RAKU[®] TOOL InnoFR[™] FX-8091



Flame Extinguish 90A

Flexible polyurethane system

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Key Properties

- Excellent physical properties
- Free of mercury, MOCA or TDI
- UL94 V-0 certified

Applications

Formulated for room temperature hand-batch systems

Processing Properties

			Resin (Isocyanate)	Hardener (Polyol)
NA' well a		pbw	55	100
Mix ratio		pbv	51	100
Density	ASTM D-792	g/cm ³	ca. 1.30	ca. 1.20
Viscosity at 77°F (25°C)	ASTM D-2393	сР	ca. 320	ca. 1,180

			Mixture
Mix viscosity at 77°F (25°C)	ASTM D-2393	сР	ca. 1,180
Gel time at 77°F (25°C)		min	10-15
Demold time at 77°F (25°C)		h	2-4

Cured / Mechanical Properties (approximate values)

Cure 1: 7 days at 77°F (25°C)	Cure 1		
Aspect	visual		White
Density	ASTM D-792	g/cm ³	1.29
Shore hardness A	ASTM D-2240		85-95
Tensile strength	ASTM D-638	psi	1,400
Elongation at Break	ASTM D-638	%	125
Tear strength	ASTM D-624	pli	160
Linear shrinkage	ASTM D-2566	in/in	0.001-0.005

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Processing

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

For best results, de-air the material prior to casting, then pressurize to 60 psi until cured. The resin contains a filler which will settle from solution. It is important that it must be shaken **before** each use.

To reduce demold times cast into preheated molds and place the filled tool in an oven set to 150°F (66°C). Remove the mold from heat and allow to cool for fifteen minutes prior to demold. Post curing of this material will not advance cured properties any further than the 7 day numbers indicated.

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

Packaging	ging		
FX-8091 Quart Kit	3.1 lbs.		
FX-8091 1 Gal. Kit	12.4 lbs.		
TV 0004 F Cal I/it	62 lbs		

FX-8091 5 Gal. Kit 62 lbs. FX-8091 Drum Kit 697.5 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.

RAMPF Group, Inc. 49037 Wixom Tech Drive Wixom, MI 48393 T +1 248. 295.0223 F +1 248. 295.0224 E info.us@rampf-group.com 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.