

THEMESPRAY 85

Spray foam system

Product Description

THEMESPRAY 85 is a two component, 1:1 ratio, carbon dioxide blown, rigid foam system which when processed through suitable spray machinery (Gusmer, Glas-Craft/Probler etc) will produce a rigid foam of approximate density 85kg/m³ with exceptionally good compressive strength and a smooth surface.

Uses

THEMESPRAY 85 is used for:

- Speciality scenic replication.

THEMESPRAY 85 should preferably be applied under factory conditions and the reactivity of the system can be tailored to suit the conditions likely to prevail at the time of application. It is essential that the foam is protected from damage during installation, ultra-violet radiation and atmospheric degradation by a suitable elastomeric coating.

Equipment

THEMESPRAY 85 can be processed through all standard foam spray machines. The machine should be capable of maintaining the mix ratio at $\pm 2\%$ 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, not greater than 200 psi difference iso / res

Storage, Handling and Personal Protection

The recommendations in our Safety Data Sheet for this product must be followed at all times.



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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 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 must be suitable for spraying with regard to humidity and ambient temperature.

Physical Properties

THEMESPRAY 85 is a two component, modified polyurethane rigid foam which, sprayed through suitable foam machinery, gives a product of nominal density 80kg/m³.

Laboratory test results (cup tests at 20°C):-

Cream time	4-5	seconds
Tack free time	35-40	seconds
Rise time	48-52	seconds
Free rise density	75-80	kg/m ³
SG	1.09	@ 25°C
Viscosity	1480	cps @ 25°C

Properties of Foam Core

Material sprayed onto a steel substrate at 15°C using GUSMER or GLAS-CRAFT equipment, to give a 65mm total thickness – see table on page 3.

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 sources.

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Typical Properties Of THEMESPRAV 85 Foam Core

		<u>Value</u>	<u>Test Method</u>
Overall density		70-90 kg/m ³	BS4370
Core density		70 kg/m ²	BS4370
Compressive strength	Parallel to rise	500 kpa	BS4370
Tensile strength	Perpendicular to rise	500 kpa	BS4370
Shear strength	Perpendicular to rise	350 kpa	BS4370
Closed Cell Content		90 % min.	ASTM D2856
Thermal Conductivity	10° C Mean- Aged	0.030 W/mK	ASTM C518 (ANACON)
Water Absorption	7 days no head	0.24 kg/m ²	ASTM D2127
Dimensional Stability (Linear Change)	7 days @ -15° C	1 %	BS4370
	7 days @ 80° C	+ 2.0 % vol.	BS4370



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