

RAKU-TOOL[®] PC-3407 (Polyol) / PH-3906 (Isocyanate)

Casting System

Flexible, RT Curing, Two Component Polyurethane

PC - Rev.-Status: 01- 2008/04/02

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Key Properties

- Flows well
- Soft / flexible
- Excellent resistance to mechanical influences (vibration) etc.

Applications

- Structural molds
- Closed plaster molds for the ceramics industry

Processing Properties

			PC-3407	PH-3906
Color	visual		Beige	Yellowish
Mix ratio		pb weight	100	30
		pb volume	100	34
Density	ISO 1183	g/cm ³	1.36	1.15
Viscosity at 25 °C	ISO 2555	m Pa.s	2500-3000	20-40

PC-3407 / PH-3906

Mix viscosity at 25 °C	ISO 2555	m Pa.s	1300
Pot life at 25 °C	1000 ml	min	15-20
Max. layer thickness		mm	20
Demouldable after		h	24

Cured / Mechanical Properties**Cure: 7 days at RT or 14 h at 40 °C****PC-3407 / PH-3906**

Appearance	visual		Ivory
Density	ISO 1183	g/cm ³	1.3
Shore Hardness A	ISO 868		65-70
Service temperature		°C	5 - 80 (see graph next page)
Tensile strength	ISO 527	MPa	5
Elongation at break	ISO 527	%	350
Linear shrinkage		mm / m	< 0.1
Abrasion	Taber	mm ³ /100R	70

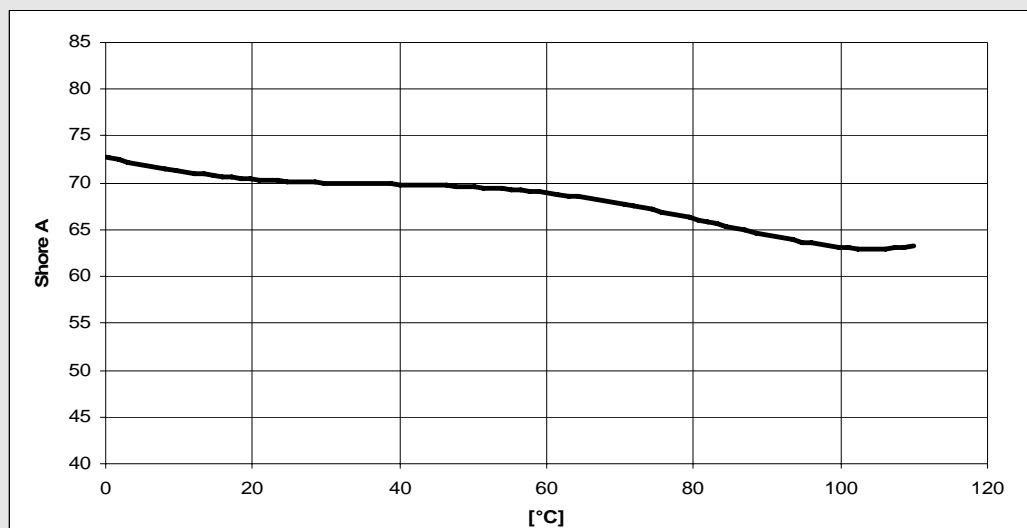
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Temperature dependent hardness profile**Processing**

The A component needs to be stirred well before use as some fillers might be prone to sedimentation. Mix the two components thoroughly in the ratio indicated carefully avoiding any air entrapment. Degassing and /or post-curing will improve final properties.

The processing and material temperature should be between 20-25 °C.

Packaging

RAKU-TOOL® PC-3407	20 kg
RAKU-TOOL® PH-3906	3 kg, 24 kg

Storage

In temperature controlled environments (20 °C - 25 °C) the original containers can be stored for at least 6 months. Both components are moisture sensitive and containers therefore need to be kept tightly sealed. The storage temperature for the hardener should not be below 20 °C as at 15 °C it might crystallize.

Handling Precautions

Good workplace ventilation is to be ensured during processing. At the same time, the employer's liability insurance association's industrial hygiene safety regulations regarding the handling of reaction resins and their hardeners are to be observed. Please take heed of the appropriate safety data sheets.