

## Casting System

Two component Polyurethane

### Key Properties

- Can be cast in thick layers
- Low exothermic reaction in thick layers
- Superior interlayer adhesion
- Easily repaired or modified
- Can be filled additionally

### Applications

- Backing casting of models, molds, negatives and general support aids
- Direct casting of foundry patterns
- Jigs

### Processing Properties

			PC-3414	PH-3915
Color	visual		Beige	Amber
Mix ratio		pb weight	100	20
		pb volume	100	29
Density	ISO 1183	g/cm <sup>3</sup>	ca. 1.79	ca. 1.24
Viscosity at 25 °C	DIN 53019-1	mPa·s	30,000-50,000	150-200

			PC-3414 / PH-3915
Mix viscosity at 25 °C	DIN 53019-1	mPa·s	2,000 – 3,000
Pot life at 25 °C	1000 ml	min	60-75
Max. layer thickness		mm	100
Demouldable after		h	14

### Cured / Mechanical Properties

#### Cure: 7 days at RT or 14 h at 40 °C

			PC-3414 / PH-3915
Appearance	visual		Beige
Density	ISO 1183	g/cm <sup>3</sup>	ca. 1.70
Shore hardness D	ISO 868		85
Deflection temperature, HDT	ISO 75	°C	50-55
Compressive strength	ISO 604	MPa	80-85
Compressive modulus	ISO 604	MPa	5,300-5,800
Flexural strength	ISO 178	MPa	45-50
Flexural modulus	ISO 178	MPa	6,300-6,800
Linear shrinkage*		mm / m	1.4

\*measured on maximum layer thickness as stated above

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### Processing

**The processing 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 carefully avoiding any air entrapment.

Degassing and /or post-curing will improve final properties.

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### Packaging

RAKU-TOOL® PC-3414	10 kg
RAKU-TOOL® PH-3915	2 kg

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### Storage

In temperature controlled environments (20 °C - 25 °C) the original containers can be stored for at least 6 months. Both components are moisture sensitive and containers therefore need to be kept tightly sealed. The storage temperature for the hardener should not be below 20 °C as at 15 °C it might crystallize.

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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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