

**RAKU® TOOL**  
**PP-3323-1 RGIC-600 / PH-3905**



**RAMPF®**  
 discover the future

**Polyurethane Paste**  
 Adhesive for Working Boards

**Key Properties**

- Good flow and easy application
- Rigid and good adhesion
- RT curing

**Applications**

- Color matched for bonding WB-1258
- Bonding of working boards

**Processing Properties**

				Polyol	Isocyanate
Aspect	visual			Orange	Brown
Mix Ratio		pbw		100	50
		pbv		100	47
Density	ASTM D-792	g/ml		1.16	1.23
				Mixture	
Mix Viscosity at	25°C (77°F)	ASTM D-2393	cP	50,000-70,000	
Pot Life			min	12-15	
Minimal Curing Time	@ 77°F (25°C)		hour	1-2	

**Cured / Mechanical Properties**

				Cure 1	Cure 2
Cure 1:	<b>7 days @ 77°F (25°C)</b>				
Cure 2:	<b>14h @ 104°F (40°C)</b>				
Aspect	visual			Orange	Orange
Density	ASTM D-792	g/ml		1.20	1.20
Density	ASTM D-792	lb/ft <sup>3</sup>		75	75
Shore D Hardness	ASTM D-2240			75-80	75-80
HDT at 66psi	ASTM D-638	°F(°C)		122-131 (50-55)	122-131 (50-55)
Flexural Strength	ASTM D-790	psi		8,350	8,350
Flexural Modulus	ASTM D-790	psi		276,000	276,000
Compressive Strength	ASTM D-695	psi		7,350	7,350
CTE from	77-131°F (25-55°C)	ASTM D-696	10 <sup>-6</sup> /K	80-90	80-90
DSC Tg	ASTM D-7426	°F (°C)		113-122 (45-50)	113-122 (45-50)

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**Processing**

The processing and material temperature should be between 68-77°F (20-25°C). Mix the two components thoroughly in the ratio indicated and apply to both sides of the surface to be bonded.

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**Packaging**

Quart Kit	3.3	lbs.	1.5	kg
1 Gal. Kit	13.2	lbs.	6.0	kg

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**Storage**

Original containers should be kept tightly sealed and stored at ambient temperatures 59-86°F (15-30°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 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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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.