

## Urethane Adhesive

Low viscosity

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### Key Properties

- Good flow and easy application
- Room temperature cure
- Quick setting
- Low viscosity, easy to mix and spread

### Applications

- Adhesive for board bonding

### Processing Properties

			PP-3364 Polyol	PH-3964 Isocyanate
Color	visual		Light Green	Light Brown
Mix ratio		parts by weight	100	100
Density	ASTM D-792	g/cm <sup>3</sup>	ca. 0.87	ca. 0.87
Viscosity at 77°F (25°C)	ASTM D-2393	cP	1500 - 3000	1500 - 3000

### Processing

				PP-3364 / PH-3964
Mix viscosity at 25°C		ASTM D-2393	cP	1500 - 3000
Minimum Curing Time	at 25°C		hr	20 - 24
Working life	at 25°C	100 ml	min	15 - 25
	at 25°C	500 ml	min	10 - 15
Hardness	8hrs at 25°C	ASTM D-2240	Shore D	50 - 60

### Cured / Physical Properties

Cure: 24 hours at 25°C				PP-3364 / PH-3964
Appearance	visual			Light Green
Density	ASTM D-792	g/cm <sup>3</sup>		ca. 0.85
Hardness	ASTM D-2240	Shore D		55 - 65

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### **Processing**

Both PP-3364 and PH-3964 will settle in the can during storage and need to be mixed thoroughly with spatula until uniform before use.

Mix the two components thoroughly in the ratio indicated. The physical properties are only obtained after material fully cures.

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### **Packaging**

RAKU® TOOL PP-3364	2.4 kg
RAKU® TOOL PH-3964	2.4 kg

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### **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.

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### **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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