



Product Information

HP 8204 is a low density rigid polyurethane molding foam system designed for processing through plural component dispensing equipment. Once fully cured, this material is tough with high compression and tensile value. HP 8204 exhibits very good surface characteristics and excellent moldability. This product is recommended for molding intricate decorative simulated wood furniture parts, moldings, picture frames and other decorative parts. This material is Eco Friendly due to its lack of HCFC's, HFC's, and lead or other heavy metals.

Physical Properties (Final Product)	Units	Test Method	Results
Free Rise Density	pcf	ASTM D-1622	3.8 - 4.2
Compressive Strength	psi	ASTM D-1621	60
Tensile Strength	psi	ASTM D-1623	-
Shear Strength	psi	ASTM D-273	45
Elongation	%	ASTM D-1623	-
Closed Cell Content	%	ASTM D-2856	-

Handling Characteristics	Units	Component A	Component B
Mix Ratio by Volume	(A/B)	50	50
Mix Ratio by Weight	(A/B)	52	48
Specific Gravity @ 75°F	g/mL	1.21 - 1.23	1.07 - 1.09
Viscosity @ 75°F	cPs	150 - 250	500 - 700
Color	-	Amber	Opaque/Beige-ish
Cream Time @ 75°F	Seconds	40 - 50	
Gel Time @ 75°F	Seconds	80 - 100	
Rise Time	Seconds	100 - 120	
Tack Free Time	Seconds	120 - 160	
Demold Time	Minutes	15 - 30	
Final Cure Time	Hours	24	

Properties are typical and not for specifications

Storage and Shelf Life

Components should be kept well sealed in a dry place from 70 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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