## RAKU<sup>®</sup> TOOL RC-0210



# High Impact/Polypropylene/Fast/Black

Tough, impact resistant elastomer

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Key Properties	Applications	
• Excellent physical properties after RT cure	<ul> <li>Formulated for room temperature meter dispensing systems and short mold cycl</li> </ul>	
<ul> <li>Free of mercury, MOCA or TDI</li> </ul>		

## **Processing Properties**

			Resin (Isocyanate)	Hardener (Polyol)
Mix ratio		pbw	100	89
		pbv	100	100
Density	ASTM D-792	g/cm <sup>3</sup>	ca. 1.20	ca. 1.07
Viscosity at 77°F (25°C)	ASTM D-2393	cP	ca. 500	ca. 1,000

			Mixture
Mix viscosity at 77°F (25°C)	ASTM D-2393	cP	ca. 900
Gel time at 77°F (25°C)		sec	50-70
Demold time at 77°F (25°C)		min	10-15

### **Cured / Mechanical Properties (approximate values)**

Cure 1: 24 hours at 77°F + 16 hours at 150°F Cure 2: 7 days at 77°F		Cure 1	Cure 2	
Aspect	visual		Black	Black
Density	ASTM D-792	g/cm <sup>3</sup>	1.05	1.05
Shore hardness D	ASTM D-2240		75-85	75-85
Deflection temperature, HDT (66psi)	ASTM D-648	°F (°C)	149 (65)	140 (60)
Tensile strength	ASTM D-638	psi	6,500	6,700
Tensile modulus	ASTM D-638	psi	250,000	300,000
Elongation at Break	ASTM D-638	%	5	5
Flexural strength	ASTM D-790	psi	7,500	8,700
Flexural modulus	ASTM D-790	psi	165,000	175,000
Notched Izod	ASTM D-256	ft∙lbf/in	2.6	3.0
Linear shrinkage	ASTM D-2566	in/in	0.001-0.005	0.001-0.005

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#### Processing

The processing and material temperature should be between 68-77°F (20-25°C).

To ensure an adequate mix has been established during meter mixing this material, it is recommended that a  $3/8 \times 40$  mix tube is used.

The components can be freeze when stored or shipped in temperatures below 32°F. In the event your system freezes, call your RAMPF Group Inc. representative to discuss reconstitution methods.

Agitate the hardener and resin before use to ensure that the formula is homogeneous.

Packaging	
RC-0210 Quart Kit	3.78 lbs.
RC-0210 1 Gal. Kit	15.12 lbs.
RC-0210 5 Gal. Kit	75.60 lbs.
RC-0210 Drum Kit	850.5 lbs.

#### Storage

Original containers should be kept tightly sealed and stored at ambient temperatures 59-86°F (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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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.