

TRIPOR 227

'Tripor 227' is a low density, rigid foam system which may be used to manufacture mouldings. It is also suitable for structural infill of fibreglass components, and relies on the thorough mixing of two low viscosity liquids by either hand or machine mix techniques.

'Tripor 227' contains no CFC's or HCFC's giving an Ozone Depletion Potential (O.D.P.) of zero, and uses blowing agents with a low GWP (Global Warming Potential) giving an overall figure of < 5 where Carbon Dioxide is given as 1.

FOAM MANUFACTURE

The foam is produced by the mixing together of the two Components A and B at a ratio of 1 to 1.06 by volume, or preferably 1 to 1.2 by weight. It is vitally important that quantities are accurately measured before mixing thoroughly. In hand mixing the Component A should be pre-mixed for at least one minute to aerate it, before mixing with the Component B. After mixing the foam should be immediately transferred to the mould or cavity to be filled, pouring should be finished before there is any significant amount of expansion. Best results are obtained if the foam rise is restricted, but it may be free-risen if necessary.

The foam should be processed between the temperatures of 18 - 23°C, temperatures lower than 18 °C will give unsatisfactory results, it is recommended that the components are kept in a warm environment for several hours before use. Lower temperatures will give a slower reaction, higher temperatures faster. Reaction times will also be affected by the bulk mixed, larger amounts will give shorter times, small amounts longer times. Best results are given if the surfaces in contact with the rising foam are at a temperature of at least 25°C.

The following times are typical for a Quality Control procedure for the checking of cream, string and rise times, and measurement of the free rise density. The test should be conducted at a temperature of 20°C, using 31.8 grams of Component A and 38.2 grams of Component B mixed together in a cup of approximately 660ml. volume, stirred intensively for 10 seconds using a bench stirrer rotating at 2000 rpm. Immediately after mixing, the chemicals are transferred to a second 660ml cup.

Cream Time	25-35 seconds	(from start of mixing to start of rise)
String Time	150-170 seconds	(from start of mixing to when a thread can be drawn from rising foam with an inserted rod)
Rise Time	180-230 seconds	(from start of mixing to end of rise)
Tack Free Time	300-360 seconds	(from start of mixing till surface can be lightly touched without foam sticking)
Density (Free rise)	48 - 50 kg/M ³	(weight of cups contents divided by volume of cup)
Core Density	41 - 43 kg/M ³	(density of piece cut from foam core)
Ratio	1:1.2	(by weight)

STORAGE & HANDLING

It is extremely important that the containers should be re-sealed immediately after use to prevent the entry of moisture which will adversely affect the resultant foam. The shelf life of the materials is four months when stored in sealed drums within the recommended temperature range of 10 - 30°C, but users are recommended not to hold in stock longer than necessary.

PLEASE SEE THE SEPARATE SAFETY DATA SHEETS BEFORE USING THESE PRODUCTS.

The data contained in this sheet is to our knowledge true and accurate but recommendations are made without guarantee or warranty since application and conditions are outside our control. It is suggested that users should carry out their own tests to ensure 'Tripor' meets their requirements.

BKB House, Goyt Valley Industrial Estate, off Station Road, Furness Vale, High Peak, SK23 7SN.

Tel 44 (0) 1663 740120 Fax 44 (0) 1663 740121

Registered in England No.2026997 Directors: C.P.Kenyon MD, C.F.Kenyon

AU TOFROTH® is a registered trademark of the BASF Corporation (USA).