



Product Information

HLS 8524 is a high density rigid polyurethane molding foam system designed for processing through plural

component (RIM) dispensing equipment. This material is certified and approved by UL for use in Canada

and US rated to 94V-0 as well as 5Va in 3mm and 6mm thickness. UL file number is E495931. This product is designed for molding intricate electronic, medical and appliance fixtures. HLS 8524 easily

Physical Properties (Final Product)	Units	Test Method	Results
Free Rise Density	pcf	ASTM D-1622	23.0 - 24.0
Heat Deflection	°F	ASTM D-648	170
Tensile Strength	psi	ASTM D-412	5050 - 5400
Elongation	%	ASTM D-412	5.5 - 7.5
Flexural Modulus	ksi	ASTM D-790	340 - 380
Flexural Strength	ksi	ASTM D-790	11.5 - 12.7
Tensile Modulus	Mpa	ASTM D-638	1500 - 1600

Handling Characteristics	Units	Component A	Component B
Mix Ratio by Volume	(A/B)	-	-
Mix Ratio by Weight	(A/B)	59	41
Specific Gravity @ 75°F	g/mL	1.20	1.09
Viscosity @ 75°F	cPs	300 - 400	800 - 1000
Color	-	Amber	Amber
Cream Time @ 75°F	Seconds	18 - 22	
Gel Time @ 75°F	Seconds	35 - 40	
Rise Time	Seconds	50 - 60	
Tack Free Time	Seconds	50 - 60	
Demold Time	Minutes	5 - 6	
Final Cure Time	Hours	1	

Properties are typical and not for specifications

Storage and Shelf Life

Components should be kept well sealed in a dry place from 55 to 90°F. Shelf life of unopened containers is six (6) months from manufacturing date. Mix Component B well prior to each use. Purge opened containers with dry nitrogen before resealing. Refer to product SDS for more information.

Packaging

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

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