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Technical Data Sheet
RAKU-PUR® 32-3250-8
soft integral foam, thixotropic

Description

RAKU-PUR® 32-3250-8 is a thixotropic, two-component polyurethane system. It consists of a filled resin component A and a hardener component B (MDI). The system contains no solvents, plasticizers or halogenated hydrocarbons. It is characterized by:

- high sealing performance
- very low foam density
- very low water absorption
- compact, hydrophobic integral skin
- high mechanical strength / tear resistance
- high tensile strength
- very short cure and assembly time
- good value / performance
- good mounting adhesion to metal surfaces
- listed UL 50

Temperature resistance			
	long-term	- 40 °C	to + 100 °C
	short exposure		up to + 160 °C

Application

The product is used for the production of formed-in-place foam gaskets (FIPFG) and of molded foams. The hardness of the material can be adjusted to the specific application by changing the mixing ratio.

Processing

Before use, the component A must be homogenized, as additives tend to cause phase separation. The density of the material can be adjusted to the processing specification of 0.80 - 0.90 g/ml by adding dispersed air through stirring. The air helps to ensure a uniform foam structure. The component B is very sensitive to moisture and must not be stirred. Due to its high reaction rate, the system is usually processed by two-component mixing and dispensing machines.

Raw components data

		RAKU-PUR® 32-3250-8 A	RAKU-PUR® 32-3250-8 B
Viscosity, γ= 2.5 s^{-1}	mPa*s	80,000 - 110,000	-----
Viscosity	mPa*s	-----	250 - 400
Density without air	g/ml	1.00 - 1.10	1.20 - 1.24
Density with recommended air loading	g/ml	0.80 - 0.90	-----
Color		black	brown

measured at 20 °C

Processing data

	Unit	Value	Value	Value
Mixing ratio A : B	Parts by weight	6 : 1	7.5 : 1	8 : 1
Processing temperature	°C	15 - 35	15 - 35	15 - 35
Cream time	sec.	40 - 50	40 - 50	40 - 50
Tack free	minutes	7 - 10	7 - 9	4 - 6
Density, foamed in 30 ml beaker	g/l	220 - 270	280 - 320	290 - 340
Hardness, lab foamed in beaker	Shore 00	65 - 72	40 - 50	40 - 50
Hardness, lab foamed in beaker	Shore A	12 - 17	5 - 10	5 - 10

measured at 20 °C, 30 ml formulation, laboratory stirrer 1800 rpm.

Standard shipping containers

	Component A	Component B
	Contents	Contents
	kg	kg
Container	1000	-----
Drum, removable lid	200	-----
Drum, screw cap	-----	250
Canister, internally coated	30	-----
Can	-----	30

Storage

Original containers may be stored at ambient temperature (10 °C - 35 °C) for 9 months. At temperatures below + 5 °C the hardener component B may crystallize. Since both components are affected by air moisture, containers should be kept tightly sealed.

Health and safety at work

The workplace in which the material is being used must be well ventilated. All applicable health and safety regulations governing the use of reactive resins and their hardeners must be observed. Please also observe the respective safety data sheets.

RAMPF Giessharze GmbH & Co. KG
Robert-Bosch-Str. 8-10 • D-72661 Grafenberg
T +49 (0) 7123 9342-0
F +49 (0) 7123 9342-1255
E info@rampf-giessharze.de
www.rampf-giessharze.de