

# RAKU-TOOL<sup>®</sup> PC-3451 (Polyol) / PH-3952 (Isocyanate)

## Casting System

### Two component Polyurethane

Supplied by

**AMBER**COMPOSITES

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

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#### 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 <sup>3</sup>	1,1
Shore hardness D	ISO 868		60-65
Coefficient of thermal expansion	ISO 11359	10 <sup>-6</sup> K <sup>-1</sup>	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	

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### 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.**

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### Packaging

RAKU-TOOL<sup>®</sup> PC-3451

RAKU-TOOL<sup>®</sup> PH-3952

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### 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.

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### 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.

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