# RAKU<sup>®</sup> TOOL VA-1905

# VA-1900 / Black

90 shore A polyurethane elastomer

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<ul><li>Key Properties</li><li>Excellent physical properties after RT cure</li></ul>	<ul> <li>Applications</li> <li>For hand-batch processing, vacuum assisted processing or meter mix dispensed</li> </ul>	

- Free of mercury, MOCA or TDI
- Excellent green strength for quick demold times

## **Processing Properties**

			Resin (Isocyanate)	Hardener (Polyol)
Ndia antin		pbw	100	100
Mix ratio		pbv	95	100
Density	ASTM D-792	g/cm <sup>3</sup>	ca. 1.16	ca. 1.10
Viscosity at 77°F (25°C)	ASTM D-2393	cP	ca. 900	ca. 1,100

			Mixture
Mix viscosity at 77°F (25°C)	ASTM D-2393	cP	ca. 1,100
Gel time at 77°F (25°C)		min	4-6
Demold time at 77°F (25°C)		min	30-60

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

Cure 1: 24 hours at 77°F + 1 hour 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>	1.10	1.10
Shore hardness A	ASTM D-2240		85-95	85-95
Tensile strength	ASTM D-638	psi	1,200	1,250
Elongation at Break	ASTM D-638	%	75	65
Tear strength	ASTM D-624	pli	140	130
Linear shrinkage	ASTM D-2566	in/in	0.002-0.005	0.002-0.005





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#### Processing

The processing and material temperature should be between 68-77°F (20-25°C). For best results, place the poured tool into a pressure vessel and pressurize to 60 psi until cured. Black pigment has been added to the hardener and will settle out of solution. Agitate Hardener and Resin before mixing to ensure a homogenous formulation.

### Packaging

VA-1905 Quart Kit	4 lbs.	
VA-1905 1 Gal. Kit	16 lbs.	
VA-1905 5 Gal. Kit	80 lbs.	
VA-1905 Drum Kit	900 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 **WWW.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.