

Soft integral foam, thixotropic

Description

RAKU-PUR® 32-3250 is a thixotropic, two-component polyurethane system. It consists of a filled resin component A and a hardener component B (MDI). The system contains no solvents, plasticizers or halogenated hydrocarbons. It is characterized by:

- high sealing performance
- tested for UL 94 HBF
- very low foam density
- very low water absorption
- compact, hydrophobic integral skin
- high mechanical strength / tear resistance
- very high tensile strength
- very short cure and assembly time
- good value / performance
- good mounting adhesion to metal surfaces

Temperature resistance

Continuous operating temperature: - 40 °C to + 100 °C
short exposure: up to + 160 °C

Application

The product is used for the production of formed-in-place foam gaskets (FIPFG) and of molded foams. The hardness of the material can be adjusted to the specific application by changing the mixing ration

Processing

Before use, the component A must be homogenized, as additives tend to cause phase separation. The density of the material can be adjusted to the processing specification of 0.80 - 0.90 g/ml by adding dispersed air through stirring. The air helps to ensure a uniform foam structure. The component B is very sensitive to moisture and must not be stirred. Due to its high reaction rate, the system is usually processed by two-component mixing and dispensing machines.

Raw components data

		RAKU-PUR® 32-3250 A	RAKU-PUR® 32-3250 B
Viscosity, $\gamma = 2.5 \text{ s}^{-1}$	mPa*s	70,000 - 100,000	-----
Viscosity	mPa*s	-----	500 - 700
Density without air	g/ml	1.05 - 1.15	1.22 - 1.24
Density with recommended air loading	g/ml	0.80 - 0.90	-----
Color: various		black, grey, red, green	light brown

measured at 20 °C

Processing data

	Unit	Value	
Mixing ratio A : B	Parts by weight	4,5 : 1	5,0 : 1
Processing temperature	°C	15 - 35	15 - 35
Cream time	sec.	20 - 30	25 - 35
Tack free	minutes	2 - 4	2 - 4
Density, foamed in 30 ml beaker	g/l	200 - 240	220 - 260
Hardness, lab foamed in beaker	Shore 00	45 - 50	30 - 35

measured at 20 °C, 30 ml formulation, laboratory stirrer 1800 rpm.

Standard shipping containers

	Component A	Component B
	Contents	Contents
	kg	kg
Container	1000	-----
Drum, removable lid	200	-----
Drum, screw cap	-----	225
Canister, internally coated	30	-----
Can	-----	30

Storage

Original containers may be stored at ambient temperature (10 °C - 35 °C) for 6 months. Short term (<3 days) the components A and B can resist temperatures down to -20°C. At longer storage, the component B may partly crystallize. Since both components are affected by air moisture, containers should be kept tightly sealed.

Health and safety at work

The workplace in which the material is being used must be well ventilated. All applicable health and safety regulations governing the use of reactive resins and their hardeners must be observed. Please also observe the respective safety data sheets.