



# FOAM-iT!<sup>®</sup> 10 SLOW

## 10lb. Density Rigid Polyurethane Foam



www.smooth-on.com

### PRODUCT OVERVIEW

Mix A+B in equal amounts by volume THOROUGHLY for 90 seconds and pour into mold or other form (apply release agent if necessary). Pot life (cream time): 3.5 minutes. Mixture will expand 6 times original volume with uniform 10 lb. cell structure. Tack free in 20 minutes, handling strength in 1 hour, full cure in 4 hours at room temperature. Read Technical Bulletin and MSDS available from Smooth-On.

#### TECHNICAL OVERVIEW

Mix Ratio; 1A:1B by volume

Mixed Viscosity; 400 cps (ASTM D-23932)

Pot Life (Cream Time);  
3.5 minutes (72° F / 23°C) (ASTM D-2471)

Tack-Free Time; 20 minutes (72° F / 23°C)

Handling Strength; 1 hour (72° F / 23°C)

Cure Time; 4 hours

Grams / Cubic Cm.; 0.15 - 0.17

Cubic Inch / lb.; 150 - 175

Lbs. / Cu. Foot = Kgs. / Cu. Meter; 10 lb/ft<sup>3</sup> = 160 kg/m<sup>3</sup>

Approx. Volumetric Expansion; 6 times

Color; Beige

\* Value measured after 7 days at 77°F/25°

### PROCESSING RECOMMENDATIONS

**Preparation** – Materials should be stored and used in a warm environment (72° F / 23° C). These products have a limited shelf life and should be used as soon as possible. Mixing tools and containers should be clean and made of metal, glass or plastic. **Mixing should be done in a well-ventilated area.** Wear safety glasses, long sleeves and rubber gloves to minimize contamination risk. **Because no two applications are quite the same, a small test application to determine suitability for your project is recommended if performance of this material is in question.**

**Applying A Release Agent** – These foams will stick to just about anything. A release agent is necessary to facilitate demolding when casting into or over most surfaces and will extend mold life. **Use a release agent made specifically for releasing urethane foams such as Ease Release<sup>®</sup> 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** – Know the mix ratio for the FOAM-iT!<sup>®</sup> product you are using. After dispensing the correct amounts of Parts A and B into mixing container, **mix thoroughly for 90 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, foams cure quickly. Do not delay between mixing and pouring.

## Safety First!

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.

**Part A (Yellow Label)** contains methylene diphenyldiisocyanate. 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.

**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 upon a patent. User shall determine the suitability of the product for the intended application and assume all risk and liability whatsoever in connection therewith.

**IMPORTANT:** Shelf life of product is 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 of unused liquid urethane products.

**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.

### **Improve Surface Finish and Minimize Voids With Back Pressure**

- Use a board that will completely cover the mold opening. Using a 3/4" (2 cm) drill bit, drill 3 holes in the board spaced a few inches / cm apart. Make sure that, when the board is placed over the mold opening, the holes are over the mold cavity and rising foam will be able to make it through. Apply Ease Release® 2831 thoroughly too both sides of the board and into the drilled holes. Mix and pour FOAM-iT!® into mold cavity and place board over mold opening. Hold board firmly in place. As foam rises in the mold cavity, some foam will grow out of the drilled holes. After the foam stops growing, you can let go of the board. Do not handle for at least 1 hour. After 1 hour, you can then cut excess material that came through holes and gently remove board and casting.



**Call Us Anytime With Questions About Your Application.**

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The new [www.smooth-on.com](http://www.smooth-on.com) is loaded with information about moldmaking, casting and more.