RAKU® TOOL



PP-3314 / PH-3905

Adhesive for working boards

Room temperature curing, two component polyurethane

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Key Properties

- Color matched to board WB-1404
- 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-3314 | PH-3905 |
|-----------|------------|-------|----------|-------------|
| Color | visual | | olive | light brown |
| Mix ratio | | pbw | 100 | 50 |
| Density | DIN 2811-1 | g/cm³ | ca. 1.16 | ca. 1.23 |

| | | Unit | PP-3314 / PH-3905 |
|---------------------|--------|------|-------------------|
| Pot life at 25 °C | 500 ml | min | 5 - 8 |
| Minimum curing time | 25°C | h | 4 |

Cured / Mechanical Properties

| Cure | | Unit | PP-3314 / PH-3905 7 days at RT or 14h at 40°C |
|----------------------------------|-----------|-----------|--|
| Color | | visual | olive |
| Density | ISO 1183 | g/cm³ | ca. 1.20 |
| Hardness | ISO 868 | Shore D | 75 - 80 |
| Coefficient of thermal expansion | ISO 11359 | 10^-6K^-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-3314 | 1 kg |
| RAKU® TOOL PH-3905 | 0,50 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.