

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 |

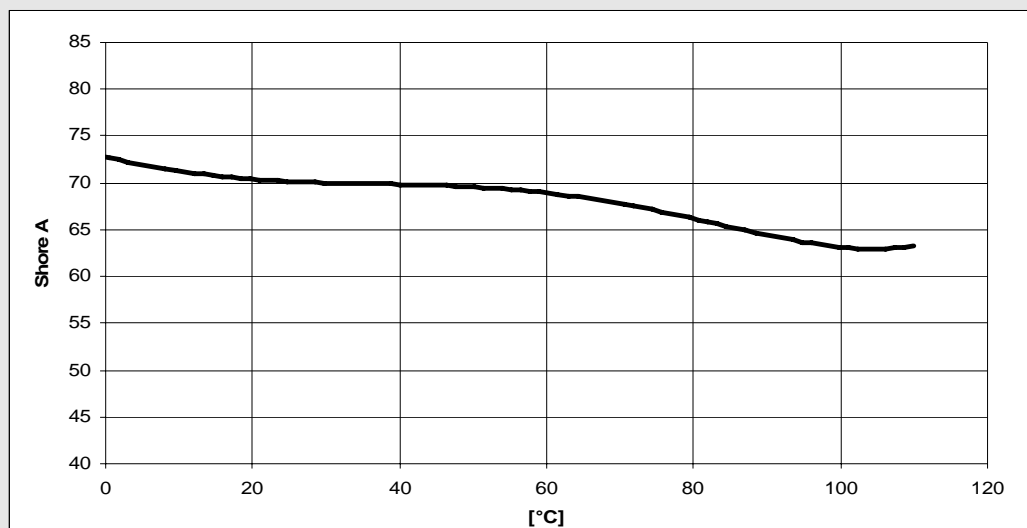
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Temperature dependent hardness profile**Processing**

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.