



PP-3311 / PH-3905

Adhesive for working boards

Room temperature curing, two component polyurethane

Key Properties

- Color matched to board WB-1222
- Excellent flow properties and easy gap filling
- High strength and good adhesion
- Fast cure at RT

Applications

- Bonding of working boards

Processing Properties

		Unit	PP-3311	PH-3905
Color	visual		green	light brown
Mix ratio		pbw	100	50
Density	DIN 2811-1	g/cm ³	ca. 1.16	ca. 1.23

		Unit	PP-3311 / PH-3905
Pot life at 25 °C	500 ml	min	5 - 8
Minimum curing time	25°C	h	4

Cured / Mechanical Properties

		Unit	PP-3311 / PH-3905
Cure			7 days at RT or 14h at 40°C
Color		visual	green
Density	ISO 1183	g/cm ³	ca. 1.20
Hardness	ISO 868	Shore D	75 - 80
Coefficient of thermal expansion	ISO 11359	10 ⁻⁶ K ⁻¹	80 - 90
Deflection temperature, HDT	ISO 75	°C	50 - 55
Glass transition temperature, Tg	DSC	°C	45 - 50
Compressive strength	ISO 604	MPa	48 - 53
Flexural strength	ISO 178	MPa	55 - 60
Flexural modulus	ISO 178	MPa	1,800 - 2,000



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Processing

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

Mix the two components thoroughly in the ratio indicated and apply to both sides of the surface to be bonded.

Packaging

RAKU® TOOL PP-3311	1 kg
RAKU® TOOL PH-3905	0,5 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.