



**NCFI Polyurethanes**

**Div. of Barnhardt Manufacturing Co.**

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## 22-064 High Density Rigid Foam System

### Technical Data Sheet

NCFI 22-064 is a two-component, water-blown, all PMDI based high density foam ideal for molding applications.

### Typical Properties of Components

Component	R-22-064	A-22-064
Appearance	Transparent amber liquid	Transparent brown liquid
Brookfield Viscosity @ 50 rpm	2850 cps at 72°F	200 cps at 72°F
Specific Gravity	1.09	1.24
Storage Temperature	40°F – 90°F	40°F – 90°F

### Mix Ratio, 115 Index

By weight.....100 parts poly : 100 parts iso

### Typical Properties of Mixed System at 72°F, 109 Index

	Regular	Slow
Cream Time	58 seconds	105 seconds
Gel Time	180 seconds	265 seconds
Tack Free Time	275seconds	388 seconds
Rise Time	325 seconds	465 seconds
Free Rise Core Density	8 pcf	

### Process Parameters

Iso Temperature	75°F to 85°F
Poly Temperature	70°F to 95°F
Mold Temperature	95°F to 125°F

\* De-mold time is dependent on shot size, and material and mold temperatures. NCFI recommends using a high-quality, properly applied wax or silicone release agent to prevent cured material from sticking to mold surfaces.

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## Storage and Handling

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Store the poly from 65°F to 85°F. Avoid moisture contamination during storage, handling, and processing. For both components, pad containers and day tanks with either nitrogen or dry air (desiccant cartridge or air dryer @ -40°F dew point). For optimum shelf life, the recommended storage temperature for iso is 64°F to 86°F. **Do not expose iso to lower temperatures – freezing may occur.** Shelf life is 6 months for factory sealed containers.

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Modified: 051716  
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