RAKU[®] TOOL RC-0255



Rapid Cast / Rigid / Black

Tough, impact resistant elastomer

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Key Properties

- Excellent physical properties after RT cure
- Free of mercury, MOCA or TDI

Applications

 Formulated for room temperature meter-mix dispensing systems and short mold cycle times

Processing Properties

			Resin (Isocyanate)	Hardener (Polyol)
N dia natio		pbw	100	84
Mix ratio		pbv	100	100
Density	ASTM D-792	g/cm ³	ca. 1.26	ca. 1.05
Viscosity at 77°F (25°C)	ASTM D-2393	сР	ca. 150	ca. 1,700

			Mixture
Mix viscosity at 77°F (25°C)	ASTM D-2393	cР	NA
Gel time at 77°F (25°C)		sec	50-70
Demold time at 77°F (25°C)		min	20-30

Cured / Mechanical Properties (approximate values)

Cure 1: 24 hours at 77°F Cure 2: 7 days at 77°F			Cure 1	Cure 2
Aspect	visual		Black	Black
Density	ASTM D-792	g/cm ³	1.05	1.05
Shore hardness D	ASTM D-2240		70-80	75-85
Deflection temperature, HDT (66psi)	ASTM D-648	°F (°C)	184 (84)	194 (90)
Tensile strength	ASTM D-638	psi	7,000	8,000
Tensile modulus	ASTM D-638	psi	195,000	230,000
Elongation at Break	ASTM D-638	%	19	10
Flexural strength	ASTM D-790	psi	11,000	13,000
Flexural modulus	ASTM D-790	psi	260,000	300,000
Notched Izod	ASTM D-256	ft-lbf/in	1.0	1.0
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).

This product will separate upon storage.

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

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RC-0255 Quart Kit	3.68 lbs.
RC-0255 1 Gal. Kit	14.72 lbs.
RC-0255 Gal. Kit	73.60 lbs.
RC-0255 Drum Kit	828 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.