



# FAGERDALA WORLD FOAMS

Fagerdala USA, Inc.

## GECET<sup>®</sup> Expandable Engineering Resins

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### PROCESSING GUIDELINES

#### EXPANSION

The following guidelines for the expansion and molding of GECET expandable resins are for typical molding conditions. Processing parameters will vary for different equipment and applications. Optimum process settings should be determined for each specific application and may differ from these guideline parameters. Fagerdala USA-Mendota's Technical Service Representatives are available to assist you in processing GECET expandable resins.

Typical operating conditions for dry, batch expansion of GECET resins below 6 pcf:

- F-100: 27 psi of jacket steam @ 270°F
- F-200: 38 psi of jacket steam @ 277°F
- F-300: 42 psi of jacket steam @ 282°F

For densities above 6 pcf, steam pressure and/or temperature should be reduced and expansion time increased.

The maximum recommended size for a wet batch expander for processing GECET resin is 2000 liters, operating at 0.3 to 0.5 bars of steam. The maximum recommended size for a continuous expander is 55 gallons. Continuous expansion is recommended for F-100 grade only, at expanded densities of 4 to 10 pcf.

Expanded GECET resin should be aged no more than 24 hours for low densities and no more than 48 hours for higher densities under normal processing conditions.

#### MOLDING

Recommended molding pressures for GECET resins:

- F-100: 28-32 psi plus 1 psi per pcf of part density
- F-200: 38-42 psi plus 1 psi per pcf of part density
- F-300: 48-52 psi plus 1 psi per pcf of part density

Both the fixed and moving sides of the mold should be designed for the above recommended steam pressures. Core vents (approximately ¼") should be located on a maximum of 1" centers. Cross steaming and water cooling are necessary to mold quality parts. Molding GECET resins at low to intermediate densities generally requires longer cycles than EPS due to higher steam pressures and greater fusion.

## **APPLICATION**

To help assure that Fagerdala USA-Mendota products are not misapplied, or used in any manner which may not have been intended or tested, we suggest a review of proposed applications with Fagerdala USA-Mendota personnel to assist in dealing with end use, regulatory and safety issues. Your Fagerdala USA-Mendota Sales Representative can arrange for the proper contact with our Technical Staff for such review.

## **SHIPPING AND HANDLING PRECAUTIONS**

Expandable GECET resin contains a flammable blowing agent and is consequently regulated by the United States Department of Transportation as a CLASS 9-MISCELLANEOUS MATERIAL. These products are shipped in regulation UN 2211, 1000-pound containers. Each container is lined with a hydrocarbon barrier liner to decrease the emissions of volatiles. Please refer to the respective resin's Material Safety Data Sheets (MSDS), copies of which are provided with the first product shipment or upon request.

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