

RAKU-TOOL[®] PC-3451 (Polyol) / PH-3952 (Isocyanate)

Casting System

Two component Polyurethane

Supplied by

AMBERCOMPOSITES

PC - Rev.-Status: 01- 2006/04/25

Page 1 of 2

Key Properties

- High abrasion resistance
- High impact strength

Applications

- Foundry patterns
- Pattern plates
- Core boxes
- Impact protection
- Conveyor rollers

Processing Properties

			PC-3451	PH-3952
Color	visual		Beige	Amber
Mix ratio		pbw	100	60
Viscosity at 25 °C	ISO 2555	m Pa.s	9300	1100

			PC-3451 / PH-3952
Mix viscosity at 25 °C	ISO 2555	m Pa.s	8000
Pot life at 25 °C	1000 ml	min	25
Max. Layer thickness		mm	10-15
Demold time		h	16

Cured / Mechanical Properties

Cure: 7 days at RT or 14h at 40°C			PC-3451 / PH-3952
Appearance	visual		Beige
Density	ISO 1183	g/cm ³	1,1
Shore hardness D	ISO 868		60-65
Coefficient of thermal expansion	ISO 11359	10 ⁻⁶ K ⁻¹	110-120
Deflection temperature, HDT	ISO 75	°C	
Compressive strength	ISO 604	MPa	
Compressive modulus	ISO 604	MPa	300-400
Flexural strength	ISO 178	MPa	20
Linear shrinkage		mm / m	

RAKU-TOOL[®] PC-3451 (Polyol) / PH-3952 (Isocyanate)

Casting System

Two component Polyurethane

PC - Rev.-Status: 01- 2006/04/25

Page 2 of 2

Processing

Mix the two components thoroughly in the ratio indicated.

Degassing and /or post-curing will improve final properties.

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

Packaging

RAKU-TOOL[®] PC-3451

RAKU-TOOL[®] PH-3952

Storage

Original containers should be kept tightly sealed and stored at ambient temperatures (15°C to 30°C). If properly stored the products have the shelf-life indicated on the product label.

Partly used containers should always be sealed appropriately and used up as soon as possible.

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.

Supplied by

AMBERCOMPOSITES

94 Station Road, Langley Mill
Nottingham, NG16 4BP United Kingdom
T: +44 (0)1773 530899 F: +44 (0)1773 768687
E: sales@ambercomposites.com
www.ambercomposites.com

RAMPF Tooling GmbH & Co. KG
Albstr. 37 • D-72661 Grafenberg
T +49 (0) 7123 9342-1600
F +49 (0) 7123 9342-1666
E info@rampf-tooling.com

www.raku-tool.com

Our recommendations on the use of the material are based on many years of experience and current scientific and practical knowledge. They are, however, provided without any obligation on our part and do not relieve the buyer of the need for suitability tests. They do not constitute a legal relationship, nor are any protected third party rights whatsoever affected thereby.