NCFI Polyurethanes
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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	A-22-063
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	40ºF – 90ºF	40ºF – 90ºF

Mix Ratio, 115 Index

By weight……100 parts poly : 100 parts iso

Typical Properties of Mixed System at 72ºF, 115 Index

	REGULAR	**SLOW**	**VS**
Cream Time	50 seconds	65 seconds	85 seconds
Gel Time	160 seconds	195 seconds	270 seconds
Tack Free Time	210 seconds	280 seconds	380 seconds
Rise Time	230 seconds	300 seconds	400 seconds
Free Rise Core Density	10.0 pcf	10.0 pcf	10.0 pcf

Process Parameters

Iso Temperature	75ºF to 85ºF
Poly Temperature	70ºF to 95ºF
Mold Temperature	95ºF to 125ºF

* 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.

Typical Physical Properties

MIL-PRF-26514G, TYPE I (STANDARD FOAM), CLASS 1	PASS
Compressive Strength (ASTM D1621)	5% deformation at max load 745 psi
Compressive Strength (ASTM D1621) After Hydrolytic Stability Test	5% deformation at max load 745 psi
Relative Combustibility (MIL-PRF-26514G)	pass
Water Absorption	4.84%
Dimensional Stability, 158F, 100% R.H. 14 days	0.09%

All testing performed on 20 pcf molded part, 100R:100A ratio

Storage and Handling

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.

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