

Guide to Use of AUSTHANE AUE 276 Rigid Low Density Foam System
(an *ecomate*® based foam system - Zero ODP¹, Zero GWP², and VOC³ exempt Blowing Agent)

GENERAL MACHINE PROCESSING CONDITIONS**1. TEMPERATURE SETTINGS FOR PROCESSING THROUGH GRACO / GUSMER EQUIPMENT**

HEATER UNIT	35 - 40 °C	[95 - 104 °F]
HOSE	35 - 40 °C	[95 - 104 °F]

PRESSURE SETTINGS FOR FUSION AP GUN WITH AR4242 MIXING CHAMBER WITH POUR TIP

MACHINE STATIC PRESSURE	Minimum of 1500 psi [103 bar]
DYNAMIC / SPRAYING PRESSURE	Minimum of 1000 psi [69 bar]

2. TEMPERATURE SETTINGS FOR PROCESSING THROUGH “LOW PRESSURE TYPE” PU EQUIPMENT – SAIP SE TYPE Machines or equivalent

COMPONENT TEMPERATURE	23 - 27 °C
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3. COMPONENT TEMPERATURES / DRUM STORAGE CONDITIONS

- Keep the temperature of both the components in the drums above 15 °C.
- Keep the supply drums sealed unless decanting product.
- Fit Desiccant Dryer Units to both Drums and monitor / replace Units regularly.
- Keep machine tanks sealed unless refilling operation is proceeding.

4. SUBSTRATE / SKIN SECTIONS SURFACE TEMPERATURE

Substrate / skin temperature should be a **minimum of 25 °C** to achieve good foam expansion and yield.

Optimum temperature is typically **35 - 40 °C**. The optimum temperature for specific applications needs to be established by actual process trials.

IMPORTANT NOTE:

If the temperature of the surface skins is below 15 °C, the physical properties of the foam may be effected and the expansion rate / yield will decline significantly.

PRODUCT USE WARRANTY

The data, information and suggestions covered in this data sheet, are given on the basis that the materials will be used correctly and professionally and at the sole risk of the user. No liability is accepted by AUSTRALIAN URETHANE SYSTEMS, for any loss, injury or damage arising from the use of the within information or materials described, no warranty, either expressed or implied, is given as to the exclusion from any patents or as to the fitness of the goods described for any particular purpose and each application should be fully evaluated to the satisfaction and acceptance of the user, in particular as to the combustibility or flammability or toxicity of material generated by combustion of the products herein described or materials produced from these products.