



# Technical Data Sheet

**NCFI Polyurethanes**  
 Div. of Barnhardt Manufacturing Co.  
 PO Box 1528 • Mount Airy, NC 27030  
 800-346-8229      www.NCFI.com

## NCFI HIGH DENSITY MOLDING SYSTEM 22-024

### DESCRIPTION:

NCFI 22-024 is a two component, water-blown, all PMDI based high-density polyurethane molding system. NCFI 22-024 has been formulated to produce a free rise core density of 5.6 pcf. This product is ideally suited to mold parts such as decorative furniture pieces, mirror and picture frames, as well as decorative and architectural millwork pieces. Products made from this system would have target overall densities of 12 - 15 pcf.

### DISTINGUISHING CHARACTERISTICS:

- Excellent Flow and Wet Out
- Good Flexibility at Demold
- Excellent Flexural Strength
- Good Dimensional Stability
- Rapid Demold Times

### TYPICAL RESIN PROPERTIES:

	<u>22-024 R</u>	<u>22-024 A</u>
Viscosity	1850 cps	200 cps
Lbs./Gallon	9.0 lbs.	10.2 lbs.
Appearance	transparent, amber liquid	transparent, brown liquid
Shelf Life	6 months	6 months

### MIX RATIO:

	<u>22-024 R</u>	<u>22-024 A</u>
By Weight	100 parts	100 parts

### TYPICAL REACTION PROPERTIES:

Hand Mix @ 72°F

Cream Time, seconds	50
Gel Time, seconds	120
Tack Free Time, seconds	160
Rise Time, seconds	190
Demold Time, minutes	8 - 15
Density (FRC)	5.6 pcf

### TYPICAL PHYSICAL PROPERTIES:

Core Density	15 pcf
ASTM D1622	
Compressive Strength	400 psi
ASTM D1621	
Flexural Strength	500 psi
ASTM D790	
Water Absorption	≤0.06 lbs/ft <sup>2</sup>
ASTM D2842	
Resistance to Solvents	Excellent
Resistance to Mold and Mildew	Excellent
Maximum Service Temperature	200°F

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

## NCFI 22-024 APPLICATION INFORMATION

### EQUIPMENT AND COMPONENT RATIOS:

NCFI 22-024 can be mixed by hand or pour machines designed to mix urethane chemicals. This system is best suited to process equipment with mechanical mix heads. For optimum processing NCFI 22-024 **R** should be maintained between 75-95°F and NCFI 22-024 **A** should be held at 70°F. NCFI 22-024 **R** is connected to the **resin/polyol** pumps with NCFI 22-024 **A** being connected to the **isocyanate** pumps.

### MOLDING RECOMMENDATION:

To obtain optimum yield, consistent part quality and quick demold times, the mold temperature must be 80°F or higher. Recommended temperature is 100°F. Heating molds with radiant or convection heat sources should be accomplished without producing 'hot spots'. Molds may be constructed of fiberglass, aluminum, epoxy or other thermal conductive material. Mold surfaces must be coated with a suitable release agent and dried before molding. Follow the recommendations of the mold release supplier. The mold design should offer adequate clamping pressure and allow trapped air to escape through vent holes in the top or the parting lines of the mold.

### STORAGE AND USE OF CHEMICALS:

Keep temperature of chemicals at 80°F for several days before use. Cold chemicals can cause poor mixing, pump cavitation or other process problems due to higher viscosity at lower temperatures. Storage temperature should not exceed 100°F. Prolonged exposure to temperatures below 60°F can cause the 'A' component to freeze. Do not store in direct sunlight. Keep drums tightly closed when not in use and under nitrogen pressure of 2 - 3 psi after they have been opened.

### SAFE HANDLING OF LIQUID COMPONENTS:

Use caution in removing bungs from the container. Loosen the small bung first and let any built up gas escape before completely removing. Avoid prolonged breathing of vapors. In case of chemical contact with eyes, flush with water for at least 15 minutes and get medical attention. For further information refer to "MDI-Based Polyurethane Foam Systems: Guidelines for Safe Handling and Disposal" publication AX-119 published by Alliance for the Polyurethanes Industry 1300 Wilson Blvd, Suite 800, Arlington, VA 22209.

### Caution:

Polyurethane products manufactured or produced from this liquid system may present a serious fire hazard if improperly used or allowed to remain exposed or unprotected. The character and magnitude of any such hazard will depend on a broad range of factors which are controlled and influenced by the manufacturing and production process, by the mode of application or installation and by the function and usage of the particular product. ***Any flammability rating contained in this literature is not intended to reflect hazards presented by this or any other material under actual fire conditions. These ratings are used solely to measure and describe the product's response to heat and flame under controlled laboratory conditions.*** Each person, firm or corporation engaged in the manufacture, production, application, installation or use of any polyurethane product should carefully determine whether there is a potential fire hazard associated with such product in a specific usage, and utilize all appropriate precautionary and safety measures

The information on our data sheets is to assist customers in determining whether our products are suitable for their applications. The customers must satisfy themselves as to the suitability for specific cases. NCFI Polyurethanes warrants only that the material shall meet its specifications; this warranty is in lieu of all other written or unwritten, expressed or implied warranties and NCFI Polyurethanes expressly disclaims any warranty of merchantability, fitness for a particular purpose, or freedom from patent infringement. Accordingly, buyer assumes all risks whatsoever as to the use of the material. Buyer's exclusive remedy as to any breach of warranty, negligence or other claim shall be limited to the purchase price of the material. Failure to adhere strictly to any recommended procedures shall relieve NCFI Polyurethanes of all liability with respect to the material or the use thereof.