

Basis	casting foam
Resin	PU 05 casting foam Comp. A
Hardener	PU 05 casting foam Comp. B
Colour	beige

Applications

- molding parts

Properties

- density 50 g/ltr.
- good milling properties
- fine structure
- good heat resistance
- very good flowability

Processing data

Product		Mixture PU 05 casting foam	Resin PU 05 casting foam Comp. A	Hardener PU 05 casting foam Comp. B
Colour		beige	yellowish transparent	brown transparent
Mixing ratio	p. b. w.		100	160
	volume		100	133
Viscosity at 25°C	mPas	-	140 ± 10	200 ± 40
Density at 20°C	g / cm ³	ca. 1,20	1,02 ± 0,2	1,23 ± 0,2

Physical data

Properties	Inspect. requirem.	Unit	Value
Density cured	-	g / l	45 ± 5
Compressive strength	EN ISO 604	MPa	0,18 ± 0,05

Sales units (packages)

Units	Comp. A	PU 05 casting foam Comp. A	5,000 kg
	Comp. B	PU 05 casting foam Comp. B	8,000 kg

Processing instructions

Material and processing temperature 18-25°C.
Close containers right after use.

Recommended temperature for demoulding approx. 60°C

For optimum demoulding we recommend our release agent T03-01, easy application by brushing or spraying.
Apply release agent 2-3 times and allow to evaporate for about 20 min. after each application.

Before processing stir-up comp.A properly until foamy. Better foaming result by stirring in air.

System can be casted manually or mechanically.
In case of manual casting both components must be mixed properly with star mixer for about 20 sec.
Foaming of wall thickness up to 300 mm.

Inition time (expansion): about 20 sec.
Curing time: about 1,5 - 2 min.
Rising time incl. holding pressure time (expansion time): about 2 min.

Follow exact mixing ratio of resin and hardener

Any resin residues can be removed with our **ebalta** cleaning agent.

Example for calculation of material quantity:

Volume of part: 4 litres
Density of expanding foam: 0,050 kg/l

$4 \text{ litres} \times 0,050 \text{ kg/l} = 0.200 \text{ kg material quantity}$

Please calculate plus 10% of the material for any material loss in mixing and casting.

Demoulding after approx. 30 minutes. Optimum product properties after storage of parts at certain temperatures.
Example: for 6 hrs. at 60°C -80°C.

Storing

Storage at room temperature 18-25 °C.

Opened containers should be closed immediately after use and should be used up as soon as possible.

Shelf life is indicated on the labels.

Safety measure

Please follow the precaution instructions of the Government Safety Organisation of the chemical industry when working with this material. Please follow safety advices !

Waste Disposal

According to arrangement with local authorities cured material can be disposed as domestic or commercial waste.
Non-cured products are waste which is subject to inspection and has to be disposed accordingly.
In case of further questions please do not hesitate to contact our Department for Product Safety.

The instructions and recommendations are given in good faith and are based on long experience and careful tests. Since the conditions of use are beyond our control, and due to versatility of applications and working methods, we can't give any guarantee. All information are non-binding and are no guarantee for special characteristics or properties of the product. Despite information given from **ebalta** the customer has to make his own tests regarding applications and processing. If any special warranty is requested, written agreement on this subject is essential.