



**NCFI Polyurethanes**

**Div. of Barnhardt Manufacturing Co.**

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## 22-047 High Density Rigid Foam System

### Technical Data Sheet

NCFI 22-047 is a two-component, water-blown, all PMDI based high density pour foam ideal for molding applications.

### Typical Properties of Components

Component	R-22-047	A-22-047
Appearance	Amber liquid	Transparent brown liquid
Brookfield Viscosity @ 50 rpm	2500 cps at 72°F	200 cps at 72°F
Specific Gravity	1.07	1.24
Storage Temperature	40°F – 90°F	40°F – 90°F

### Mix Ratio, 97 Index

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

### Typical Properties of Mixed System at 72°F, 97 Index

Cream Time	27-33 seconds
Rise Time	160-175 seconds
Free Rise Core Density	3.8-4.2 pcf

### Process Parameters

Iso Temperature	75°F to 85°F
Poly Temperature	70°F to 95°F
Mold Temperature	100°F to 125°F

### Storage and Handling

Mix poly component to a homogenous state prior to use. Avoid entraining air during mixing. 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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