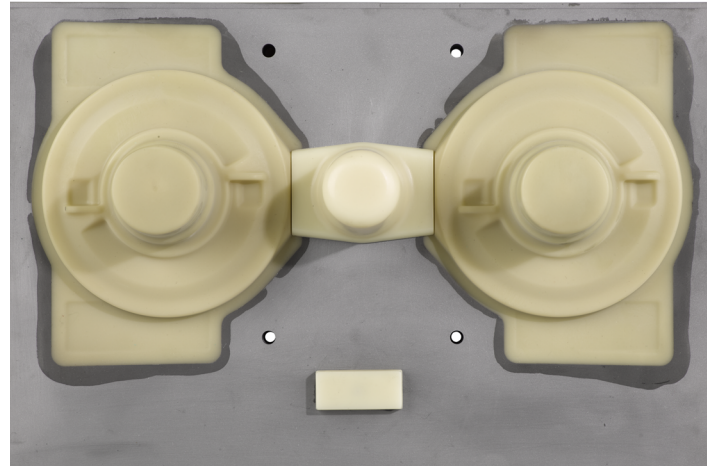
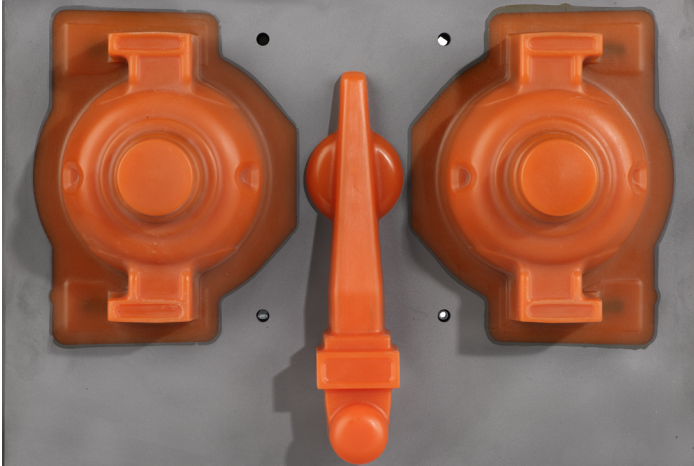


Invented. Perfected.

The RAKU-TOOL® Three Component Face Casting System



Objective / application:

Manufacture of pattern plates for medium and large series production

Production process - Pattern plate (upper part):

- > Master model milled from RAKU-TOOL® MB-0670
- > Negative produced in lay-up with RAKU-TOOL® EG-2102 / EL-2209-1 / EC-2401 + AC-9005 / wooden frame
- > Base plate milled from steel
- > Milling of 2 x backing structure (insert) from aluminum with a -5 mm offset
- > Assembly of pattern plate, backing structure and negative for face casting
- > Face casting with RAKU-TOOL® PC-3459 / PH-3958
- > Production and assembly of gating system

Production process - Pattern plate (lower part):

- > Master model milled from RAKU-TOOL® MB-0720
- > Negative produced in lay-up with RAKU-TOOL® EG-2101 / EL-2209-1 / PC-3414 + AC-9005 / wooden frame
- > Base plate milled from steel
- > Milling of 2 x backing structure (insert) from aluminum with a -5 mm offset
- > Face casting with RAKU-TOOL® PC-3458 / PH-3958
- > Production and assembly of gating system

RAMPF Tooling Solutions Products:

RAKU-TOOL® PC-3458 / PH-3958

- > The original: „orange“ and highly abrasion resistant
- > Can be put into operation the next day
- > The only system with a 95 °C heat deflection temperature (HDT-B)
- > Hand casting up to approx. 25 kg possible
- > Proven, more than 170,000 parts produced

RAKU-TOOL® PC-3459 / PH-3958

- > The established: „beige“
- > Can be put into operation after 5 – 7 days RT cure
- > Heat deflection temperature (HDT-B) 65 °C
- > Hand casting up to approx. 110 kg possible
- > Proven, more than 80,000 parts produced

Key benefits:

- > Suitable for large series production
- > Very high dimensional stability and accuracy of foundry core box (metal support)
- > High number of parts can be produced due to the excellent abrasion resistance
- > When wear limit has been reached, the front casting layer can be refaced (cost reduction for maintenance / reconditioning)
- > Excellent resistance to chemicals, no swelling
- > No / minimal sand adhesion

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. No liability accepted for misprints.

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