NCFI Polyurethanes
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22-069
High Density Rigid Foam System

Technical Data Sheet

NCFI 22-069 is a two-component, water-blown, all PMDI based high density pour foam ideal for molding applications.

Typical Properties of Components

Component	B-22-069	A2-000
Appearance	Transparent amber liquid	Transparent brown liquid
Brookfield Viscosity @ 50 rpm	2130 cps at 72°F	200 cps at 72°F
Specific Gravity	1.08	1.24
Storage Temperature	40ºF – 90ºF	40ºF – 90ºF

Mix Ratio, 91 Index

By weight……100 parts poly : 87 parts iso

Typical Properties of Mixed System at 72ºF, 91 Index

Cream Time	52 seconds
Gel Time	180 seconds
Tack Free Time	225 seconds
Rise Time	270 seconds
Free Rise Core Density	6.67 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.

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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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