

Key Properties

- Filled, easy to pour
- Low shrinkage
- Very accurate reproduction of finest patterns and details

Applications

- Structural molds for formwork, concrete molds
- Plastic molds for the ceramics industry e.g. wash basin, sinks

Processing Properties

		Unit	PC-3406-1	PH-3906
Color	visual		gray	colorless
Mix ratio		pbw	100	80
Mix ratio		pbv	100	108
Density	ISO 1183	g/cm ³	ca. 1.40	ca. 1.04
Viscosity at 25 °C	DIN 53019-1	mPa·s	1,800 - 2,000	5,800 - 6,000

		Unit	PC-3406-1 / PH-3906
Mix viscosity at 25 °C	DIN 53019-1	mPa·s	5,600 - 5,900
Pot life at 25 °C	1000 ml	min	15 - 20
Demold time		h	12

Cured / Mechanical Properties

		Unit	PC-3406-1 / PH-3906 7 days at RT or 14h at 40°C
Cure			
Color		visual	gray
Density	ISO 1183	g/cm ³	ca. 1.24
Hardness	ISO 868	Shore A	50 - 55
Tensile strength	ISO 527	MPa	2 - 3
Elongation at break	ISO 527	%	800 - 1,000
Tear strength	DIN 53515		8 - 10



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.

Packaging

RAKU® TOOL PC-3406-1	25 kg
RAKU® TOOL PH-3906	20 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.