# RAKU<sup>®</sup> TOOL VA-1505



## **VA-1500 / Black**

# 50 shore A polyurethane elastomer

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#### **Key Properties**

- Excellent physical properties after RT cure
- Free of mercury, MOCA or TDI
- Excellent green strength for quick demold times

#### **Applications**

• For hand-batch processing

### **Processing Properties**

			Resin (Isocyanate)	Hardener (Polyol)
Mix ratio		pbw	40	100
		pbv	37	100
Density	ASTM D-792	g/cm <sup>3</sup>	ca. 1.18	ca. 1.08
Viscosity at 77°F (25°C)	ASTM D-2393	сР	ca. 1,250	ca. 600

			Mixture
Mix viscosity at 77°F (25°C)	ASTM D-2393	cР	ca. 900
Gel time at 77°F (25°C)		min	4-6
Demold time at 77°F (25°C)		min	30-60

### **Cured / Mechanical Properties (approximate values)**

Cure 1: 24 hours at 77°F + 1 hour at 150°F Cure 2: 7 days at 77°F			Cure 1	Cure 2
Aspect	visual		Black	Black
Density	ASTM D-792	g/cm <sup>3</sup>	1.08	1.08
Shore hardness A	ASTM D-2240		45-55	45-55
Tensile strength	ASTM D-638	psi	350	370
Elongation at Break	ASTM D-638	%	160	150
Tear strength	ASTM D-624	pli	40	40
Linear shrinkage	ASTM D-2566	in/in	0.001-0.003	0.001-0.003

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#### **Processing**

The processing and material temperature should be between 68-77°F (20-25°C).

For best results, de-air the material prior to casting, then pressurize to 60 psi until cured.

The hardener contains black pigment.

Agitate Hardener and Resin before mixing to ensure a homogenous formulation.

#### **Packaging**

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VA-1505 Quart Kit	2.8 lbs.
VA-1505 1 Gal. Kit	11.2 lbs.
VA-1505 5 Gal. Kit	56 lbs.
VA-1505 Drum Kit	630 lbs.

#### **Storage**

Original containers should be kept tightly sealed and stored at ambient temperatures 59-86°F (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.

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 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.