



## EXO - SET

### High Density Spray Foam System

#### Product Description

**EXO-SET** is a zero ODP two component foam system fully formulated to produce a high density rigid spray foam. The system should be processed at a 1:1 volume ratio through suitable spray machinery ( Gusmer, Glas-Craft/Probler etc ) and will produce a closed celled rigid foam of approximately 220kg/m<sup>3</sup> density. When fully cured the foam is extremely strong and durable, and is fire retardant in accordance with BS4735.

#### Uses

**EXO-SET** is used for speciality scenic replication and reinforcement purposes.

**EXO-SET** should be applied under standard conditions of temperature and humidity where possible – approximately 20°C and 50% humidity. The reactivity of the system has been tailored to suit these conditions.

#### Equipment

**EXO-SET** can be processed through all standard foam spray machines. The machine should be capable of maintaining the mix ratio at ±2% accuracy and controlling the component temperatures at 40-60°C (variable).

#### Recommended machine settings

Block Temperature	<i>Minimum, operating</i>	120-140° F / 50-60° C
Hose Temperature	<i>Minimum, operating</i>	120° F / 50° C
Chemical Pressures	<i>Minimum, operating</i>	500 psi, <b>not greater than 200 psi difference iso / res</b>



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#### Spray Techniques

**The guidelines in Isothane Limited's standard specification should be followed but the general requirements are as follows.**

- The foam reaction gives out a large amount of heat.
- Care must be taken to build up the thickness of foam required gradually, to reduce the risk of scorching.
- The substrate should be clean, dry and free of dirt, grease, oil and loose particles.
- In certain cases primer may be necessary to maximise adhesion.
- Factory conditions should be suitable for spraying with regard to humidity and ambient temperature.

#### Physical Properties

The reactivity of **EXO-SET** when tested at the laboratory at 20°C is as follows:

Mix Ratio (by weight) Resin 100 : 114 Iso (EXO –SET [R] : EXO –SET [H])

Mix Ratio (by volume) Resin 100 : 100 Iso (EXO –SET [R] : EXO –SET [H])

Cream time	4-8	seconds
Tack free time	10-15	seconds
Rise time	16-24	seconds
Free rise density	200 – 240	kg/m <sup>3</sup>
SG	1.08 – 1.10	@ 20°C
Viscosity	650 – 850 cps	@ 20°C

#### Fire Safety

Rigid polyurethane foams are organic, combustible materials and may present a fire risk in certain applications if exposed to fire and/or heat. Do not use welding and cutting torches, flame or any other ignition source on or near such exposed foams. The cured foam is fire retardant to BS4735.

#### Storage, Handling and Personal Protection

Please consult our separate Material Safety Data Sheet. The MSDS gives a comprehensive list of all aspects of safe handling.

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## ISOOTHANE EXO - SET High Density Spray Foam System



Specially created  
'Burnt Out' effect  
film set using  
sprayed  
polyurethane  
foam



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