



## 2 Lb. Polyurethane Mix and Pour Foam

Part # - 24/25

For Floatation, Sculpting, and Cavity Filling

Our #24/25 is a two-part, equal mix, self-rising, 2lb/ cu. ft. density closed-cell foam system. Foaming begins within 45 seconds after the two liquids are mixed and continues for several more minutes. The foam expands approximately 30 times its liquid volume before curing, and will fill any shape cavity. It does not react with oil or gasoline and it will not absorb water. #24/25 is ideal for floatation applications and provides 60 pounds of floatation per cubic foot of foam. Unlike polyester foams, polyurethane foam is compatible with both polyester and epoxy resins. This foam is designed to meet USCG Title 33, Chapter 1, Part 183.

Properties of “#25” SIDE	
Appearance	Dark brown liquid
Odor	Slight Amine
Density, @ 77° F	10.2 lbs / gal
Viscosity, @ 77° F	200 cps
Flash Point	>400° F
Vapor Pressure, at 20° C	0.00016 mm Hg

Properties of “#24” SIDE	
Appearance	Amber liquid
Odor	Amine
Density, @ 55° F	9.1 lbs / gal
Viscosity, @ 73° F	450 cps
Flash Point, ASTM 3278-89	>200° F
HFC-245fa, % Resin	7.6 %

Application	
Mix Ratio: Parts by Weight	89 “#24” Side / 100 “#25” Side

Foam Reactivity & Density	Hand mix	High-Pressure
Jiffy Mixer RPM	1720	--
Component Pressures, “#24” Side / “#25” Side	--	1500 psi / 1500 psi
Component Temps, “#24” Side / “#25” Side	55° F / 70° F	70° F / 70° F
Mix time, seconds	20	--
Cream time, seconds	34	10
Gel time, seconds	180	55
Tack Free time, seconds	220	120
Free Rise Density, #10 Cup, lb/ft <sup>3</sup>	2.0	2.0

Typical Physical Properties		ASTM
Molded Panel		
Core Density, pcf	3.0	D-1622
Compressive Strength, psi	34	D-1621
Perpendicular: Compressive Strength @10% deflection, psi	28	D-1621
Compressive Modulus, psi	669	D-1621
Tensile Strength, psi	52	D-1623
Moisture Vapor Transmission	11	D-1623
Water absorption, lbs./sq ft	0.06	D-2842
Closed Cells, %	94	NCFI TM-300
K Factor, BTU-IN / HR-FT <sup>2</sup> -°F Aged	0.21	C-518
UL® 94 Flame Class (File E112987)	HBF	

Dimensional Stability, % Volume Change		ASTM
158° F/ 100% RH 28 Days	-1.0	D-2126
200° F 28 Days	-1.0	D-2126
-20° F 28 Days	-0.5	D-2126

**Certification:****U.S. Coast Guard: (CGD 75- 168) Flotation Material**

Rigid polyurethane samples prepared from this foam have been tested at an independent laboratory. Molded samples have passed the U.S. Coast Guard immersion test (CGD 75-168), and meet or exceed performance criteria set out in D.O.T. – Coast Guard – Flotation Materials, Par. 183.144, Federal Regulations Volume 43, No. 233, 1/5/2005

**U.S. Coast Guard: (CITE: 33CFG183.516) Encase Fuel Tanks.**

Rigid polyurethane foam samples have been tested by an independent laboratory. Molded samples have passed the ASTM D-471 and Military specification MIL P-21929B sections of 33CFG183.516. 12/23/2005.