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TECHNICAL DATA

Erathane MF62

RIGID POLYURETHANE FOAM

Erathane MF62 is two-part polyurethane product that contains a fire retardant. When mixed at the correct ratio, produces a **WHITE** foam with a free rise density of 62 kg/m³.

The product can be manually drill mixed (@ a minimum speed 2000 rpm) or processed through a low-pressure foam-dispensing machine. It has been designed for use in a wide range of moulding, special effects, and cavity filling applications.

COMPONENT PROPERTIES

	Polyol	Isocyanate
Appearance	Clear, honey coloured liquid	Clear, pale yellow liquid
Brookfield viscosity (cps)	300	33
Specific gravity	1.15	1.22

REACTION PROFILE

Laboratory results based on hand-mix @ 20°C

Mix ratio by weight (Polyol: Iso) 100:100

Mix time (seconds)	20
Cream time (seconds)	70
Gel time (seconds)	155
Tack free time (seconds)	190
Free rise density (kg/m³)	62

MIXING PROCEDURES

There are a number of ways to successfully produce foam. It is greatly dependant on the type of mould and desired finish. A method will be explained below which highlights the finish and mould cost.

This information is of general nature and is supplied without recommendation of guarantee. It does not make claim to be free from patent infringement. Properties shown are typical and do not imply specification tolerances. Era Polymers cannot accept liability for loss or damage through use. Whilst these technical details are based on expert knowledge, practical experience and laboratory testing, successful application depends upon the nature and conditions in which the products are supplied. Users must, by comprehensive testing, evaluate this product in their own application.



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TYPICAL PHYSICAL PROPERTIES

Properties presented below are to be used as a guide and not intended for specification purposes.

Foamed Density (kg/m³)	62	
Compressive stress @ 10% (kPa) Parallel to the rise	295	(Based on AS2498.3)
Compressive stress @ 10% (kPa) Perpendicular to the rise	168	(Based on AS2498.3)
Closed Cell Content (%)	>92	(Based on AS2498.7)
Thermal Conductivity-initial (W/mK)	0.021	(Based on ASTM C518)
Flexural strength (MPa)	0.64	(Based on AS2132)

RIGID MOULD METHOD

This technique utilises simple and low cost mould production. It is limited to relatively simple shapes.

MOULD MATERIAL

Can be produced from most workable products including wood, aluminum, steel and plaster. Porous materials such as wood and plaster must be sealed with adequate coats of appropriate sealant.

MOULD PRODUCTION

- Typically a cavity is formed up or machined from the mould material.
- Moulds are usually two-part (base and lid joined with hinges). This type of suit case mould will allow the mixed material to be poured around the cavity quickly and easily. It also allows the lid to be secured quickly and safely.
- The product is a rigid foam and is **only** easily removed from a rigid mould if the cavity has a slight taper.
- Breather holes (1-2 mm) should be placed strategically around the mould to allow air to escape during the foaming process.

METHOD

1. Coat the mould with Erlease brand release agent.
2. Weigh out Polyol into a clean dry container.
3. Into the same container, add the correct amount of Iso.
4. Drill stir (2,500 - 2,800 rpm) for approximately 20 seconds.
5. Pour mixed material around the mould cavity.
6. Close lid and clamp shut.
7. Open mould after 10-15 minutes and de-mould carefully.
8. Wipe release agent off foam thoroughly with compatible solvent before painting.

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