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RAKU-TOOL®PG-3104 Resin / PH-3954 Isocyanate
Gelcoat System
Two component Polyurea

Key Properties

- High wear resistance
- High impact resistance
- Both components are without skull and crossbones label

Applications

- Foundry patterns
- Pattern plates
- Core boxes
- Impact protection

Processing Properties

			PG-3104 Resin	PH-3954 Isocyanate
Color	visual		Green	Yellowish
Mix ratio		parts by weight	100	100
Density	ISO 1183	g/cm^3	1.32	1.09

			PG-3104 / PH-3954
Pot life at 25 °C	250 ml	min	20 - 25
Demold time		h	16

Cured / Mechanical Properties

Cure: 7 days at RT or 14h at 40°C			PG-3104 / PH-3954
Appearance	visual		Green
Density	ISO 1183	g/cm^3	1.22
Shore hardness D	ISO 868		60 - 65
Abrasion	Taber	mm³/100R	35 – 40

Processing

The processing and material temperature should be between 20-25 ºC.
Mix the two components thoroughly in the ratio indicated.
Apply in thin layers with a brush.
Wait until gelcoat has gelled, but ensure that it is still slightly tacky before proceeding.
Post curing will improve final properties.

Packaging	
RAKU-TOOL® PG-3104	6 x 0.2 kg, 5.0 kg
RAKU-TOOL® PH-3954	6 x 0.2 kg, 5.0 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.

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