

# 10124

## Systems: Footwear

10124 is a polyurethane microcellular foam system designed for soft Sandal shoe sole.

### APPLICATIONS

- Soft Sandal shoe sole (open-pouring)

### TYPICAL PROPERTIES

10124 system consists of 3 components.

Materials	Typical Properties	Method	Unit	Value
<b>A5902</b>	<b>Viscosity (@60° C)</b>	QC0-I002-T025	cps	approx 1,100
<b>B9802</b>	<b>Isocyanate content</b>		% by weight	21.1 – 21.6
	<b>Viscosity (@60° C)</b>	QC0-I002-T025	cps	≈ 170
<b>C5216</b>	Mixture of catalyst, chain extenders, cell regulators and foaming agent.			
<b>D5002H</b>	Hardener			

### PREPARATION OF PRODUCTS

A5902 must be warmed at 45-50 °C for 12-24 hours before mixing with C5216 (25-30°C) for about 15 minutes.

B9802 should be warmed at 45-50 °C for 12-24 hours prior to its use. It has a clear to turbid solution appearance. The temperature of components in the production tanks should be 40-50°C to ensure good processing.

### MIXING RATIO BY WEIGHT

Materials	A : C Ratio (pbw)
A5902	100.00
C5216	16.40

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### FOAMING FORMULATION ON MACHINE

100 pbw the above mixture (A+C) at working temperature 40±5°C  
 90 - 96 pbw B9802 at working temperature 40±5°C (The optimum ratio of Component B can be slightly different as per working condition)

**\*\* Mold temperature 50-55°C**

### FOAMING CHARACTERISTICS (at 40°C)

Foam Properties	Unit	Hand mix method
Cream time	Sec., approx.	10 – 11
Gel time	Sec., approx.	22 – 35
Tack free time	Sec., approx.	37 – 45
Demold time	approx.	Min. 6 – 8
Free rise density	kg/m <sup>3</sup> , approx.	190 – 210

### TYPICAL PROPERTIES OF FINISHED PRODUCTS

Physical Properties	Unit	Value
Molded density	kg/m <sup>3</sup>	370 – 400
Hardness	Shore C, approx.	55 – 60

### ADJUST MIXING RATIO TO VARY SOLE HARDNESS

Properties	Value	Value	Value
Molded density g/cc about	0.37 – 0.40	0.37 – 0.40	0.37 – 0.40
Hardness shore C	55 – 60	60 – 65	65 – 70
(depend on processing and mold)			
Weight of A5902, kg.	20	20	20
Weight of C5216, kg.	3.3	3.3	3.3
Weight of D5002H, kg.	-	0.4	0.8
Polyol : Isocyanate (B9802) Ratio	100 : 90-96	100 : 102-106	100 : 115

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### PACKAGE

Material can be supplied in 200 litre drum or 20 litre can.

### STORAGE AND HANDLING

The components are sensitive to moisture and should therefore at all times be kept in sealed drums. Storage temperatures should be within the range 20-25°C to ensure maximum shelf life. Rayelast® B 9802 at the best condition can be use up to 6 months, since the high humidity and warm condition such as Thailand the time consumption within 3 months is recommended.

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