



Polyurethane Foam Pouring Procedure

Mixing Instructions

Mixing of polyurethane foam is a skilled technical operation deserving of care and attention throughout the entire operation.

It must only be carried out by trained operators fully conversant with the safety aspects to be observed when working with polyurethane foam.

Equipment required:

- High speed electric drill
- Adhesive tape
- Mixing pot
- Stirrer (paint type)
- Polyurethane foam
- Foam mask, gloves and goggles

NOTE: It is recommended that a trial mix is carried out on the first mix of the job, batch of foam, or day.

Use 100ml of each component, measure and mix as below and allow to free rise.

Time the reaction from start of mixing until start of rise. This will give you an indication of how long you have.

When fully risen the foam should have risen out of the container and be standing some 50mm above the lip. If it does not rise this high you may have suspect foam. Break the foam open after 10 minutes and look at its colour, cell size and structure

1. Check components marked A and B.

Key point: Never foam if ambient temperature is outside 10-25°C without referral to your local agent.

2. Clean mixing pot out.

Key points: Ensure mixing pot is scrupulously clean and free from any contaminants.

3. Pour B into mixing pot.

Key points: Use correct amount, see table below. Be accurate. If temperature is over 20°C, cool down the component by running cold water over sides and bottom of component container. Take care not to get water into the components. Store bulk container out of sun in a cool place.

4. Pour A over the B in the mixing pot.

Key points: Use correct amount, see table below. Be accurate. If temperature under 15°C, store bulk container in warm but not hot environment.

5. Mix for 15-20 sees.

Key points: Use high speed electric drill and paint stirrer. In warm weather period available for mixing decreases. In cold weather period available for mixing is increased. Mix thoroughly in an up and down motion and ensure material clinging to sides of mixing pot is collected and mixed in. Mix as close as possible to area of work.

6. Pour foam into joint.

Key points: Ensure all foam goes into joint. Do not pour rising foam. Do not pour foam in the rain.

7. Seal pour hole.

Key points: Use adhesive tape.

8. Observe "mushrooms".

Key points: Foam must extrude through air holes. If it does not strip joint out. Check foam quantities, check foam quality. Re-sheathe and foam joint.

Dos and Don'ts with Polyurethane Foam

DO

- be as accurate as possible when measuring quantities.
- mix well.
- wear goggles and respirators in confined areas.
- keep foam warm (+ 15°C) in winter, and keep foam cool (+ 20°C) in summer.
- be trained.
- know decontamination and first-aid procedures.

DON'T

- use if you have had bronchial or asthmatic problems in the past.
- get foam in your eyes or mouth.
- breathe the vapour in confined areas.
- use dirty or contaminated gear.
- mix and pour in the rain.
- keep foam for longer than 3 months or from job to job.

Foam Quantities

The quantities listed below for each fitting are the total quantities of the A component to the B components is 1:1. Half of the quantity shown is the A component and the other half is the B component. Together they total the quantity required.

The foam quantities listed have been calculated to suit the system.

Pipe/Casing dia	15/100	25/100	32/125	40/125	50/150	65/150	80/175	100/200	125/225	150/225	150/275	200/325	250/375	300/425													
	20/100	32/100	40/100	50/125	65/125	80/150	100/175	125/200	125/250	150/250	200/275	250/325	300/375														
Straight Joint	250g	250	250	250	350	200	350	300	500	300	450	400	500	450	700	500	800	1050	550	850	1200	700	1450	800	1650	900	1900
Tee	400g	400	350	350	550	300	550	500	750	450	700	600	900	700	1100	800	1250	1700	900	1600	1900	1100	2300	1250	2650	1450	300
Bend	400g	400	400	400	550	300	550	450	750	450	700	650	950	800	1250	1000	1500	2000	1200	1800	2600	1800	3600	2400	3600	1950	4250
Cone	100g	100	100	100	100	100	100	100	200	100	200	100	200	200	200	200	300	300	200	300	400	200	500	300	500	300	600