

## PC-3200 Integral Skin Foam

Flexible Urethane System with 120% Rise

## Technical Bulletin

Rev. Date: 6/12/2014

PC-3200 is a two-component, flexible, urethane base integral skin foam. This system has been developed to replace plastisol, due to its lower cost per part, reduced weight and higher productivity.

### Key Features

- Quick Gelling.
- Excellent Adhesion to Various Substrates.
- Excellent Dimensional Stability.
- Excellent Retention of Toughness at Elevated Temperatures.
- TDI-free and Mercury-free, 100% Water-Blown

### Typical Uncured Properties

Color		
PC-3200 Resin (Polyol Component)		Black
PC-3200 Hardener (Isocyanate Component)		Dark Amber
PC-3200 Mixed		Black
Viscosity (Brookfield) @ 25°C ± 1°C (77°F ± 2°F); cPs		
PC-3200 Resin		550
PC-3200 Hardener		200
Density @ 25°C ± 1°C (77°F ± 2°F); Lbs./Gal. (g/cm <sup>3</sup> )		
PC-3200 Resin		8.52 (1.02)
PC-3200 Hardener		10.30 (1.23)

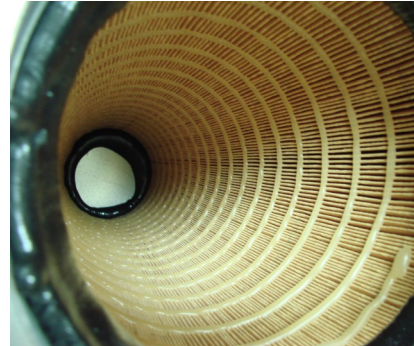
### Mixing Specifications & Characteristics

Mix Ratio		
Parts by Weight		100 parts Resin : 39 parts Hardener
Parts by Volume		3 parts Resin : 1 part Hardener
Processing Times @ 25°C ± 1°C (77°F ± 2°F); min:sec		
Crème Time		0:15–0:25
Rise Time		1:00–1:05
Gel Time (139 gram mass; 250 mL beaker)		2:00
Full Cure		7 Days
Percent Rise @ 25°C ± 1°C (77°F ± 2°F); %		100–120

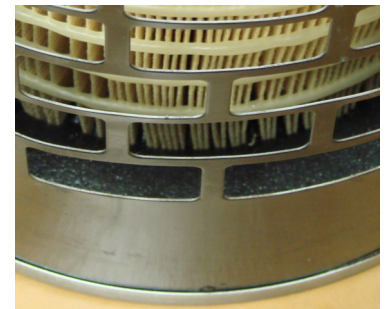
### Typical Cured Properties

Color		Black
Hardness; Shore 00		65–75
Hardness; Shore A		30–35
Free Rise Density; Lbs./ft <sup>3</sup>		35

**Limited Warranty:** Polyset Company Inc. makes no warranty, expressed or implied, including any warranty of merchantability of fitness for a particular purpose. The sole remedy of Purchaser for any claim concerning this product, including, but not limited to, claims alleging breach of warranty, negligence, strict liability or otherwise, is the replacement of product or refund of the purchase price, at the discretion of Polyset Company Inc. Any claims concerning this product shall be submitted in writing within one year of the delivery date of this product to Purchaser and any claims not presented within that period are waived by Purchaser. IN NO EVENT SHALL POLYSET COMPANY INC. BE LIABLE FOR ANY SPECIAL, INCIDENTAL, CONSEQUENTIAL (INCLUDES LOSS OF PROFITS) OR PUNITIVE DAMAGES.



PC-3200 Integral Skin Foam in a Truck Filter Application



Cutaway View of PC-3200 in a Filtration Application

### Processing Instructions

For good results, automatic mixing and dispensing equipment should be used. Please consult with Polyset technical staff before making final processing decisions.

### Storage Information

Keep away from flames. Material should be used once container is opened. Long term storage of opened material should be under nitrogen. Shelf life of both PC-3200 Resin and PC-3200 Hardener is 6 months @ 25°C (77°F) in unopened containers.

### Safety Information

Avoid direct contact. Use safety goggles or safety glasses with side shields and impervious gloves when handling PC-3200 Resin and PC-3200 Hardener. If skin contact occurs, wash with soap and water. If PC-3200 Resin or PC-3200 Hardener enters the eyes, flush with cool water for at least 15 minutes and call a physician immediately. Refer to product Safety Data Sheets for further information.