

ETECO, INC.

POLYURETHANE SPECIALIST

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HP 8204

Product Information

HP 8204 is low density rigid polyurethane molding foam system designed for processing through plural component dispensing equipment. This material is Eco Friendly, no HCFC's or HFC's. This product is recommended for molding intricate decorative simulated wood furniture parts, moldings, picture frames and other decorative parts. HP 8204 easily accepts paints and stains.

Physical Properties (Components)

	Component A	Component B
Viscosity at 75°F (cps)	160 - 220	500 - 700
Specific Gravity (gr/ml)	1.22 - 1.23	1.07 - 1.09

Physical Properties (Final Product)

Free Rise Density (pcf)	4.0 – 4.5
Compressive Strength ASTM D-1621	60 psi
Shear Strength ASTM D-273	45 psi

Handling Characteristics

Mix Ratio by Weight (Component A/ Component B)	52 / 48
Mix Ratio by Volume (Component A/ Component B)	50 / 50
Cream Time (at 75°F), (seconds)	40 - 50
Rise Time (seconds)	100 - 120
Tack Free Time (seconds)	120 - 160
Demold Time (minutes)	15 - 30

Storage and Shelf Life

Components A and B should be kept well sealed in a dry place at a temperature between 55 and 90°F. Shelf life of unopened containers is 6 (six) months from a manufacturing date. Purge opened containers with dry nitrogen before resealing.

Refer to MSDS of the product for more information.

Packaging

Component A:	55 gallon steel drum (closed top)	500 lb Net Weight
	275 gallons plastic totes	2500 lb Net Weight
Component B:	55 gallon steel drum (closed top)	450 lb Net Weight
	275 gallons plastic totes	2250 lb Net Weight

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