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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

PAC 4064 is a 64 kg/m³ density low viscosity Rigid Pour Foam.

This formulation is suitable for both hand mix and machine application and is designed for general thermal and sound insulation, marine flotation and void fill. The high percentage of closed cells provides low water permeability.

APPLICATIONS

PAC 4032 is ideally suited to any of following applications.

Marine flotation
Wall and door cavity fill and insulation
Pipe insulation
Void filling
Refrigeration units, cabinets and coolrooms
Fish bins, holds and freezers
Model creation

PHYSICAL PROPERTIES

LIQUID COMPONENTS

| | COMPONENT A | COMPONENT B |
|-----------------------|--------------|--------------|
| Appearance | Brown liquid | Clear liquid |
| Specific Gravity | 1.24 | 1.19 |
| Viscosity (20°C) | 200 cps | 600 cps |
| Mix Ratio – by volume | 1 | 1 |
| - by weight | 1.04 | 1 |

REACTION PROFILE (20°C)

| | |
|----------------|-------------|
| Cream Time | 80 seconds |
| Gel Time | 180 seconds |
| Full Rise Time | 240 seconds |

FOAM PROPERTIES

| | |
|--------------------------------|------------------------------|
| Free rise density | 64 ± 2 kg/m ³ |
| Thermal Conductivity | 0/02 W/mK approx |
| Compressive Strength -Parallel | 150 kN/m ² approx |
| -Perpendicular | 125 kN/m ² approx |
| Closed Cells | 90 – 95% |
| Dimensional Stability | 1 – 5% |
| Water Absorption (20°C) | 2% by volume |

SALES UNITS

| | |
|---------------------|------------|
| 2 X 1 kg tins | 2 kg kit |
| 2 x 5 kg tins | 10 kg kit |
| 2 x 20 kg drums | 40 kg kit |
| 2 x 60 kg drums | 120 kg set |
| 2 x 200 litre drums | 480 kg set |

PROCESSING INFORMATION

PAC 4064 can be hand mixed or processed through high pressure pour - in place plural component dispensing equipment, such as the Glas-Craft dispenser fitted with a Probler Gun.

Drums of components should be pre-heated to at least 25°C prior to mixing or dispensing.

Do not add more foam until the product has fully risen, which will be 3 - 4 minutes following mixing.

Hand Mix:

Ensure drums/cans of product are warmed to at least 25°C. Accurately measure or weigh the A and B components at the specified ratio. Mix thoroughly with a rotary power mixer for a minimum of 25 seconds. Pour into place.

Machine Dispensing:

| | |
|-----------------------------|------------------|
| Equipment pressure | 1000 psi minimum |
| Component A (iso) | |
| Pre-heat | 20 to 30°C |
| Hose Temperature | 35 to 40°C |
| Component B (Polyol) | |
| Pre-heat | 20 to 30°C |
| Hose Temperature | 35 to 40°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

PAC 4064 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 fills 0.016 m³.

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.

Our technical service – whether verbal, in writing or by way of trials – is given in good faith but without warranty, and this also applies where proprietary rights of third parties are involved. It does not release you from the obligation to test the products supplied by us as to their suitability for the intended processes and uses. The application, use and processing of the products are beyond our control and, therefore, entirely your own responsibility. Should, in spite of this, liability be established for any damage, it will be limited to the value of the goods delivered by us and used by you.

PRODUCT HANDLING

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

Provide additional ventilation and/or breathing apparatus if used in confined spaces, as required to maintain safe working conditions.

Component A (diphenylmethane-diisocyanate)

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

Avoid contact with the eyes or skin and breathing the vapour.

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