

# RAKU-TOOL® PE-3803 (Polyol) / PH-3905 (Isocyanate)



## Polyurethane Foaming System

Two component, liquid foam

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PC - Rev.-Status: 01- 2015/07/09

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### Key Properties

- Fast reactivity
- Good flow properties
- Fast cure

### Applications

- Production of rigid molded parts

### Processing Properties

			PE-3803 Polyol	PH-3905 Isocyanat
Color	visual		Clear	Amber
Mix ratio		parts by weight	100	100
		parts by volume	100	83
Density	ISO 1183	g/cm <sup>3</sup>	ca. 1.03	ca. 1.24
Viscosity at 25 °C	DIN 53019-1	mPa·s	600-700	150-200

			PE-3803 / PH-3905
Cream time at RT	200g	seconds	180-220
Gel time	200g	min	12-13
Tack-free after	200g	min	30-35

### Cured / Mechanical Properties

Cure: 3 h at RT			PE-3803 / PH-3905
Appearance	visual		Beige
Specific weight		g/l	ca. 100-120

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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. Due to the short processing time, the system is generally processed using a two component mixing and metering machine. The recommended material temperature **must** be observed. Too high or low a material temperature will change the viscosity (high/low) and have a direct influence on the mixing ratio set up on the machine. Changes in the mixing ratio will result in faults in the finished part.

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#### Packaging

RAKU-TOOL® PE-3803 Polyol	25 kg
RAKU-TOOL® PH-3905 Isocyanate	25 kg

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#### 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.

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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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