Polytek Development Corp.

Polytek® Casting Foams

Technical Reference Chart

Series	Product	Mix Ratio	Mix Viscosity (cP)	Cream Time	Rise Time	Tack-Free Time	Demold Time	Free-Rise Density (lb/ft³)	Molded Density (lb/ft³)
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 (in^3). Convert the volume to ft^3 by dividing by 1728 in^3/ft^3. Determine the desired density of the foam part in pounds per cubic foot (lb/ft^3). 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/ft^3; for R-5 use 7 lb/ft^3; and so on). Multiply the volume of the part (ft^3) by the desired density (lb/ft^3) to determine how many pounds of PolyFoam liquid to mix.

Example:

You intend to make a part that is 4320 in^3.

Convert to ft^3: 4320 in^3 ÷ 1728 in^3/ft^3 = 2.5 ft^3.

Desired density is 5 lb/ft^3, so choose R-2 and determine volume to pour based on packing to 5 lb/ft^3.

5 lb/ft^3 x 2.5 ft^3 = 12.5 lb PolyFoam total

Polytek Development Corp.

Polytek® Latex Rubbers

Technical Reference Chart

Series	Product	Percent Solids	Density of Liquid Latex	Color	Viscosity @ 80°F ± 2 (cP)
NaturForm™ Molding Latex Rubbers	**NaturForm™ 60**	58-62%	8.15 ± 0.1 lb/gal	White	9,500-10,500
	NaturForm™ 60-R	58-62%	8.15 ± 0.1 lb/gal	Blue	5,000-7,000
	NaturForm™ 74	70-74%	8.1 ± 0.1 lb/gal	White	9,000-15,000
	NaturForm™ 74-R	70-74%	8.1 ± 0.1 lb/gal	Blue	17,000-20,000
NaturForm™ Mask Making Latex Rubber	**NaturForm™ 30**	61-65%	8.7 ± 0.1 lb/gal	Natural	2,000-3,000

ND = Not Determined