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Hand Pour/Injection/
 Sprayable Foams

HCFC/HFC/Pentane/
 Water Blown Foams

Integral Skin Foams

Polyurethane Rigid Foam
 Sheets

Polyurea & Polyurethane
 Spray Elastomers

Polyurethane Panel
 Adhesives

Tufflex Waterproofing

Disposable Foam
 Products

Packaging Foams

Foam-in-Place/Foam-in-Bag
 Dispensers

DESCRIPTION

PACTHANE PAC 1927HW is a 27 kg/m³ density low viscosity fire retardant Rigid Polyurethane Injection Foam system formulated for hot water cylinders and discontinuous panel products.

PACTHANE PAC 1927HW achieves high adhesion to metal and wooden facings and is recommended for maximum yield.

A dual blowing system gives optimum foam quality with reduced R141B content.

APPLICATIONS

PACTHANE PAC 1927HW is specifically formulated for **Hot water cylinders** but may also be used for other general insulation applications, such as cabinets, pipework, fish holds etc as well for foaming discontinuous panel products and doors.

PHYSICAL PROPERTIES

LIQUID COMPONENTS

	COMPONENT A	COMPONENT B
Appearance	Brown liquid	Clear liquid
Specific Gravity	1.24	1.19
Viscosity	200 cps	800 -1000 cps
Mix Ratio – by volume	1	1

REACTION PROFILE (20°C)

Cream Time	30 seconds
Gel Time	140 seconds
Rise Time	150 seconds

FOAM PROPERTIES

Free rise density	27 ± 2 kg/m ³
Thermal Conductivity	0/025 W/mK approx
Compressive Strength	130 kN/m ² approx
Closed Cells	>90%
Dimensional Stability	1 – 5%
Water Absorption (20°C)	<2% by volume

PROCESSING INFORMATION

PATHANE PAC 1927HW is best processed through high pressure pour - in place plural component dispensing equipment, such as the Glas-Craft dispenser.

Component drums should be pre-heated to at least 25°C prior to mixing/dispensing. Preheat substrate if possible to >25°C.

Do not add more foam until the product has fully risen (up to 3 minutes following pouring).

Machine Dispensing:

Equipment Pressure	1000 28si minimum
Component A (iso)	
Hose Temperature	30°C – 40°C
Machine Temperature	40°C – 45°C
Component B (Polyol)	
Hose Temperature	30°C – 40°C
Machine Temperature	40°C – 45°C

Check machine pressure balance and dispensing ratios regularly. Check the foam quality frequently and resolve any problems before continuing.

The optimum temperatures can vary depending on ambient conditions, applications and substrate.

APPLICATION CONDITIONS

PACTHANE PAC 1927HW is formulated for application on most surfaces under various conditions. Substrates should however be clean and dry. Water or moisture may react with the components and affect the finished results. Elevated surface temperatures will increase the yield. Low surface temperatures (<15°C) will lead to the foam "over-packing" and a loss of yield. Ideal temperatures are 25°C – 35°C.

YIELD

Under ideal conditions, 1 kg of foam should fill 0.037cu. m. The actual yield will depend on factors such as ambient conditions, product geometry, mixing efficiency and equipment settings.

In particular, cold temperatures and long, thin flow paths will reduce yield noticeably.

PRODUCT HANDLING

All persons using polyurethane foam components should be trained in their use and be familiar with the product MSDS's.

Breathing apparatus or forced ventilation/extraction may be required when used in confined areas.

Component A (diphenylmethane-diisocyanate)

This is a potential respiratory sensitizer. Persons who suffer from hypersensitivity of the respiratory tract (e.g. asthmatics and chronic bronchitis sufferers) should avoid handling this product.

Exposure levels must be maintained below the safe thresholds.

Avoid contact with the eyes or skin and breathing the vapour. Wear appropriate personal protective equipment when servicing equipment.

Component B (polyol blend)

This contains polyols and HCFC blowing agents.

Avoid contact with the eyes or skin. If eye contact occurs, flush thoroughly with water and consult a physician.

Wear appropriate personal protective equipment when servicing equipment.

Cleanup

Cured polyurethane foam is difficult to remove chemically. Therefore spillage should be minimized and cleaned up as soon as possible.

PAC Poly Clean aerosol cans can be used for small areas while PAC Methyl Proxitol is available for larger areas and for flushing lines.

Storage

Components should be stored at temperatures between 15°C and 25°C. Containers should be tightly closed

Polyols should be remixed if not used within 3 months of delivery.

Shelf life is 6 months from delivery minimum

24 hr Emergency No: 00800 2436-2255