

#### Key Properties

- High abrasion resistance
- High impact resistance

#### Applications

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

#### Processing Properties

		Unit	PG-3159-1	PH-3958
Color	visual		green	colorless
Mix ratio		pbw	100	125
Density	DIN 2811-1	g/cm <sup>3</sup>	ca. 1.53	ca. 1.02

		Unit	PG-3159-1 / PH-3958
Pot life at 25 °C	250 ml	min	20 - 25
Demold time		h	16

#### Cured / Mechanical Properties

		Unit	PG-3159-1 / PH-3958 7 days at RT or 14h at 40°C
Cure			
Color		visual	green
Density	ISO 1183	g/cm <sup>3</sup>	ca. 1.20
Hardness	ISO 868	Shore D	55 - 60
Abrasion	Taber	mm <sup>3</sup> /100R	35 - 40



## Processing

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

Mix the two components thoroughly in the ratio indicated.

Apply in thin layers with a brush. Wait until the gelcoat has gelled, but ensure that it is still slightly tacky before proceeding.

Post curing will improve final properties.

Packaging	
RAKU® TOOL PG-3159-1	0,8 kg
RAKU® TOOL PH-3958	1,0 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.