



## 22-063 High Density Rigid Foam System

### Technical Data Sheet

NCFI 22-063 is a two-component, water-blown, all PMDI based high density pour foam ideal for molding applications.

### Typical Properties of Components

Component	B-22-063	A2-000
Appearance	Transparent amber liquid	Transparent brown liquid
Brookfield Viscosity @ 50 rpm	2200 cps at 72°F	200 cps at 72°F
Specific Gravity	1.07	1.24
Storage Temperature	40°F – 90°F	40°F – 90°F

### Mix Ratio, 115 Index

By weight.....100 parts poly : 100 parts iso

### Typical Properties of Mixed System at 72°F, 115 Index

Cream Time	50 seconds
Gel Time	160 seconds
Tack Free Time	210 seconds
Rise Time	230 seconds
Free Rise Core Density	10 pcf

### Process Parameters

Iso Temperature	75°F to 85°F
Poly Temperature	70°F to 95°F
Mold Temperature	95°F to 125°F
Demold Time	7 to 9 minutes*

\* Demold time is dependent on shot size, and material and mold temperatures. NCFI recommends using a high-quality, properly applied wax or silicone release agent to prevent cured material from sticking to mold surfaces.

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## **Storage and Handling**

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Mix poly component to a homogenous state prior to use. Avoid entraining air during mixing. Store the poly from 65°F to 85°F. Avoid moisture contamination during storage, handling, and processing. For both components, pad containers and day tanks with either nitrogen or dry air (desiccant cartridge or air dryer @ -40°F dew point). For optimum shelf life, the recommended storage temperature for iso is 64°F to 86°F. **Do not expose iso to lower temperatures – freezing may occur.** Shelf life is 6 months for factory sealed containers.