

# Elastofoam® 38100R / 3120T

Polyurethane

BASF Corporation

## Message:

Low density I-skin foam system (natural color)

HFC 245fa-blown, two-component microcellular polyurethane foam system designed for molding of miscellaneous Integral Skin articles that require good skin at relatively low molded densities. Depending on the application requirements and the processing conditions this system can provide

Exceptional skin formation when casted in metal tools at low mold temperatures

Wide range of molded densities from 10 to 25 pcf

Hardness range from 10 to 70 Shore A

Wide processing window on both low-pressure and high-pressure equipment

General Information			
Features	Low density		
	Workability, good		
Uses	Foam		
	Application in Automobile Field		
	Car interior parts		
Physical	Nominal Value	Unit	Test Method
Density			ASTM D1622
-- <sup>1</sup>	0.256	g/cm <sup>3</sup>	ASTM D1622
-- <sup>2</sup>	0.320	g/cm <sup>3</sup>	ASTM D1622
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shaw A <sup>3</sup>	45		ASTM D2240
Shaw A <sup>4</sup>	55		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Strength			ASTM D412
Yield <sup>5</sup>	1.17	MPa	ASTM D412
Yield <sup>6</sup>	1.86	MPa	ASTM D412
Tensile Elongation <sup>7</sup> (Break)	130	%	ASTM D412
Tear Strength			ASTM D624
--	4.03	kN/m	ASTM D624
--	5.78	kN/m	ASTM D624
Cracking <sup>8</sup>	1.6	kN/m	ASTM D624
Cracking <sup>9</sup>	2.1	kN/m	ASTM D624
Compression Set			ASTM D395B
70°C, 22 hr <sup>10</sup>	15	%	ASTM D395B
70°C, 22 hr <sup>11</sup>	10	%	ASTM D395B
Flammability	Nominal Value	Unit	Test Method

Burning Rate			FMVSS 302
-- 12	0.0	mm/min	FMVSS 302
-- 13	0.0	mm/min	FMVSS 302

#### Additional Information

Processing parameters:

Mix Ratio (Resin/Isocyanate): 100/38 pbw

Isocyanate Temperature: 75 to 95°F

Resin Temperature: 75 to 90°F

Mold Temperature: 75 to 110°F

Demold Time: 5 to 6 min

Liquid Component:

Density, Resin at 25°C, ASTM D1638: 1.05 g/cm<sup>3</sup>

Density, Isocyanate at 25°C, ASTM D1638: 1.20 g/cm<sup>3</sup>

Viscosity, Resin at 25°C, ASTM D2196: 500 cP

Viscosity, Isocyanate at 25°C, ASTM D2196: 150 cP

Hand Mix at 77°F:

Cream Time: 20 sec

Top of Cup: 50 sec

Gel Time: 70 sec

Rise Time: 110 sec

Tack Free Time: 130 sec

Free Rise Density: 7.0 lb/ft<sup>3</sup>

High Pressure at 77°F:

Cream Time: 13 sec

Top of Cup: 35 sec

Gel Time: 50 sec

Rise Time: 75 sec

Tack Free Time: 100 sec

Free Rise Density: 6.5 lb/ft<sup>3</sup>

#### NOTE

- |     |               |
|-----|---------------|
| 1.  | Hand Mix      |
| 2.  | High Pressure |
| 3.  | Hand Mix      |
| 4.  | High Pressure |
| 5.  | Hand Mix      |
| 6.  | High Pressure |
| 7.  | Hand Mix      |
| 8.  | Hand Mix      |
| 9.  | High Pressure |
| 10. | Hand Mix      |
| 11. | High Pressure |
| 12. | Hand Mix      |
| 13. | High Pressure |

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