



Technical Data Sheet

SPECFIL™ FC 480 Polyol **SPECFIL™ FE 137** Isocyanate

Description

SPECFIL™ FC 480 Polyol/SPECFIL™ FE 137 Isocyanate is a two-component polyurethane system designed for use in the manufacturing of panel filters.

Typical Component Properties

	Units	SPECFIL™ FE 137 Isocyanate	SPECFIL™ FC 480 Polyol	Test Method
Viscosity	mPa.s	40-60 (at 25°C)	700-1300 (at 25°C)	ASTM D 445
Specific Gravity	g/cc	1.21 (at 25°C)	1.03 (at 25°C)	ASTM D 891

These are typical values and should not be construed as specifications.

Recommended Process Conditions

Polyol component needs to be remixed before use. Both components need to be protected from humidity. Molds should be treated with an appropriate release agent.

	Units	Limits
SPECFIL™ FE 137 Isocyanate	pbw	32
SPECFIL™ FC 480 Polyol	pbw	100
Typical component temperature	°C	20-25
Typical mold temperature	°C	45-65

Typical Reaction Characteristics

	Units	Limits
Cream Time	s	20-25
Gel Time	s	70-80
Free Rise Density	Kg/m ³	230-350

Data referred to laboratory tests made with components at 20 °C, hand-mixed with a mechanical stirrer at 3000 rpm. Reported values may vary depending on processing condition.

Handling and Storage

	Units	SPECFIL™ FE 137 Isocyanate	SPECFIL™ FC 480 Polyol
Storage temperature	°C	15-25	15-25
Storage stability/Shelf life ⁽¹⁾	months	6	6

1. Stored in the original sealed containers in a dry place at the suggested temperature

Typical Polymer Properties

	Units	Values	Test Method
Final Density (molded)	Kg/m ³	350-420	Internal DOW Method
Hardness	Shore A	18-26	ASTM D2240

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