

PAC PFA170D POLYURETHANE PANEL FOAM ADHESIVE PRODUCT DATA SHEET

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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 PFA170D is a two component polyurethane Panel Foam Adhesive system with a free rise density of 37 - 38 Kg/m³.

The system is designed to bond metal sheeting to polystyrene in a continuous panel forming process. **PAC PFA170D** is also tolerant to process fluctuations and is compatible with various plural component dispensing equipment.

Such equipment includes low pressure plural component polyurethane dispensers or the traditional gravity fed drip and smear panel process.

No CFC, HCFC or HFC blowing agents are used in the formulation.

PHYSICAL PROPERTIES

LIQUID COMPONENTS

	COMPONENT A	COMPONENT B
Appearance	Brown liquid	Clear liquid
Specific Gravity	1.24	1.08
Viscosity	200 cps	800 -1000 cps
Mix Ratio – by volume	1.7	1

REACTION PROFILE (20°C)

Cream Time	11 seconds
Gel Time	32 seconds
Tack Free Time	45 seconds

FOAM PROPERTIES

Free rise density	37 ± 2 kg/m ³
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PROCESSING INFORMATION

Component drums should be pre-heated to at least 25°C prior to mixing/dispensing. Preheat metal and polystyrene to >25°C.

The amount of adhesive required will depend on the surface structure and conditions of the metal and polystyrene.

Check component ratios and dispensing rate regularly.

Metal sheets and polystyrene must be pressed together firmly before the Gel Time is reached.

A specially catalysed version is available to increase cure rate in very cold or winter conditions however best performance is achieved in a warm, temperature controlled environment.

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 sensitiser. 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 water based 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.

Provide additional ventilation if used in confined spaces.

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

Return of Containers

Empty containers can be returned to Pacific Urethanes for recycling.

24 hr Emergency No: 00800 2436-2255