

# 25

## 2 lb. Polyurethane Mix and Pour Foam

### For Floatation, Sculpting, and Cavity Filling



Our #25/326 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. #25/326 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” A SIDE	
Appearance	Brown liquid
Brookfield Viscosity, @ 20 rpm	200 cps at 72°F
Specific Gravity	1.24
Storage Temperature	40°F - 90°F

Properties of “#326” B SIDE	
Appearance	Brown liquid
Brookfield Viscosity, @ 20 rpm	450 cps at 72°F
Specific Gravity	1.13
Storage Temperature	40°F - 90°F

Application	
Mix Ratio: Parts by Weight	100 parts poly “#326” side / 112 parts iso “#25” side
Mix Ratio: Parts by Volume	100 parts poly “#326” side / 110 parts iso “#25” side

Typical Properties of Mixed System at 72°F	Regular	Fast
Cream Time	45 seconds	18 seconds
Gel Time	230 seconds	120 seconds
Track Free Time	360 seconds	180 seconds
Rise Time	400 seconds	220 seconds
Free Rise Core Density	2.2 pcf	2.2 pcf

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**Other Properties:**

- Meets Title 46 CFR 179.240 for flotation foam
- Meets USCG Title 33, Chapter 1, Part 183

**Storage and Handling:**

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.

Typical Physical Properties	ASTM
Overall Molded Density	3.2 pcf
Compressive Strength	24.5 psi
Initial k-factor	0.167
Moisture Vapor Transmission	2-3 perm inch
Closed Cell Content	90%
Water Absorption	0.044 lb/ft <sup>2</sup>
Flammability	Pass Pass Pass
Resistance to Solvents	Excellent
Resistance to Mold & Mildew	Excellent
Maximum Service Temperature	200°F

\*The above values are average values obtained from laboratory experiments and should serve only as guide lines.