



Casting Systems

Unfilled, two component Polyurethane

Key Properties

- Hand cast
- No skull and crossbones label
- Shore hardness can be adjusted

Applications

- Structural molds
- Assembly jigs, impact protection
- Production of flexible parts

Processing Properties

			PC-3412	PC-3413	PH-3923
Color	visual		opaque/white	opaque/white	yellowish
Mix ratio		parts by weight	100	100	17
		parts by volume	100	100	45
Density	ISO 1183	g/cm ³	ca. 1.06	ca. 1.06	ca. 1.21
Viscosity at 25 °C	DIN 53019-1	mPa·s	550-600	950-1000	100-150

			PC-3412 / PH-3923	PC-3413 / PH-3923
Mix viscosity at 25 °C	DIN 53019-1	mPa·s	400-450	850-900
Pot life at 25 °C	1000 ml	min	3	3
Pot life at 25 °C	250 ml	min	10	10
Pot life at 45°C	250 ml	min	3	3
Max. layer thickness		mm	100	100
Demold time		h	14	14

Cured / Mechanical Properties

Cure: 7 days at RT or 14h at 40°C			PC-3412 / PH-3923	PC-3413 / PH-3923
Appearance	visual		white/opaque	white/opaque
Density	ISO 1183	g/cm ³	ca. 1.11	ca. 1.11
Shore hardness A	ISO 868		40	85
Tensile strength	ISO 527	MPa	3-5	10-15
Elongation at break	ISO 527	%	250-300	250-300
Tear strength	DIN 53515	N/mm	3-5	15-20
Abrasion	Taber	mm ³ /100R	30-40	30-40

PC-3412, PC-3413 (Polyols) and PH-3923 (Isocyanate) can be mixed to obtain a Shore hardness between A 40 and A 85.

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Processing

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

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.

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

Packaging

RAKU-TOOL® PC-3412	5 kg
RAKU-TOOL® PC-3413	5 kg / 25 kg
RAKU-TOOL® PH-3923	5 kg

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.
