

# RAKU-TOOL<sup>®</sup> PF-3702-1 (Polyol) / PH-3972-1 (Isocyanate)

## Fast Cast System

### Two component, filled, fast curing polyurethane

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**Key Properties**

- Easy to cast
- Fine structure
- Accurate castings
- Fast curing
- Universally applicable

**Applications**

- Foundry patterns and core boxes
- Jigs
- Negatives
- Replicas
- Prototypes

**Processing Properties**

			PF-3702-1	PH-3972-1
Color	visual		White	Light yellow
Mix ratio		pb weight	100	20
		pb volume	100	28
Density	ISO 1183	g/cm <sup>3</sup>	1.78	1.20
Viscosity at 25 °C	ISO 2555	m Pa.s	3400-3600	30-50
			PF-3702-1 / PH-3972-1	
Pot life at 25 °C	1000 ml	min	6-7	
Max. layer thickness		mm	20	
Demold time (RT)		h	0.5-1	

**Cured / Mechanical Properties****Cure: 7 days at RT or 14h at 40°C**

			PF-3702-1 / PH-3972-1
Appearance	visual		White
Density	ISO 1183	g/cm <sup>3</sup>	1.60
Shore Hardness D	ISO 868		75-80
Deflection temperature, HDT	ISO 75	°C	50-60
Compressive strength	ISO 604	MPa	40-50
Compressive modulus	ISO 604	MPa	2500-2700
Flexural strength	ISO 178	MPa	30-40
Linear shrinkage		mm / m	0.30

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### Processing

Carefully stir / shake the material before use.

Mix the two components thoroughly in the ratio indicated until a homogenous color has been obtained.

Cast onto a dry and clean surface which has been pre-treated with a suitable release agent.

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® PF-3702-1	6 x1 kg
RAKU-TOOL® PH-3972-1	6x0.200 kg

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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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