RAKU[®] TOOL InnoTuf[®] HP-2185

Density

Viscosity at 77°F (25°C)

Mix viscosity at 77°F (25°C)

Demold time at 77°F (25°C)

Gel time at 77°F (25°C)



ca. 1.06

ca. 350

Mixture ca. 3,300

20-30

4-6

High Performance 85A

Tough, abrasion resistant elastomer

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Key Properties	Applicatio	ons	
Excellent physical properties after RT cure	 For room temperature hand-mix processing methods 		x processing
Free of mercury, MOCA or TDI	method	5	
Processing Properties			
		Resin (Isocyanate)	Hardener (Polyol)
Mix ratio	pbw	Resin (Isocyanate) 100	Hardener (Polyol) 34

g/cm³

сΡ

cР

min

h

ASTM D-792

ASTM D-2393

ASTM D-2393

ca. 1.08

ca. 7,100

Cured / Mechanical Properties (approximate values)

Cure 1: 7 days at 77°F Cure 2: 24 hours at 77°F + 5 hours at 150°F			Cure 1	Cure 2
Aspect	visual		Amber	Amber
Density	ASTM D-792	g/cm ³	1.08	1.08
Shore hardness A	ASTM D-2240		80-90	80-90
Tensile strength	ASTM D-638	psi	2,800	3,000
Elongation at break	ASTM D-638	%	520	460
Tear Strength	ASTM D-624	pli	320	300
Split tear	ASTM D-470		105	105
Taber abrasion*	ASTM D-4060	mg loss	9	9
Linear shrinkage	ASTM D-2566	in/in	0.003-0.006	0.003-0.006

*H-18 wheel, 1000g load, 1000 cycles

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Processing

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

The hardener component will darken as it ages. It is recommended that dry nitrogen be used to blanket the material to prevent oxidization and from becoming moisture contaminated.

Both the hardener and resin will freeze when exposed to temperatures below 32°F. If this occurs, place containers in an oven at 120°F, agitating every 45 minutes until the materials are re-liquefied. It is important to note that temperatures exceeding the recommended heating conditions or failure to agitate will cause excessive localized heat and potentially damage the product.

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

Packaging		
HP 2185 Quart Kit	2.68 lbs.	
HP 2185 1 Gal. Kit	10.72 lbs.	
HP 2185 5 Gal. Kit	53.6 lbs.	
HP 2185 Drum Kit	603 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.