



TC-265 A/B

FLEXIBLE POUR-IN-PLACE FOAM

WATER BLOWN

PRODUCT DESCRIPTION:

TC-265 A/B is a two-component water blown flexible polyurethane foam system specifically developed for low-density molding. Nominal density of the finished product is in the range of 2.5 - 3.5 pounds per cubic foot, when open blown or not restricted. Higher densities may be obtained in closed or restricted molds. This material is frequently used to mold behind flexible skin materials such as SkinFlex III, FastFlex, or other BJB elastomers.

HANDLING PROPERTIES:

Mix Ratio (by weight):

Part A 50 parts by weight

Part B 100 parts by weight

Specific Gravity:

Part A 1.19

Part B 1.05

Density Range (lb/ft³)..... 2.5 - 3.5

Viscosity (cps) @ 77°F (25°C) Brookfield:

Part A 205

Part B 550

Cream Time @ 75° F (24°C)..... 20 - 30 seconds

Rise Time 2.5 - 3.5 minutes

Cure Time 75°F (24°C)..... 15 - 30 minutes depending on part size and cross section

➤ The density and processing times listed are derived from a statistical average of long-term testing. We recommend a test mix be performed before use.

MIXING:

Mixing is best with a high speed drill or air motor with a Jiffy Mixer. The blade shears the material and provides a thorough mix within the 5 to 8 second periods generally established for achieving a uniform blend. The material should have a uniform blended appearance. Mixing too long or not enough can result in poor material performance.

Once mixed, the material should be *immediately* poured. If too much time goes by, the foam will rise in the mix container and the batch may be lost.

When pouring the foam, avoid trying to scrape any material from the container sidewalls or bottom. Generally, there isn't enough time to do this and more importantly there may be material that is not well mixed on the container sides.

MOLD PREPARATIONS:

The mold should be well sealed and released. Foams will seek moisture through release waxes and stick to mold surfaces if an insufficient seal exists. Sealing can be accomplished by using lacquer or other similar sealers. The mold should be warmed to between 75°- 85°F (24°-29°C) prior to casting the first part. Once a mold is heated and cycled it will maintain heat for continued production.

MOLD PREPARATIONS (continued):

Release systems vary in accordance to the type of mold used, however, as a general product we recommend Challenge 90 Release or Meguiar's #87 paste wax from our line of products. As a rule, silicone based releases do not work with either the flexible or rigid foam groups of materials. The silicone migrates and often causes poor surface conditions. Silicone will also inhibit the adhesion of paints and over-coatings.

The best molds for production (rather than prototype or limited production parts) are either machined aluminum molds or epoxy molds. Epoxy molds offer the least expensive method for long term use when cycle times allow slower heat dissipation.

DEMOLDING FOAM MATERIALS:

TC-265 A/B can be removed from the mold within a 15-20 minute timeframe. However, smaller masses will develop lower exothermic reaction and may require a slightly longer cure time.

It is recommended that foam parts be crushed or squeezed after demolding to remove residual gases remaining in the cell structure. This will help to reduce post shrinkage and aid in reducing natural odors from the foam part.

STORAGE:

Shelf life is 6 months from date of shipment in sealed containers. Store both resin and hardener in an area where the temperature is between 70°-90°F (21°-32°C). Containers should be stored on pallets to prevent cold flooring from lowering material temperatures.

When first using the material, a sample should be visually inspected to be sure no crystallization is present. Crystallization of either the resin or hardener can occur during shipment in cold weather. If the resin appears cloudy or the hardener becomes gummy, the component should be warmed with the containers open and stirred until the material returns to its proper smooth liquid consistency.

NOTE:

The B component should be gently shaken or stirred to re-blend prior to mixing with part A.

PACKAGING:

Gallon kits..... 4 lbs. A, 8 lbs. B
5 Gallon kits..... 20 lbs. A, 40 lbs. B
55 Gallon kits..... 235 lbs. A, 470 lbs. B

SAFETY PRECAUTIONS:

Use in a well-ventilated area. Avoid contact with skin using protective gloves and protective clothing. Repeated or prolonged contact on the skin may cause an allergic reaction. Eye protection is extremely important. Always use approved safety glasses or goggles when handling this product.

IF CONTACT OCCURS:

Skin: Immediately wash with soap and water. Remove contaminated clothing and launder before reuse. It is *not* recommended to remove resin from skin with solvents. Solvents only increase contact and dry skin. Seek qualified medical attention if allergic reactions occur.

Eyes: Immediately flush with water for at least 15 minutes. Call a physician.

Ingestion: If swallowed, call a physician immediately. Remove stomach contents by gastric suction or induce vomiting only as directed by medical personnel. Never give anything by mouth to an unconscious person.

Refer to the Material Safety Data Sheet before using this product.

NON-WARRANTY "Except for a warranty that materials substantially comply with the data presented in Manufacturer's latest bulletin describing the product (the basis for this substantial compliance is to be determined by the standard quality control tests generally performed by Manufacturer), all materials are sold "AS IS" and without any warranty express or implied as to merchantability, fitness for a particular purpose, patent, trademark or copyright infringement, or as to any other matter. In no event shall Manufacturer's liability for damages exceed Manufacturer's sale price of the particular quantity with respect to which damages are claimed."