



Polyurethane Foaming System

Flexible foam, liquid

Key Properties

- Soft – flexible and compressible
- Very fast reactivity, short demold time
- Good flow properties
- Very low weight of foam

Applications

- Foam system for seat upholstery

Processing Properties

			PE-3801 Polyol	PH-3905 Isocyanate	PH-3980 Isocyanate
Color	visual		Yellowish	Light brown	Light brown
Mix ratio		parts by weight	100	37.5	50
		parts by volume	100	30.5	40.5
Density	ISO 1183	g/cm ³	ca. 0.95-1.05	ca. 1.22-1.24	ca. 1.22-1.24
Viscosity at 25 °C	DIN 53019-1	mPa·s	1,200-1,800	150-200	500-700

			PE-3801 / PH-3905	PE-3801 / PH-3980
Cream time at RT	30g	seconds	90-120	45-70
Gel time	30g	min:sec	3:00-3:30	2:00-3:00
Tack-free after	30g	min	10-15	10-15

Cured / Mechanical Properties

Cure: 30 minutes at RT			PE-3801 / PH-3905	PE-3801 / PH-3980
Appearance	visual		Beige	Beige
Specific weight		g/l	ca. 100-110	ca. 80-90
Shore hardness 00	ISO 868		18-22	30-35
Elongation at break	ISO 1798	%	70-75	100-110
Tensile strength	ISO 1798	MPa	0.1-0.15	0.4-0.5



Polyurethane Foaming System

Flexible foam, liquid

Processing

The processing and material temperature should be between 20-25 °C.

The A component needs to be stirred well before use as some fillers might be prone to sedimentation. Due to the short processing time, the system is generally processed using a two component mixing and metering machine. The recommended material temperature **must** be observed. Too high or low a material temperature will change the viscosity (high/low) and have a direct influence on the mixing ratio set up on the machine. Changes in the mixing ratio will result in faults in the finished part.

Packaging

RAKU-TOOL® PE-3801	25 kg
RAKU-TOOL® PH-3905	25 kg
RAKU-TOOL® PH-3980	25 kg

Storage

Original containers should be kept tightly sealed and stored at ambient temperatures (15°C to 30°C). If properly stored the products have the shelf-life indicated on the product label.

Partly used containers should always be sealed appropriately and used up as soon as possible.

Handling Precautions

Good workplace ventilation is to be ensured during processing. At the same time, the employer's liability insurance association's industrial hygiene safety regulations regarding the handling of reaction resins and their hardeners are to be observed. Please take heed of the appropriate safety data sheets.