

Technical Data Sheet

F-18.02 ORANGE / OEB 21

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1. Product description

F-18.02 ORANGE / OEB 21 is two-component raw material system on polyether base. The system is recommended to air filters gasket in machine manufacturing.

Two-component system	F-18.02 ORANGE Component A	OEB 21 - Component B
State of aggregation	liquid	liquid
Colour	orange	straw-coloured, slightly opalescent
Viscosity at 25°C [mPas]	1200 - 1700	700 - 1000
Density at 20°C [g/cm ³]	1,04 ± 0,03	1,17 ± 0,03
Mixing ratio by weight [g]	100	41 - 43

2. Application method recommended

Component A should be thoroughly mixed before use. Component B can be solid substance in room temperature. This component should be heated in original containers at temperature of 60 – 70°C to complete liquefying before processing. Liquefying time is usually 4 – 6 hours in the case of 50 dm³ containers and 18 – 24 hours in the case of 216 dm³ drum. Because repeated heating can have negative influence on produced plastic properties, the whole of liquefied system processing is recommended. Moulding surfaces should be covered with suitable release agent to enable the profile easy taking out of the mould.

Raw material temperature	[°C]	20 – 25
Mould temperature	[°C]	45 – 55

3. Technological properties of foaming process (cup test, 100g of the system)*

Components A:B ratio	[g]	70,4 : 29,6
Raw materials temperature	[°C]	20
Start time	[s]	38 – 41
Gel time	[s]	75 – 85
End of rise	[s]	140 – 160
Free rise density	[kg/m ³]	310 – 330

4. Physico-mechanical properties of the foam*

Optimum foam density in the product	[kg/m ³]	450 – 500
Hardness	[°ShA]	22 – 28
Tensile strenght [DIN 53504]	[MPa]	> 0,6
Elongation at break [DIN 53504]	[%]	> 120
Compression set [PN-EN ISO 1856]	[70°C, 50%, 22h, %]	< 10

5. Transport and storage

Store in dry, well ventilated room, in tightly closed containers. Protect against moisture access and direct exposure to sunrays. Containers opened before should be tightly closed and stored in position making out-flow impossible. Optimum storage temperature is 15 – 30°C. Permissible temperature during transport is 5°C – 50°C.

*Notes

Data presented in this information have been obtained during the system foaming in model conditions. The results obtained when foaming in other conditions can be slightly different from published.

Every time the user is obliged to check the product and auxiliary agents usefulness for his intentional use.

The user is obligated to have a valid technical data sheet and safety data sheet of the product, which is provided by the manufacturer during the sale and every time on the customer's request.

Prior to processing the user must carefully read aforementioned documentation and follow the rules of procedure for product use.