

## PC-3205 Integral Skin Foam

Flexible Urethane System with 200% Rise

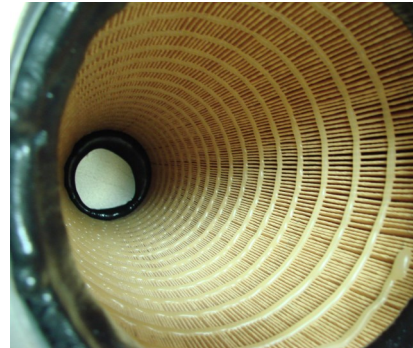
## Technical Bulletin

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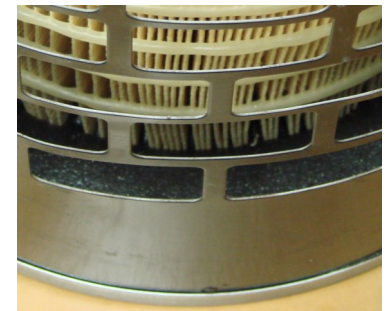
PC-3205 is a two-component, flexible, urethane base integral skin foam. This system has been developed to replace plastisol, due to its lower cost per part, reduced weight and higher productivity.

### Key Features

- Quick Gelling with Fast Green Strength.
- Excellent Adhesion to Various Substrates.
- Excellent Dimensional Stability.
- Excellent Retention of Toughness at Elevated Temperatures.
- TDI-free and Mercury-free, 100% Water-Blown Integral Skin Foam — Environmentally Friendly.



PC-3205 Integral Skin Foam in a Truck Filter Application



Cutaway View of PC-3205 in a Filtration Application

### Typical Uncured Properties

#### Color

PC-3205 Resin (Polyol Component)	Black
PC-3205 Hardener (Isocyanate Component)	Light Yellow
PC-3205 Mixed	Black

#### Viscosity (Brookfield) @ 25°C ± 1°C (77°F ± 2°F); cPs

PC-3205 Resin	1500
PC-3205 Hardener	300

#### Density @ 25°C ± 1°C (77°F ± 2°F); Lbs./Gal. (g/cm<sup>3</sup>)

PC-3205 Resin	8.52 (1.02)
PC-3205 Hardener	10.00 (1.20)

### Mixing Specifications & Characteristics

#### Mix Ratio

Parts by Weight	100 parts Resin : 42 parts Hardener
Parts by Volume	2.8 parts Resin : 1.0 part Hardener

#### Processing Times @ 25°C ± 1°C (77°F ± 2°F); min:sec

Crème Time	0:18–0:20
Rise Time	0:25
Gel Time (142 gram mass; 250 mL beaker)	0:45
Full Cure	7 Days

#### Percent Rise @ 25°C ± 1°C (77°F ± 2°F); %

200

### Typical Cured Properties

Color	Black
Hardness; Shore A	15–20

### 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-3205 Resin and PC-3205 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-3205 Resin and PC-3205 Hardener. If skin contact occurs, wash with soap and water. If PC-3205 Resin or PC-3205 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.

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