

Polytek® Casting Foams



Series	Product	Mix Ratio	Mix Viscosity (cP)	Cream Time	Rise Time	Tack-Free Time	Demold Time	Free-Rise Density (lb/ft³)	Molded Density (lb/ft ³)
PolyFoam Rigid Polyurethane Casting Foam	PolyFoam R-2	1A:1B by weight or volume	500	30 sec.	3 min.	10 min.	30 min.	2.5	4-8
	PolyFoam R-5	1A:1B by weight or volume	1,100	45 sec.	2 min.	3 min.	10-15 min.	5	8-20
	PolyFoam R-8	1A:1B by weight or volume	1,100	45 sec.	2 min.	3 min.	10-15 min.	8	8-20
PolyFoam Flexible Polyurethane Casting Foam	PolyFoam F-3	1A:2B by weight	2,000	25 sec.	1.5 min.	3 min.	10 min.	3	5-8
	PolyFoam F-5	1A:1B by weight or volume	1,400	45 sec.	3-5 min.	25 min.	30-60 min.	5	8-15
SiliFoam Flexible Platinum-Cured Silicone Foam	PlatSil® SiliFoam	1A:1B by weight or volume	7,500	30-45 sec.	4 min.	ND	30 min.	15	ND

Note on PolyFoam Compaction Calculation:

Determine the volume of the space you want to fill with foam in cubic inches (in³). Convert the volume to ft³ by dividing by 1728 in³/ft³. Determine the desired density of the foam part in pounds per cubic foot (lb/ft³). Note: Foam products are typically compacted to at least 2 pounds more than their free-rise density to produce good quality parts. Therefore, to determine the quantity of foam needed, add at least 2 pounds to the free-rise density (e.g., for R-2, use at least 4 lb/ft³; for R-5 use 7 lb/ft³; and so on). Multiply the volume of the part (ft³) by the desired density (lb/ft³) to determine how many pounds of PolyFoam liquid to mix.

Example:

You intend to make a part that is 4320 in³. Convert to ft^3 : 4320 in³ ÷ 1728 in³/ft³ = 2.5 ft³. Desired density is 5 lb/ft³, so choose R-2 and determine volume to pour based on packing to 5 lb/ft³. $5 \text{ lb/ft}^3 \times 2.5 \text{ ft}^3 = 12.5 \text{ lb PolyFoam total}$

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Technical Reference Chart

ND = Not Determined

