

TRIDENT FOAMS LIMITED



✕TRIPOR ✕TRICAST ✕TANCAST ✕AUTOFROTH ✕AUTOPOR ✕MHD

TRIPOR 229

'Tripor 229' 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 229' contains no CFC's or HCFC's and therefore has an Ozone Depletion Potential (O.D.P.) of zero.

FOAM MANUFACTURE

The foam is produced by the mixing together of the two Components A and B at a ratio of 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 - 23⁰C, 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 25⁰C.

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 20⁰C, using 32 grams of Component A and 38.4 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	15-20 seconds	(from start of mixing to start of rise)
String Time	95-115 seconds	(from start of mixing to when a thread can be drawn from rising foam with an inserted rod)
Rise Time	160-200 seconds	(from start of mixing to end of rise)
Tack Free Time	240-300 seconds	(from start of mixing till surface can be lightly touched without foam sticking)
Density (Free rise)	47-50 kg/M ³	(weight of cups contents divided by volume of cup)
Core Density (Free	42- 44 kg/M ³	(density of piece cut from foam core)

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

rise)		
Suggested Minimum Core Density	50 kg/M ³	(density of foam core section of moulding, will need to be denser in narrow sections < 50mm)
Ratio	1:1.2	(by weight)

The following results are from a test panel manufactured under laboratory conditions,

<u>Property</u>	<u>Result</u>	<u>Test Method</u>
Actual Core Density	50 kg/M ³	BS 4370 Pt.1 1988 Method 2
Compressive Strength (parallel to rise)	– 290 kPa	BS 4370 Pt. 1 1988 Method 3
Compressive Strength (perpendicular to rise)	– 215 kPa	BS 4370 Pt. 1 1988 Method 3
Closed Cell	>95%	BS 4370 Pt. 2 1973 Method 10
Initial K Factor @ 10°C	0.03 W/M ^{°K}	BS 4370 Pt.2 1993 Method 7

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 MATERIAL 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.