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TECHNICAL DATA SHEET

20-038
Rigid Foam Molding System

Technical Data Sheet

NCFI 20-038 is a two-component, HFO-1336mzz blown, all PMDI based rigid pour foam ideal for taxidermy applications.

Typical Properties of Components

Description	Poly	Iso
Component	B-20-038	A2-002
Appearance	Transparent amber liquid	Transparent brown liquid
Brookfield Viscosity @ 50 rpm	327 cps at 72°F	200 cps at 72°F
Specific Gravity	1.11	1.24
Storage Temperature	40ºF – 85ºF	40ºF – 90ºF
Shelf Life	6 months	24 months

Mix Ratio, 114 Index

By weight……..100 parts poly : 111.7 parts iso
By volume…….100 parts poly : 100 parts iso

Typical Properties of Mixed System at 72ºF, 114 Index

Cream Time (sec)	25
Gel Time (sec)	117
Tack Free Time (sec)	168
Rise Time (sec)	208
Free Rise Core Density (pcf)	3.00

Process Parameters

Iso Temperature	75ºF to 85ºF
Poly Temperature	70ºF to 95ºF
Mold Temperature	95ºF to 125ºF

Storage and Handling

For both components, avoid moisture contamination during storage, handling and processing. Pad containers and day tanks with either nitrogen or dry air (desiccant cartridge or –40°F dew point dry air). Follow recommended storage temperature requirements as indicated above. **Failure to follow temperature requirements can result in irreparable damage to the iso component.**

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