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TECHNICAL DATA

Erathane TX56

RIGID POLYURETHANE FOAM

Erathane TX56 foam has been specially designed for taxidermy and black boy moulding type applications. Erathane TX56 is a two-part polyurethane system comprising of a polyol and isocyanate component. When mixed at the correct ratio, produces foam with a free rise density of 56 kg/m³.

COMPONENT PROPERTIES

	Polyol	Isocyanate
Appearance	Clear, honey coloured liquid	Brown liquid
Brookfield Viscosity (cps)	300	250
Specific Gravity	1.15	1.22

REACTION PROFILE

Laboratory results based on hand-mix @ 20°C

Mix ratio by weight (Polyol: Iso)	100:100
Mix time (seconds)	20
Cream time (seconds)	120
Gel time (seconds)	270
Tack free time (seconds)	420
Free rise density (kg/m³)	56

MIXING PROCEDURES

There are a number of ways to successfully produce foam. It is greatly dependant on the type of mould and desired finish. A method will be explained below which highlights the difference in finish and mould cost.

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RIGID MOULD METHOD

This technique utilizes simple and low cost mould production. It is limited to relatively simple shapes.

MOULD MATERIAL

Can be produced from most workable products including wood, aluminum, steel and plaster. Porous materials such as wood and plaster must be sealed with adequate coats of appropriate sealant.

MOULD PRODUCTION

- Typically a cavity is formed up or machined from the mould material.
- Moulds are usually two-part (base and lid joined with hinges). This type of suit case mould will allow the mixed material to be poured around the cavity quickly and easily. It also allows the lid to be secured quickly and safely.
- The product is a rigid foam and is **only** easily removed from a rigid mould if the cavity has a slight taper.
- Breather holes (1-2 mm) should be placed strategically around the mould to allow air to escape during the foaming process.

METHOD

1. Coat the mould with Eralease brand release agent.
2. Weigh out Polyol into a clean dry container.
3. Into the same container, add the correct amount of Iso.
4. Drill stir (2,500 - 2,800 rpm) for approximately 20 seconds.
5. Pour mixed material around the mould cavity.
6. Close lid and clamp shut.
7. Open mould after 10-15 minutes and de-mould carefully.
8. Wipe release agent off foam thoroughly with compatible solvent before painting.

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