

#### Key Properties

- Hand cast
- Components are nontoxic

#### Applications

- Structural molds
- Assembly jigs
- Impact protection parts
- Production of flexible parts
- Holding fixtures / jigs

#### Processing Properties

		Unit	PC-3412	PH-3923
Color	visual		opaque	yellowish
Mix ratio		pbw	100	17
Mix ratio		pbv	100	15
Density	ISO 1183	g/cm³	ca. 1.06	ca. 1.21
Viscosity at 25 °C	DIN 53019-1	mPa·s	550 - 600	100 - 150

		Unit	PC-3412 / PH-3923
Mix viscosity at 25 °C	DIN 53019-1	mPa·s	400 - 500
Pot life at 25 °C	1000 ml	min	2 - 3
Pot life at 25 °C	250 ml	min	8 - 10
Pot life at 45 °C	250 ml	min	2 - 3
Max. layer thickness		mm	100
Demold time		h	14

#### Cured / Mechanical Properties

		Unit	PC-3412 / PH-3923
Cure			7 days at RT or 14h at 40 °C
Color		visual	opaque
Density	ISO 1183	g/cm³	ca. 1.10
Hardness	ISO 868	Shore A	35 - 40
Tensile strength	ISO 527	MPa	1.5 - 3.5
Elongation at break	ISO 527	%	300 - 450
Tear strength	DIN 53515	N/mm	2 - 4
Abrasion	Taber	mm³/100R	20 - 30



## Processing

The processing temperature 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.

Degassing and / or post curing will improve final properties.

## Packaging

RAKU® TOOL PC-3412	5 kg
RAKU® TOOL PH-3923	5 kg

## Storage

Original containers should be kept tightly sealed and stored at ambient temperatures (20°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.