

### TECHNICAL DATA SHEET

Eco-Pur® 325-6 is a two component, closed cell, rigid polyurethane foam system specially formulated for pour-in-place applications. The resin contains polyols made from renewable soy oils, recycled plastic, and the newest generation of blowing agent with zero ozone depleting potential. Eco-Pur 325-6 is specially designed for filling voids and applications where superior load bearing properties are required.

Applications: Injection, residential doors, insulation for garage doors, panel, refrigerator units and very large parts.

PHYSICAL PROPERTIES			
Density	2.2 - 2.4 lb/ft <sup>3</sup>	35.2 - 38.4 kg/m <sup>3</sup>	ASTM D 1622
Initial Thermal Resistance (R-value @ 1 inch)	6.5 - 6.7 Btu•in/ft <sup>2</sup> •h•°F	45 - 46.5 W/m <sup>2</sup> •°C	ASTM C 518
Compressive Strength	25 - 30 psi	172 - 207 kPa	ASTM D 1621
Dimensional Stability (% volume change @ 14 days)			ASTM D 2126
158°F (70°C), Ambient Relative Humidity	1%		
158°F (70°C), 75% Relative Humidity	0.5 - 1%		
73°F (23°C), 90% Relative Humidity	1 - 2%		
Water Absorption (% absorption)	1.77		ASTM D 2842
Flexural Strength	60.6 psi	418 kPa	ASTM C 203
Modulus of Elasticity	1,222 psi	8425 kPa	ASTM C 203

REACTIVITY PROFILE				
	Cream Time	Gel Time	Tack Free Time	Free Rise Density
Hand Mix*	40 - 70 seconds	200 - 250 seconds	300 - 400 seconds	2.2 - 2.4 lb/ft <sup>3</sup>
Machine Mix**	10 - 15 seconds	100 - 150 seconds	200 - 250 seconds	1.9 - 2.1 lb/ft <sup>3</sup>

\*Hand mixed using a 2" mixer @ 2500 RPM for 10 seconds, liquid components at 77°F (25°C).

\*\*High pressure machine (Graco E-30), liquid components at 73°F (23°C).

LIQUID COMPONENT PROPERTIES*		
PROPERTY	A-PMDI ISOCYANATE	ECO-PUR 325-6 RESIN
Color	Brown	Amber
Viscosity @ 77°F (25°C)	180 - 220 cps	400 - 600 cps
Specific Gravity	1.24	1.13 - 1.17
Shelf Life of unopened drum properly stored	12 months	6 months
Storage Temperature	50 - 100°F (10 - 38°C)	50 - 85°F (10 - 29°C)
Mixing Ratio (volume)	100	100
Mixing Ratio (weight)	110	100

\*See SDS for more information.

PROCESSING RECOMMENDATIONS*		
Type of Machine	High or low pressure PIP machine	
Isocyanate Temperature	68 - 73°F	20 - 23°C
Resin Temperature	68 - 73°F	20 - 23°C
Mold or Panel Temperature	110 - 130°F	43 - 54°C
Minimum In-place Density	Per product lb/ft <sup>3</sup>	Per product kg/m <sup>3</sup>

\*Foam application temperatures and pressures can vary widely depending on temperature, humidity, elevation, substrate, equipment and other factors. While processing, the applicator must continuously observe the characteristics of the foam and adjust processing temperatures and pressures to maintain proper cell structure, adhesion, cohesion and general foam quality. It is the sole responsibility of the applicator to process and apply Eco-Pur 325-6 within specification.

**General Requirements:** It is important to monitor the in-place density of the foam as stated in the Processing Recommendations section above. A lower density will result in poor physical properties. Furthermore, proper temperature of the substrates (110 - 130°F (43 - 54°C)) is critical in order to obtain a good adhesion of the foam to the substrate. It is the user's responsibility to test the product to ensure it performs to their expectations. This product should not be used when the continuous service temperature of the substrate is outside the range of -76°F (-60°C) to 176°F (80°C).

**Disclaimer:** The information herein is to assist customers in determining whether our products are suitable for their applications. We request that customers inspect and test our products before use and satisfy themselves as to contents and suitability. Nothing herein shall constitute a warranty, expressed or implied, including any warranty of merchantability or fitness, nor is protection from any law or patent inferred. All patent rights are reserved. The foam product is combustible and must be protected in accordance with applicable codes. Protect from direct flame and spark contact, around hot work for example. The exclusive remedy for all proven claims is replacement of our materials.