

Product Name

SR-FOAM 135 A/B

135kg Semi Rigid Self Skinning Foam

Product Description

SR-FOAM 135 is a semi rigid, medium density foam. Skin thickness is controlled by material and mould temperature, and the loading of the mould. BJB Pigments may be added for developing a wide range of colours. SR-FOAM 135 can be mixed by hand (see notes) with a spatula, high shear mixer or machine dispensed. This system is perfect for bumpers and crash pads, arms rests and movie construction and SFX departments.

Physical Properties

Density	Free Rise	135 kg/m ³
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Handling Properties

Mix Ratio	By Weight	Part A	100 pbw
		Part B	63 pbw
Viscosity	cps @ 20°C	Part A	1000
		Part B	250
Mix time	@ 20°C		20 seconds
Cream Time	@ 20°C		37 seconds
Gel Time	@ 20°C		78 seconds
Tack Free Time	@ 20°C		120 seconds
Demould Time	@ 20°C		30+ minutes

Mixing Procedures

To produce a high quality skinned foam it is essential that the following procedures be carefully followed.

- The Part B should be accurately weighed into a suitable container, Suitable containers include metal or plastic that are clean and dry.
- The Part A should be mechanically stirred before decanting from the pack. The Part A should be accurately weighed and placed into the same container. The reaction between A & B begins immediately when the two products meet.
- The product should be mixed with an electric drill and paint mixing head. The speed of the mix should be a minimum of 2000rpm. A slower speed such as "hand mixing" may produce a poor quality foam
- The product should typically be mixed for 20 seconds. This may vary depending on the batch size and temperature of the materials. The material should be mixed and poured into the mould before the cream time has been reached.

Mould Preparation

The mould should be well sealed and released. Foams will seek moisture through release waxes and stick to mould surfaces if an insufficient seal exists. The type of sealer is dependant on the mould material. Ideally the mould should be warmed to between 30-40°C, essentially the higher the mould temperature the less skinning is achieved. The temperature should be varied to give the optimum skin.

Release systems vary in accordance with the mould material, however, as a general rule we recommend JWax, Challenge 90 and TR-Wax. As a general rule, silicone based releases do not work successfully with either the S-FOAM, SR-FOAM or R-FOAM series. The silicone migrates and often causes poor surface conditions. Silicone can also inhibit the adhesion of paints and over-coatings.

The premium moulds for foam production (rather than short run prototypes and limited parts) are either machine aluminium moulds or epoxy moulds. Epoxy moulds offer the least expensive method for long term use when cycle times allow slower heat dissipation.

Storage

Containers should always be purged with F720 Dry Air Blanket prior to replacing the lid after each use. Store both containers in an area where the temperature is between 18-25°C. When first using the material, a sample should be visually inspected to be sure no crystallization is present. Crystallization can occur during shipment and storage in cold weather. If the product appears cloudy or gummy, the components should be warmed with the containers open and stirred until the material returns to its proper smooth liquid consistency.

Do not shake the closed containers excessively. This could cause unmixed material to expand on its own.

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1

Disclaimer

The data presented in this leaflet are in accordance with the present state of our knowledge, and does not absolve the user from carefully checking all supplies immediately on receipt. We reserve the right to alter product constants within the scope of technical progress or new developments. The recommendations made in this leaflet should be checked by preliminary trials because of conditions during processing over which we have no control, especially where other companies' raw materials are also being used. Recommendations for use do not constitute a warranty, either expressed or implied, of the fitness or suitability of the product for a particular purpose.