

AstiTech PU Foam

Usage Advice

AstiTech PU foams are a 2 part component polyurethane Soft-Foam system.

Application: Production of individual cushion parts, for example orthopaedic foot supports, seat cushions and mattresses.

Information on Components:

Density: A-Component: 1.0g/cm³
B-Component: 1.2g/cm³

Storage: Temperature: 20-25°C
A and B components are extremely sensitive to damp conditions and should be stored in a dry environment with the lid securely closed.

Sizes: A-Component: 2.5Kg & 865g
B-Component: 2.5Kg, 865g & 433g

Info: The AstiTech range is available in 3 different 'A' components (500 = strong / 300 = soft / 150 = extra soft)
The 'B' component is the same for all 'A' components, for the mixing ratios see table below.

Processing Procedure:

- Shake both components well before mixing, note that the B-Component is sensitive to cold and should not be stored at a temperature below 15°C.
- You can change the shore strength (Shore A) of the foam by the following:
 1. Use a different A-Component (see table below)
 2. Foaming into a closed mould (see table below)
- To mix the components use a stirring machine. For smaller quantities hand-mixing is possible however it is the strength rather than the duration that creates a good mix so stir vigorously.
- Processing temperature: 20-25°C
- Stirring duration: approx. 30 seconds (hand-mixing)
approx. 15 seconds (stirring machine)
- Starting time: approx. 60-70 seconds (the foam will begin to cream up)
- Time of rising: approx. 140-160 seconds
- Density: see table below
- Structure: Open-cell



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Technical Information

Table for component quantities per mould volume.

	AstiTech® 500		AstiTech® 300		AstiTech® 150	
Size	2.5Kg (TK1596) 865g (TK1594)		2.5Kg (TK1600) 865g (TK1598)		2.5Kg (TK1504) 865g (TK1502)	
Expansion factor	approx. 2.1		approx. 3.8		approx. 5.3	
Density in Kg/m³	510		280		200	
Shore A Hardness	approx. 30-40		approx. 10-15		approx. 6-10	
Component	A	B	A	B	A	B
Mixing ratio in parts per weight	100	50	100	50	100	50
Required mould volume in cm³.	Required weight of the components in g.					
100	34	17	19	9	13	7
200	68	34	37	19	27	13
300	102	51	56	28	40	20
400	136	68	74	37	53	27
500	171	85	93	47	67	33
600	205	102	112	56	80	40
700	239	119	130	65	93	47
800	273	136	149	74	107	53
900	307	153	167	84	120	60
1000	341	171	186	93	133	67

Applicant data are approx. because the expansion result is subject to conditions such as material and mould temperature, humidity, mixing power etc.