



FOAM-iT!™ Series

3lb., 5lb & 15lb. Density Rigid Polyurethane Foams

PRODUCT OVERVIEW

Smooth-On's **FOAM-iT!™ Series** consists of two-component rigid foams that are versatile and easy to use. FOAM-iT! products are available in 3lb., 5 lb. or 15 lb. per cubic foot densities. Parts A + B are mixed in equal amounts by volume (1A: 1B) and are poured into a mold or other form (apply release agent if necessary). Mixture will expand many times original volume (depending on which **FOAM-iT!** product you are using) and develop a uniform cell structure. Foam becomes tack free in about 4 - 6 minutes, develops handling strength in 20 minutes and fully cures in 2 hours.

FOAM-iT!™ products are premium foams that are very strong and durable. They can be pigmented and are used for a variety of art/craft, industrial design and special effect applications. **FOAM-iT!™** can be used as a straight casting material, backfill material for hollow castings (adds structural strength) or as an encapsulation material, etc. **FOAM-iT!™ 15** can be cast and used as a carvable prototype modeling medium. **FOAM-iT!™** can also be pigmented. If your application calls for flexible foam, try *FlexFoam-It™* from Smooth-On. It is a premium flexible foam that is strong and resists tearing and compression set.

TECHNICAL OVERVIEW

<u>Smooth-On Rigid Foam</u>	<u>Foam-iT! 3</u>	<u>Foam-iT! 5</u>	<u>Foam-iT! 15</u>
Mixed A+B Viscosity	200 cps	300 cps	500 cps
Pot Life (Cream Time)	1 Minute	1.5 Minutes	1.5 Minutes
Tack-Free Time	6.5 Minutes	5 Minutes	4 Minutes
Handling Strength	20 Minutes	20 Minutes	20 Minutes
Demold Time	2 Hours	2 Hours	2 Hours
Grams/Cubic Cm.	0.04 - 0.06	0.08 - 0.10	0.22 - 0.26
Cubic Inches/Lb.	530 - 630	300 - 350	105 - 125
Lbs./Cu. Foot = Kgs./Cu. Meter	3 lb/ft³ = 48 kg/m³	5 lb/ft³ = 80 kg/m³	15 lb/ft³ = 240 kg/m³

Applying A Release Agent

Preparation . . . Materials should be stored and used in a warm environment (72° F / 33° C). Mixing tools and containers should be clean and made of metal, glass or plastic. **Mixing should be done in a well ventilated area.** Wearing eye protection, latex gloves and long sleeve garments to minimize skin contact is strongly recommended.

Applying A Release Agent . . . A release agent is necessary to facilitate demolding when casting into or over most surfaces. **Use a release agent made specifically for releasing urethane foams such as *Ease Release 2831*** available from Smooth-On or your Smooth-On distributor - Do not use a silicone based release agent. A liberal coat of release agent should be applied onto all surfaces that will contact the foam. **~IMPORTANT:** To ensure thorough coverage, lightly brush the release agent with a soft brush over all surfaces. Let the release agent dry for 30 minutes.

Mixing & Pouring

Mixing . . . After dispensing equal amounts of Parts A and B into mixing container, **mix thoroughly** for 45 seconds. Stir quickly making sure that you scrape the sides and bottom of the mixing container several times. Be careful not to splash low viscosity material out of the container. **Remember, this product cures quickly.** Do not delay between mixing and pouring.

Pouring . . . For best results, pour your mixture in a single spot at the lowest point of the containment field and let the mixture seek its level.

IMPORTANT: Shelf life of product is drastically reduced after opening. Remaining product should be used as soon as possible. Immediately replacing the lids on both containers after dispensing product will help prolong the shelf life of the unused product. **XTEND-IT Dry Gas Blanket** (available from Smooth-On) will significantly prolong the shelf life (up to 4 times longer) of unused liquid urethane products.

Safety First!

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The material safety data sheet (MSDS) for this or any Smooth-On product should be read before using and is available on request. All Smooth-On products are safe to use if directions are read and followed carefully. **Keep Out Of Reach Of Children!**

Be careful. Part A (Yellow Label) contains methylene diphenyl diisocyanate. Vapors, which can be significant if heated or sprayed, may cause lung damage and sensitization. Use only with adequate ventilation. Contact with skin and eyes may cause severe irritation. Flush eyes with water for 15 minutes and get immediate medical attention. Remove from skin with soap and water. Part B (Blue Label) is irritating to the eyes and skin. Avoid prolonged or repeated skin contact. If contaminated, flush eyes with water for 15 minutes and get immediate medical attention. Remove from skin with soap and water. When mixing with Part A, follow precautions for handling isocyanates. If machining cured Foam-iT 5, wear dust mask or other apparatus to prevent inhalation of residual particles.

Important - The information contained in this bulletin is considered accurate. However, no warranty is expressed or implied regarding the accuracy of the data, the results to be obtained from the use thereof, or that any such use will not infringe a copyright or patent. User shall determine suitability of the product for the intended application and assume all associated risks and liability.

Call Us Anytime With Questions About Your Application.

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