

RAKU-TOOL® for the Foundry Industry



Build-up method	RAKU-TOOL Products	Models	Negatives	Pattern Plates	Core Boxes	approx. number of parts that can be produced (dependent on the forming process)							Key Property		
						<500	<1000	<5000	>10000	>20000	>50000	>100000			
Full Casting	Polyurethane Fastcast	PF-3701-2/PH-3977/AC-9004		•	•									Fast cure	
	Polyurethane Casting System	PC-3414/PH-3915		•	•									Little shrinkage	
	Epoxy Casting System	EC-2402/EH-2905-1			•	•									Hard, workable surface
		EC-2400/EH-2952-1			•	•									High resistance to chemicals
Face Casting	Polyurethane Fastcast	PF-3701-2/PH-3977		•	•									Fast cure	
	Epoxy Casting System	EC-2402/EH-2904-1			•	•									Hard, workable surface
		EC-2400/EH-2909			•	•									High resistance to chemicals
	Polyurea Casting System	PC-3459/PH-3958			•	•									High impact strength
PC-3458/PH-3958				•	•									High temperature resistance 90–95 °C HDT, high impact strength	
Surfaces for lay-up techniques	Epoxy Gelcoat	EG-2101/EH-2950-1		•										Easy to sand, good resistance to chemicals	
		EG-2103/EH-2903-1			•	•								Hard, workable surface	
	Polyurea Gelcoat	EG-2102/EH-2950-1			•	•									Good chemical resistance
		PG-3159/PH-3958			•	•									High impact strength
Milling	Modeling Board	MB-0670	•											Easily shaped by hand	
		MB-0720	•		•									Excellent surface structure	
	Working Board	WB-0801		•	•	•									Low coefficient of thermal expansion
		WB-1001	•		•										Also available in beige (WB-1000)
		WB-1460			•	•									Fine surface structure
		WB-1404			•	•									Low coefficient of thermal expansion
		WB-1222			•	•									Foundry standard
		WB-1250			•	•									Excellent chip formation
		WB-1258			•	•									Very high abrasion resistance whilst good dimensional stability and accuracy
* CCC & CB only available in Europe	Close Contour Casting (CCC)* / Close Contour Block (CB)*	CC-6010/CB-6010	•		•									Excellent surface structure	
		CC-6504/CB-6504	•	•	•	•								Low coefficient of thermal expansion	
		CC-6507/CB-6507			•	•									Mechanical properties like WB-1404
Backfilling for lay-up techniques															
	Epoxy Coupling Coat	EL-2209-1/EH-2950-1		•	•	•									
	Polyurethane Casting System	PC-3414/PH-3915/AC-9005		•	•	•									
		PC-3403/PH-3903/AC-9004		•	•	•									
	Epoxy Casting System	EC-2401/EH-2904-1/AC-9005		•	•	•									
	Epoxy Laminating System	EL-2200/EH-2900		•	•	•									
Epoxy Laminating Paste	EL-2207-2/EH-2907-2		•	•	•										

The indicated number of parts are dependent on the respective forming process and part geometry and are not binding.

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.

3-3-004/5EN. Errors excepted. Subject to change.