

## IsoPour 20C45

IsoPour 20C45 is a slow reacting two component rigid polyurethane foam that exhibits low viscosity and exotherm. Due to its slow initiation it is suitable for mixing by either hand or machine. It has very good flow and cavity filling due to its speed and expansion of approximately 32 times its liquid volume. It is suitable for void fill, flotation, cavity insulation, or wherever a low density rigid foam is needed.

\*Values given are not intended to be used in specific preparation

### Component Properties

Color - ISO	Dark Brown
Color - POL	Amber , Light Brown
Specific Gravity - 74°F, ISO	1.22 - 1.25
Specific Gravity - 74°F, POL	1.085 - 1.105
Viscosity - ASTM D-2196 - 74°F, ISO	200 - 400 cps
Viscosity - ASTM D-2196 - 74°F, POL	700 - 1000 cps

### Reactivity Profile

Ratio by Weight - ISO:POL	1.1:1
Ratio by Volume - ISO:POL	1:1
Cream Time	35 - 45 Seconds
Gel Time	165 - 195 Seconds
Rise Time	230 - 270 Seconds
Tack Free Time	245 - 300 Seconds

### Typical Physical Properties

Closed Cell Content - ASTM D6226	90 %
Compressive Strength - ASTM D695 - Parallel to Rise	37 psi
Compressive Strength - ASTM D695 - Perpendicular to Rise	22 psi
Free Rise Density	1.9 - 2.1 pcf
K Factor, initial per inch - ASTM C518	0.14
Dimen. Stability - ASTM D2126 - 7 Day (158°F)	1.54 %
Dimen. Stability - ASTM D2126 - 7 Day (-20°F)	1.30 - 1.54 %

### RECOMMENDED HANDLING INSTRUCTIONS

Isotec<sup>®</sup> International's Recommended Application and Handling Instructions

- Use only in well-ventilated areas.
- Wear chemically resistant rubber gloves, safety glasses, and an apron.
- Avoid prolonged or repeated contact with skin.
- In case of skin contact, wipe affected area with isopropyl alcohol, followed by soap and water.
- In case of eye contact, flush eyes with water for 15 minutes and consult a physician.
- If swallowed or comes into contact with eyes, seek medical attention immediately.

THOROUGHLY MIX THE "POL" SIDE PRIOR TO USE

This ensures the material is homogenous and parts made will have the correct density and physical properties.

**TYPICAL APPLICATIONS-** Isotec®'s IsoPour products can be used as casting material for customized shapes that need to be lightweight and decorative. The IsoPour products are also used as a filling material to add structural strength to hollow castings such as taxidermy or archery targets. Isotec®'s IsoPour products can also be used for industrial design, special effect applications and other various art/craft applications.

**Measuring and Mixing -** Liquid urethanes are moisture sensitive and will absorb atmospheric moisture. Mixing tools and containers should be clean and made of metal, glass or plastic. Materials should be stored and used in a warm environment (~72°F) to achieve optimal results.

Know the mix ratio and initiation time for the IsoPour products you are using. This information is located in the Reaction Profile section of the Technical Data Sheet. Isotec®'s IsoPour products can be mixed with a jiffy mixer. After dispensing the correct amounts of POL and ISO into the mixing container, mix thoroughly for 10-20 seconds. Stir quickly making sure that you scrape the sides and bottom of the mixing container several times; be careful not to splash low viscosity material out of the container. Remember, foams cure quickly. Do not delay between mixing and pouring.

**Pouring & Curing -** For best results, pour your mixture in a single spot at the lowest point of the mold containment field and let the mixture seek its level. Allow space in the containment field for the foam to grow as it expands to its ultimate volume. Allow foam to cure for at least 30 minutes before handling.

**Improving Surface Finish & Minimizing Voids With Back Pressure -** Use a board that will completely cover the mold opening. Using a 3/4" (2 cm) drill bit, drill 3 holes in the board spaced a few inches/cm apart. Make sure that, when the board is placed over the mold opening, the holes are over the mold cavity and rising foam will be able to make it through. Apply IsoKote S5 mold release thoroughly to both sides of the board and into the drilled holes. Mix and pour IsoPour into mold cavity and place board over mold opening. Secure board firmly in place (mold straps may be necessary). As foam rises in the mold cavity, some foam will grow out of the drilled holes. After the foam stops growing, you can let go of the board. Do not handle for at least 30 minutes. You can then cut excess material that came through holes and gently remove board and casting.

Fully Cured Foam can be sanded, machined, drilled, etc. (wear NIOSH approved respirator). Foam can also be primed and/or painted.

## **STORAGE**

Keep the ISO and POL containers tightly closed when not in use and store at temperatures between 55 - 115° F (12.7 - 46° C). Exposing the POL container to temperature conditions above those recommended, will cause the containers to distend.

Do not expose the ISO or POL to moisture. If moisture contaminates either product, it will not cure correctly or may have reduced density and physical properties. If these storage requirements are met, this foam carries a shelf life warranty of six months, from the date of receipt.

## **SAFETY**

-Refer to the product SDS for all relevant safety information.

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Since Seller exercises no control over Buyers application or use of the product manufactured by Seller ("product") and since materials used with the product may vary, it is understood that:

- THERE ARE NO WARRANTIES, EXPRESS OR IMPLIED, INCLUDING ANY WARRANTIES OR MERCHANTABILITY OR FOR ANY PARTICULAR PURPOSE. While all data presented in Seller's technical data sheet is based on the best information available to Seller and believed correct, such data is not to be construed as a warranty that the product will conform to such specifications. Such technical data sheets are subject to change without notice. Reported laboratory test results of fire redundancy in no way relates to the actual performance under fire conditions. Since all urethane systems are organic, they will burn.
- Reported laboratory test results of the color stability in no way relates to the actual performance upon exposure to light sources. Since all aromatic urethanes experience color degradation upon ultraviolet light exposure, Seller shall not be liable for any damages resulting from ultraviolet light color degradation of any aromatic urethane systems manufactured or sold by Seller.
- The liability of the Seller shall not exceed the purchase price and the Buyer shall not be entitled to nor the Seller be liable for any consequential, incidental, indirect or special damages resulting in any manner from the furnishing of the product.

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