	DIN 53019-1	mPa·s	1,200 - 1,800	150 - 200	500 - 700

		Unit	PE-3801 / PH-3905	PE-3801 / PH-3980
Cream time	30g	sec	90 - 120	45 - 70
Setting time	30g	sec	180 - 210	120 - 180
Tack-free time	30g	min	10 - 15	10 - 15

Cured / Mechanical Properties

		Unit	PE-3801 / PH-3905 30 min at RT	PE-3801 / PH-3980 30 min at RT
Cure				
Color		visual	beige	beige
Volumetric weight at 25°C		g/l	ca. 100	ca. 80
Hardness	ISO 868	Shore 00	18 - 22	30 - 35
Elongation at break	ISO 1798	%	70 - 75	100 - 110
Tensile strength	ISO 1798	MPa	0.1 - 0.2	0.4 - 0.5



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The processing temperature and material temperature should be between 20-25°C.

The A component needs to be stirred well before use as some fillers might be prone to sedimentation.

Due to the short processing time, the system is generally processed using a two component meter, mix and dispense machine. The recommended material temperature must be observed. Too high or low a material temperature will change the viscosity (high/low) and have a direct influence on the mixing ratio set up on the machine. Changes in the mixing ratio will result in faults in the finished part.

Packaging

RAKU® TOOL PE-3801	25 kg
RAKU® TOOL PH-3905	25 kg
RAKU® TOOL PH-3980	25 kg

Storage

Original containers should be kept tightly sealed and stored at ambient temperatures (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.

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.