

Key Properties

- Hand cast
- Components are nontoxic

Applications

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

Processing Properties

| | | Unit | PC-3412 | PH-3923 |
|--------------------|-------------|-------------------|-----------|-----------|
| Color | visual | | opaque | yellowish |
| Mix ratio | | pbw | 100 | 17 |
| Mix ratio | | pbv | 100 | 15 |
| Density | DIN 2811-1 | g/cm ³ | ca. 1.06 | ca. 1.21 |
| Viscosity at 25 °C | DIN 53019-1 | mPa·s | 550 - 600 | 100 - 150 |

| | | Unit | PC-3412 / PH-3923 |
|------------------------|-------------|-------|-------------------|
| Mix viscosity at 25 °C | DIN 53019-1 | mPa·s | 400 - 500 |
| Pot life at 25 °C | 1000 ml | min | 2 - 3 |
| Pot life at 25 °C | 250 ml | min | 8 - 10 |
| Pot life at 45 °C | 250 ml | min | 2 - 3 |
| Max. layer thickness | | mm | 100 |
| Demold time | | h | 14 |

Cured / Mechanical Properties

| | | Unit | PC-3412 / PH-3923 |
|-------------------------------------|-----------|-----------------------|-------------------|
| Cure 7 days at RT or 14h at 40°C | | | |
| Color | | visual | opaque |
| Density | ISO 1183 | g/cm ³ | ca. 1.10 |
| Hardness | ISO 868 | Shore A | 35 - 40 |
| Tensile strength | ISO 527 | MPa | 1.5 - 3.5 |
| Elongation at break | ISO 527 | % | 300 - 450 |
| Tear strength | DIN 53515 | | 2 - 4 |
| Abrasion | Taber | mm ³ /100R | 20 - 30 |



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-3412 | 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.