

**AMBERCOMPOSITES**
**RAKU-TOOL<sup>®</sup> PF-3704 (Polyol) / PH-3974**  
 (Isocyanate) Fast Cast System

**Two component, filled, fast curing polyurethane**

PC - Rev.-Status: 01- 2006/01/17

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**Key Properties**

- Filled
- Can be cast in layers of up to 100 mm
- Medium cure rate when casting larger components
- Low shrinkage
- 1 : 1 mix ratio by volume and parts by weight

**Applications**

- Foundry patterns and core boxes
- Negatives
- Replicas
- Jigs and holding fixtures
- Prototype parts

**Processing Properties**

			PF-3704	PH-3974
Color	visual		Blue	Beige
Mix ratio		pbw	100	100
Viscosity at 25 °C	ISO 2555	m Pa.s		
			PF-3704 / PH-3974	
Mix viscosity at 25 °C	ISO 2555	m Pa.s	1100-1300	
Pot life at 25 °C	1000 ml	min	8	
Max. layer thickness		mm	100	
Demold time (RT)		h	2-3	

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

			PF-3704 / PH-3974
Appearance	visual		Blue
Density	ISO 1183	g/cm <sup>3</sup>	1.7
Shore Hardness D	ISO 868		80-85
Deflection temperature, HDT	ISO 75	°C	95
Compressive strength	ISO 604	MPa	75-80
Compressive modulus	ISO 604	MPa	4800-5200
Flexural strength	ISO 178	MPa	65-70
Linear shrinkage		mm / m	1.0

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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-3704	6 x 0.7kg
RAKU-TOOL® PH-3974	6 x 0.7kg

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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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*Supplied by*

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