RAKU® TOOL PP-3358 / PH-3905

Adhesive for working boards

Polyurethane Paste

Key Properties

- Good flow and easy application
- Rigid and good adhesion
- Rapid RT curing

Applications

- Color matched adhesive for bonding working board WB-1258
- Bonding of working boards

Processing Properties

			PP-3358	PH-3905
Color	visual		Orange	Brown
Mix ratio		pb weight	100	50
Density	ASTM D-792	lb/ft³ (g/cm³)	ca. 72.4 (ca. 1.16)	ca. 76.8 (ca. 1.23)

			PP-3358 / PH-3905
Pot life at 25 °C (77°F)	500 ml	min	5-8
Minimal curing time at 25 °C (77°F)		h	4

Cured / Mechanical Properties

Cure: 7 days at RT or 14h at 40°C (104°F)			PP-3358 / PH-3905
Aspect	visual		Orange
Density	ASTM D-792	lb/ft³ (g/cm³)	ca. 74.9 (ca. 1.2)
Shore hardness D	ASTM D-2240		75-80
Coefficient of thermal expansion	ASTM D-3386	$10^{-6}F^{-1}$ ($10^{-6}K^{-1}$)	44-50 (80-90)
Deflection temperature, HDT	ASTM D-648	°F (°C)	122-131 (50-55)
Glass Transition Temperature, Tg	DSC	°F (°C)	113-122 (45-50)
Compressive strength	ASTM D-695	psi (MPa)	7,000-7,700 (48-53)
Flexural strength	ASTM D-790	psi (MPa)	8,000-8,700 (55-60)
Flexural modulus	ASTM D-790	psi (MPa)	261,000-290,000 (1,800-2,000)

Processing

The processing and material temperature should be between 20-25 ºC (68-77 ºF).
Mix the two components thoroughly in the ratio indicated and apply to both sides of the surface to be bonded.

Packaging

RAKU-TOOL® PP-3358	6 x 1 kg, 1 kg
RAKU-TOOL® PH-3905	6 x 0.5 kg

Storage

Original containers should be kept tightly sealed and stored at ambient temperatures (15°C to 30°C) (59-86 °F).
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.

RAMPF Group, Inc.
49037 Wixom Tech Drive
Wixom, MI 48393
T +1 248. 295.0223
F +1 248. 295.0224
E info.us@rampf-group.com
www.rampf-group.com