Polytek Development Corp.

Polytek® Casting Foams

Technical Reference Chart

Series	Product	Mix Ratio	Mix Viscosity (cP)	Cream Time	Rise Time	Tack-Free Time	Demold Time	Free-Rise Density (lb/ft^3)	Molded Density (lb/ft^3)
PolyFoam | Rigid Polyurethane Casting Foam	**PolyFoam R-2**	1A:1B by weight or volume	500	30 sec.	3 min.	10 min.	30 min.	2.5	4-8
	PolyFoam R-5	1A:1B by weight or volume	1,100	45 sec.	2 min.	3 min.	10-15 min.	5	8-20
	PolyFoam R-8	1A:1B by weight or volume	1,100	45 sec.	2 min.	3 min.	10-15 min.	8	8-20
PolyFoam | Flexible Polyurethane Casting Foam	**PolyFoam F-3**	1A:2B by weight	2,000	25 sec.	1.5 min.	3 min.	10 min.	3	5-8
	PolyFoam F-5	1A:1B by weight or volume	1,400	45 sec.	3-5 min.	25 min.	30-60 min.	5	8-15
SiliFoam | Flexible Platinum-Cured Silicone Foam	**PlatSil® SiliFoam**	1A:1B by weight or volume	7,500	30-45 sec.	4 min.	ND	30 min.	15	ND

ND = Not Determined

Note on PolyFoam Compaction Calculation:

Determine the volume of the space you want to fill with foam in cubic inches (in^3). Convert the volume to ft^3 by dividing by 1728 in^3/ft^3. Determine the desired density of the foam part in pounds per cubic foot (lb/ft^3). Note: Foam products are typically compacted to at least 2 pounds more than their free-rise density to produce good quality parts. Therefore, to determine the quantity of foam needed, add at least 2 pounds to the free-rise density (e.g., for R-2, use at least 4 lb/ft^3; for R-5 use 7 lb/ft^3; and so on). Multiply the volume of the part (ft^3) by the desired density (lb/ft^3) to determine how many pounds of PolyFoam liquid to mix.

Example:

You intend to make a part that is 4320 in^3.

Convert to ft^3: 4320 in^3 ÷ 1728 in^3/ft^3 = 2.5 ft^3.

Desired density is 5 lb/ft^3, so choose R-2 and determine volume to pour based on packing to 5 lb/ft^3.

5 lb/ft^3 x 2.5 ft^3 = 12.5 lb PolyFoam total