

**RAKU® TOOL**  
**PP-3323-1 RGIC-742 / PH-3905**



**Polyurethane Paste**  
 Adhesive for Working Boards

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Page 1 of 2

**Key Properties**

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

**Applications**

- Color matched for bonding WB-1223
- Bonding of working boards

**Processing Properties**

|                     |               |             | Polyol  | Isocyanate    |
|---------------------|---------------|-------------|---------|---------------|
| Aspect              | visual        |             | Red     | 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                      |                    | Red                 | Red             |
| 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           |
| DSC Tg               | ASTM D-7426                 | °F (°C)            | 113-122 (45-50)     | 113-122 (45-50) |

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Page 2 of 2

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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.