

RAKU-TOOL®
PC-3410, PC-3411, PC-3459 (Resin)
PH-3911-1, PH-3958 (Isocyanate)



Polyurea Casting System

Two component polyurea (Shore A40-A95)

Processing properties

			PC-3410	PC-3411	PC-3459
Color			Black	Black	Beige
Density	ISO 1183	g/cm ³	ca. 1.09	ca. 1.20	ca. 1.18
Viscosity at 25 °C	DIN 53019-1	mPa·s	1,300 – 1,800	500 – 600	100-150

			PH-3911-1	PH-3958
Color			Yellowish	Clear
Density	ISO 1183	g/cm ³	ca. 1.06	ca. 1.02
Viscosity at 25 °C	DIN 53019-1	mPa·s	4,000 – 4.500	12,000-13,000

PC-3410, PC-3411, PC-3459 (Resin) and PH-3911-1, PH-3958 (Isocyanate) can be mixed to obtain a Shore hardness between A40 and A95.

	Mix ratio (parts by weight)								
	100	75	65	25					
PC-3410	100	75	65	25					
PC-3411		3	3.5	7.5	10				
PC-3459						100	100	100	100
PH-3911-1	300	250	225	150	100	352	222	175	
PH-3958						88	148	175	250
Color	Black	Black	Black	Black	Black	Beige	Beige	Beige	Beige
Shore A	40	50	55	65	80	85	90	95	
Shore D				20	30	32	50	55	55-65
Pot life at 25 °C, 1000 ml (min)	45-50	40-45	40-45	40-45	30-35	15-20	15-20	15-20	15-20

Cure: 7 days at RT or 14h at 40°C

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Processing

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.

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

The processing and material temperature should be between 20-25 °C.

Packaging

RAKU-TOOL® PC-3410	5 kg
RAKU-TOOL® PC-3411	2 kg
RAKU-TOOL® PC-3459	2 kg
RAKU-TOOL® PH-3911-1	5 kg, 20 kg
RAKU-TOOL® PH-3958	5 kg, 25 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.
