

**TotalBoat Flotation Foam - 6 LB Density -- Tech Data Sheet**

**PREPARATION:**

**FOAM PREPARATION:** Before mixing this product, several considerations must first be addressed:

- **TEMPERATURE:** TotalBoat Flotation Foam should be mixed and applied at a warm room temperature, 75-80°F is optimum. If the material or environmental conditions are too cool, the polyurethane will shrink back after rising, losing much of its insulating properties and flotation strength.
- **PREPAREDNESS:** This product must be poured immediately after a quick mixing. The area to be filled must be accessible and prepped ahead of time. Drilling holes in advance may be required for proper accessibility and application. For proper bonding, the surface should be clean and free of contaminants. Be sure the substrate you are pouring the foam into will not be compromised by the foam's thermal reaction, which can reach temperatures nearing 130°F.
- **OVERFLOW RELIEF:** TotalBoat Flotation Foam will expand tremendously by volume. In doing so, it can exert as much as 5 psi of pressure in contained areas. This is enough pressure to lift the deck off a boat when poured into cavities without proper venting. It may be necessary to cut overflow vents over large surface areas such as decks. This can be accomplished easily with a hole saw.

**APPLICATION:**

- 1 Clean the surface thoroughly. Remove any water, oil, grease, dust, or other contaminants before starting.
- 2 Ensure products are within the proper application temperature range and the substrate can safely handle an exothermic reaction up to 130°F.
- 3 Combine resin and hardener (1:1 by volume or by weight) into a sufficiently sized mixing pot. Accuracy is very important when measuring each component.
- 4 Mix thoroughly for 25 seconds. Timing is important.
  - In hot conditions over 80°F, mixing time may only be as little as 15 seconds before expansion begins — mix dilligently, and be ready to pour.
- 5 Pour foam.
- 6 Foam will start expanding 10-20 seconds after mixing, and will expand for roughly 4 minutes (in 70-80°F conditions)
- 7 Once cured, the foam can be overcoated with more foam, epoxy resin, or polyester resin, or cut into a desired shape.

**PROPERTIES:**

**Shear Strength:** 220 psi  
**Compressive Strength:** 55-80 psi  
**Tensile Strength:** 375 psi  
**Closed-Cell Content:** > 94%  
**Water Absorption:** ≤ .06 lbs./sq. ft.  
**Solvent Resistance:** Excellent  
**Mold and Mildew Resistance:** Excellent  
**Maximum Service Temperature:** 200°F  
**Flotation:** 23 lbs./quart, 92 lbs./gallon (admixed)

**APPLICATION DATA:**

<b>Mix Ratio:</b> 1:1 (by Weight) 1:1 (by Volume)
<b>Cream Time:</b> 65 seconds
<b>Gel Time:</b> 150 seconds
<b>Tack-Free Time:</b> 215 seconds
<b>Rise Time:</b> 200-250 seconds
<b>Demold Time:</b> 5-20 minutes
<b>Free Rise Core Density:</b> 6 pcf
<b>Yield:</b> 3/4 cubic feet (2 Quart Kit), 3 cubic feet (2 Gallon Kit)
<b>Application Temperature:</b> 60-85°F (75-80°F is optimal for yield and cure/working times)

**PHYSICAL DATA:**

<b>Color:</b> Transparent brown liquid (resin and activator)
<b>Components:</b> 2 - Resin and Activator
<b>Units of Measure:</b> 2 Quart Kit, 2 Gallon Kit
<b>Storage:</b> 65-95°F - DO NOT ALLOW TO FREEZE!
<b>Weight:</b> 9.0 lbs./gallon (resin), 10.2 lbs./gallon (activator)
<b>Flotation:</b> 23 lbs./ quart, 92 lbs./gallon (admixed)

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