RAKU® TOOL



PF-3700-2 / PH-3977, AC-9004

Fast Cast Resin

Two component polyurethane system, processable filled or unfilled

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Key Properties

- Unfilled, very low viscosity

• Fast cure and short demold time

- Good heat resistance
- Improved moisture resistance
- High fill rate possible
- · Very high strength

- Foundry patterns, core boxes, negatives, pattern plates
- Checking casts
- Copy models

Applications

- Thermoforming tools
- Cutting jigs for prototype parts

Processing Properties

		Unit	PF-3700-2	PH-3977	AC-9004
Color	visual		opaque	yellowish	white
Mix ratio		pbw	100	100	-
Mix ratio		pbw	100	100	300
Mix ratio		pbv	100	86	-
Density	ISO 1183	g/cm³	ca. 0.95	ca. 1.10	ca. 2.40
Viscosity at 25 °C	DIN 53019-1	mPa·s	80 - 90	30 - 50	-

		Unit	PF-3700-2 / PH-3977	PF-3700-2 / PH-3977 AC-9004
Pot life at 25 °C	1000 ml	min	3 - 4	4 - 5
Max. layer thickness		mm	10	60
Demold time		min	60	90

Cured / Mechanical Properties

Cure		Unit	PF-3700-2 / PH-3977 7 days at RT or 14h at 40°C	PF-3700-2 / PH-3977 AC-9004 7 days at RT or 14h at 40°C
Color		visual	white	beige
Density	ISO 1183	g/cm³	ca. 1.10	ca. 1.60
Hardness	ISO 868	Shore D	70 - 75	75 - 80
Deflection temperature, HDT	ISO 75	°C	50 - 60	60 - 70
Compressive strength	ISO 604	MPa	40 - 50	50 - 60
Compressive modulus	ISO 604	MPa	1,000 - 1,100	3,400 - 3,500
Flexural strength	ISO 178	MPa	30 - 40	40 - 50
Linear shrinkage*		mm/m	-	ca. 1.50

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Processing

The processing temperature 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.

The fillers should first be mixed into the individual A and B components, ensuring that the two components have roughly the same viscosity. This allows for easier and better mixing of the two components afterwards. With a bit of practice it is possible to mix small quantities of unfilled A and B and then add the filler without the pot life being too short for the casting process.

Packaging	
RAKU® TOOL PF-3700-2	20 kg, 4,5 kg, 6 x 1 kg
RAKU® TOOL PH-3977	20 kg, 4,5 kg, 6 x 1kg
RAKU® TOOL AC-9004	1.000 kg, 20 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.

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Our recommendations on the use of the material are based on many years of experience and current scientific and practical knowledge. They are, however, provided without any obligation on our part and do not relieve the buyer of the need for suitability tests. They do not constitute a legal relationship, nor are any protected third party rights whatsoever affected thereby. The technical data sheet is not a specification, but contains only approximate values.