

Key Properties

- Hand cast
- Low moisture sensitivity
- Long pot life

Applications

- Structural molds
- Impact protection parts
- Holding fixtures / jigs
- Production of flexible parts

Processing Properties

		Unit	PC-3413-1	PH-3923
Color	visual		opaque	yellowish
Mix ratio		pbw	100	45
Mix ratio		pbv	100	40
Density	DIN 2811-1	g/cm ³	ca. 1.02	ca. 1.21
Viscosity at 25 °C	DIN 53019-1	mPa·s	950 - 1,000	100 - 150

		Unit	PC-3413-1 / PH-3923
Mix viscosity at 25 °C	DIN 53019-1	mPa·s	850 - 900
Pot life at 25 °C	1000 ml	min	20 - 25
Max. layer thickness		mm	100
Demold time		h	14

Cured / Mechanical Properties

		Unit	PC-3413-1 / PH-3923
Cure			7 days at RT or 14h at 40°C
Color		visual	opaque
Density	ISO 1183	g/cm ³	ca. 1.11
Hardness	ISO 868	Shore A	77 - 82
Tensile strength	ISO 527	MPa	8 - 12
Elongation at break	ISO 527	%	250 - 400
Tear strength	DIN 53515		15 - 20
Abrasion	Taber	mm ³ /100R	30 - 40



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.

Mix the two components thoroughly in the ratio indicated.

Degassing and / or post curing will improve final properties.

Packaging	
RAKU® TOOL PC-3413-1	25 kg, 5 kg
RAKU® TOOL PH-3923	5 kg

Storage

Original containers should be kept tightly sealed and stored at ambient temperatures (20°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.