





RAKU® TOOL Boards	RAKU® TOOL SB-0064		RAKU® TOOL SB-0096		RAKU® TOOL SB-0130		RAKU® TOOL SB-0160		RAKU® TOOL SB-0240
Styling and Design with RAKU® TOOL									
Color	beige		light green		light yellow		light gray		light green
Density (ISO 1183) lb/ft³ (ca.)	4.0		6.0		8.0		10.0		15.0
Applications	<ul style="list-style-type: none"> > Design studies > CNC program checking > Substructures for tooling pastes > Negative molds for casting 		<ul style="list-style-type: none"> > Design studies > CNC program checking > Substructures for tooling pastes > Negative molds for casting 		<ul style="list-style-type: none"> > Design studies > CNC program checking > Substructures for tooling pastes > Negative molds for casting 		<ul style="list-style-type: none"> > Design studies > CNC program checking > Substructures for tooling pastes > Negative molds for casting 		<ul style="list-style-type: none"> > Styling models > Epoxy laminating molds > Substructures for tooling pastes > Negative molds for casting
Key Properties	<ul style="list-style-type: none"> > Very light weight with good surface > Easily shaped > Good heat resistance > Resistant to organic solvents 		<ul style="list-style-type: none"> > Very light weight and smooth surface > Easily shaped, minimal dust > Excellent heat resistance > Good dimensional stability > Resistant to organic solvents 		<ul style="list-style-type: none"> > Light weight with smooth surface > Easily machined, minimal dust > Excellent heat resistance > Good dimensional stability > Resistant to organic solvents 		<ul style="list-style-type: none"> > Excellent surface structure > Easily machined, minimal dust > Excellent heat resistance > Good dimensional stability > Resistant to organic solvents 		<ul style="list-style-type: none"> > Excellent surface structure > Easily machined, minimal dust > High edge definition > Excellent heat resistance > Good dimensional stability > Resistant to organic solvents
Hardness (ISO 868) Shore D	-		-		-		-		-
Coefficient of thermal expansion (ISO 11359) in/in/°Fx10⁻⁶	-		-		-		-		33 – 39
Glass transition temperature Tg °F	-		-		203 – 212		203 – 212		203 – 212
Deflection temperature (ISO 75) °F	-		-		-		-		-
Compressive strength (ISO 604) psi	73 – 116		73 – 145		218 – 290		290 – 440		290 – 580
Flexural strength (ISO 178) psi	-		-		-		290 – 440		580 – 870
Dimensions in	96x24x [2, 4, 6, 8] 96x48x [2, 4, 6, 8] Other thicknesses are available.		96x24x [2, 4, 6] 96x48x [2, 3, 4, 6, 8, 10, 12, 14] Other thicknesses are available.		96x24x [2, 4, 6, 8] 96x48x [2, 4, 6, 8, 10, 12, 14, 16] Other thicknesses are available.		96x24x [2, 4, 6, 8] 96x48x [1, 2, 4, 6, 8, 10, 12, 16] Other thicknesses are available.		96x24x [2, 4, 6, 8] 96x48x [1, 2, 3, 4, 6, 8, 10, 12] Other thicknesses are available.
Bonding with RAKU® TOOL	> PE-3804	> PF-3708 / PH-3978	> PE-3804	> PF-3708 / PH-3978	> PE-3804	> PF-3708 / PH-3978	> PE-3804	> PF-3708 / PH-3978	> PP-3364 / PH-3964
Mixing ratio (pbw)	1 part	100 : 100	1 part	100 : 100	1 part	100 : 100	1 part	100 : 100	100 : 100
Color	beige	beige	beige	beige	beige	beige	beige	beige	light green
Pot life 500 ml (min.)	5 – 10	4 – 5	5 – 10	4 – 5	5 – 10	4 – 5	5 – 10	4 – 5	10 – 15
Minimum curing time (h)	2 – 4	0.5 – 1	2 – 4	0.5 – 1	2 – 4	0.5 – 1	2 – 4	0.5 – 1	20 – 24
Repair with RAKU® TOOL	Repair with adhesive bonded inserts		Repair with adhesive bonded inserts		> EP-2305 / EH-2936-2		> EP-2305 / EH-2936-2		> EP-2305 / EH-2936-2
Mixing ratio (pbw)					100 : 50		100 : 50		100 : 50
Color					apricot		apricot		apricot
Pot life 100 ml (min.)					15 – 20		15 – 20		15 – 20
Minimum curing time (min)					90 – 120		90 – 120		90 – 120
SB = Styling Board MB = Modeling Board WB = Working Board. Special sizes available on request.									



RAKU® TOOL Boards	RAKU® TOOL SB-0320	RAKU® TOOL SB-0451	RAKU® TOOL SB-0470	RAKU® TOOL SB-0497
Styling and Design with RAKU® TOOL				
Color	apricot	apricot	apricot	brown
Density (ISO 1183) lb/ft³ (ca.)	20.0	28.1	29.3	31.0
Applications	> Styling models > Master models and data control models > Epoxy laminating molds	> Styling models > Master models and data control models > Epoxy laminating molds	> Styling models > Master models and data control models > Epoxy laminating molds	> Styling models > Master models > Data control models > Epoxy laminating molds
Key Properties	> Excellent surface structure > Easily machined, minimal dust > High edge definition > Excellent heat resistance > Good dimensional stability > Resistant to organic solvents	> Excellent surface structure > Easily machined, minimal dust > High edge definition > Excellent heat resistance > Good dimensional stability > Resistant to organic solvents	> Excellent surface structure > Easily machined, minimal dust > High edge definition > Excellent heat resistance > Good dimensional stability > Resistant to organic solvents	> Excellent surface structure > Easily machined, minimal dust > High edge definition > Excellent heat resistance > Good dimensional stability > Resistant to organic solvents
Hardness (ISO 868) Shore D	–	–	–	–
Coefficient of thermal expansion (ISO 11359) in/in/°F x 10⁻⁶	33 – 39	33 – 39	33 – 36	33 – 39
Glass transition temperature Tg °F	203 – 212	203 – 212	203 – 212	203 – 212
Deflection temperature (ISO 75) °F	–	–	–	–
Compressive strength (ISO 604) psi	730 – 1,020	1,450 – 2,176	1,450 – 2,176	1,450 – 2,176
Flexural strength (ISO 178) psi	870 – 1,200	1,450 – 2,176	1,450 – 2,176	2,176 – 2,901
Dimensions in	96x24x [2, 4, 6, 8] 96x48x [1, 2, 3, 5, 8]	96x24x [2, 4, 6, 8] 96x48x [2, 4, 6, 8]	59.1x19.7x [2, 3.9, 5.9, 7.9]	96x48x [1, 2, 3, 4, 6]
Bonding with RAKU® TOOL	> EP-2305 / EH-2904-1	> EP-2305 / EH-2904-1	> EP-2305 / EH-2904-1	> EP-2306 / EH-2904-1
Mixing ratio (pbw)	100 : 30	100 : 30	100 : 30	100 : 30
Color	apricot	apricot	apricot	brown
Pot life 500 ml (min.)	25	25	25	35
Minimum curing time (h)	16	16	16	16
Repair with RAKU® TOOL	> EP-2305 / EH-2936-2	> EP-2305 / EH-2936-2	> EP-2305 / EH-2936-2	> EP-2306 / EH-2936-2
Mixing ratio (pbw)	100 : 50	100 : 50	100 : 50	100 : 50
Color	apricot	apricot	apricot	brown
Pot life 100 ml (min.)	15 – 20	15 – 20	15 – 20	15 – 20
Minimum curing time (min)	90 – 120	90 – 120	90 – 120	90 – 120
SB = Styling Board MB = Modeling Board WB = Working Board. Special sizes available on request.				

3-3-001/16US. 1/2. Errors excepted. Subject to change.

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RAKU® TOOL Boards	RAKU® TOOL MB-0600 	RAKU® TOOL MB-0670 	RAKU® TOOL MB-0720 	RAKU® TOOL WB-0691	RAKU® TOOL WB-0700
	Modeling with RAKU® TOOL			Tool Making with RAKU® TOOL	
Color	brown	brown	brown	blue	light green
Density (ISO 1183) lb/ft³ (ca.)	37.5	41.8	45.0	43.1	43.8
Applications	> Master & cubing models > Patterns	> Master & cubing models > Patterns	> Master & cubing models > Patterns	> Lay-up tools for low temperature tooling prepregs > Vacuum forming molds > Medium temperature applications	> Lay up tools for prepreg > High temperature applications > Vacuum forming molds
Key Properties	> Superior surface structure > Easily shaped and machined > Low coefficient of thermal expansion > Good dimensional stability	> Superior surface structure > Easily shaped and machined > Low coefficient of thermal expansion > Good dimensional stability	> Superior surface structure > Low coefficient of thermal expansion > Good dimensional stability > Good compressive and flexural strength	> Prestine surface quality > Excellent machinability > Excellent dimensional stability > Heat resistant up to 230°F	> Prestine surface quality > Very easily machined > Excellent dimensional stability > Heat resistant up to 266 °F
Hardness (ISO 868) Shore D	50 – 55	60 – 65	60 – 65	70 – 75	70 – 75
Coefficient of thermal expansion (ISO 11359) in/in/°Fx10⁻⁶	28 – 31	28 – 31	28 – 31	19 – 25	19 – 25
Glass transition temperatuer Tg °F	–	–	–	248 – 266	–
Deflection temperature (ISO 75) °F	158 – 167	167 – 176	167 – 176	212 – 230	266 – 284
Compressive strength (ISO 604) psi	2,200 – 2,900	2,200 – 2,900	2,900 – 3,600	7,300 – 8,700	8,700 – 10,100
Flexural strength (ISO 178) psi	2,200 – 2,900	2,900 – 3,600	3,600 – 4,400	3,600 – 5,100	5,800 – 7,250
Dimensions in	59.1x19.7x [1, 2, 3, 3.9, 5.9, 7.9]	59.1x19.7x [1, 2, 3, 3.9, 5.9]	59.1x19.7x [1, 2, 3, 3.9, 5.9, 7.9]	59.1x19.7x [2, 3, 3.9, 5.9] 60x24x [2, 3, 4, 6]	59.1x19.7x [2, 3, 3.9, 5.9, 7.9]
Bonding with RAKU® TOOL	> EP-2306 / EH-2904-1	> EP-2306 / EH-2904-1	> EP-2306 / EH-2904-1	> EP-2303 / EH-2934-1	> EP-2304 / EH-2934-1
Mixing ratio (pbw)	100 : 30	100 : 30	100 : 30	100 : 20	100 : 20
Color	brown	brown	brown	blue	light green
Pot life 500 ml (min.)	35	35	35	50 – 60	50 – 60
Minimum curing time (h)	16	16	16	16	16
Repair with RAKU® TOOL	> EP-2306 / EH-2936-2	> EP-2306 / EH-2936-2	> EP-2306 / EH-2936-2	> EP-2303 / EH-2936-2	> EP-2304 / EH-2936-2
Mixing ratio (pbw)	100 : 50	100 : 50	100 : 50	100 : 50	100 : 50
Color	brown	brown	brown	blue	light green
Pot life 100 ml (min.)	15 – 20	15 – 20	15 – 20	15 – 20	15 – 20
Minimum curing time (min)	90 – 120	90 – 120	90 – 120	90 – 120	90 – 120
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RAKU® TOOL Boards	RAKU® TOOL WB-0890	RAKU® TOOL WB-0801 	RAKU® TOOL WB-1223	RAKU® TOOL WB-1258 	RAKU® TOOL WB-1700		
Tool Making with RAKU® TOOL							
Color	dark blue	gray	red	orange	dark gray		
Density (ISO 1183) lb/ft³ (ca.)	56	49.9	76.3	74.9	106.0		
Applications	> Lay-up tools for low temperature tooling prepregs > Vacuum forming molds > Medium temperature applications	> Master models > Cubing models > Tooling jigs and fixtures > Vacuum forming tools	> Foundry pattern plates > Hammer tools > Checking fixtures for metal parts	> Pattern plates > Core boxes	> Metal forming tools > Vacuum forming molds, jigs > Foam molds, rapid prototyping molds		
Key Properties	> Prestine surface quality > Excellent machinability > Excellent dimensional stability > Heat resistant up to 212 °F	> Excellent surface structure > High HDT and very low CTE > Excellent dimensional stability > Good compressive and flexural strength	> Low wear of milling tools > Resistant to amine > Most proven working board on the foundry market > Resistant to dry ice cleaning > Good abrasion resistance	> Superior abrasion resistance whilst good dimensional stability and accuracy > Homogeneous surface > High impact strength, good edge strength > Very easily machined > Excellent resistance to chemicals, no swelling	> Superior surface structure > Polishable > Easily machined > High temperature resistance > Excellent compressive strength > High abrasion resistance		
Hardness (ISO 868) Shore D	75 – 80	65 – 70	75 – 85	80 – 85	85 – 90		
Coefficient of thermal expansion (ISO 11359) in/in/°F x 10⁻⁶	19 – 25	25 – 28	44 – 47	39 – 42	25 – 28		
Glass transition temperatuer Tg °F	–	–	–	158 – 167	–		
Deflection temperature (ISO 75) °F	212 – 230	185 – 194	176 – 194	–	248 – 257		
Compressive strength (ISO 604) psi	8,700 – 10,200	5,800 – 6,500	8,700 – 10,000	13,100 – 14,500	18,000 – 19,000		
Flexural strength (ISO 178) psi	5,800 – 7,300	5,100 – 5,800	10,000 – 12,000	14,500 – 16,000	11,000 – 12,000		
Dimensions in	59.1x19.7x [2, 3, 3.9, 5.9] in	59.1x19.7x [1, 2, 3, 3.9, 5.9]	60x24x [1.2, 2, 3, 4]	39.4x19.7x [1.2, 2, 3, 3.9]	29.5x19.7x [2, 3.9]		
Bonding with RAKU® TOOL	> EP-2303 / EH-2934-1	> EL-2210 / EH-2910-1*	> PP-3358 / PH-3905	> PP-3323 / PH-3905	> PP-3358 / PH-3905	> PP-3323 / PH-3905	> EL-2210 / EH-2910-1*
Mixing ratio (pbw)	100 : 20	100 : 60	100 : 50	100 : 50	100 : 50	100 : 50	100 : 60
Color	blue	transparent	red	red	orange	orange	transparent
Pot life 500 ml (min.)	50 – 60	60	5 – 8	40 – 50	5 – 8	40 – 50	60
Minimum curing time (h)	16	16	4	8	4	8	16
Repair with RAKU® TOOL	> EP-2303 / EH-2936-2	Repair with adhesive bonded inserts	> PP-3358 / PH-3905		> PP-3358 / PH-3905		Repair with adhesive bonded inserts
Mixing ratio (pbw)	100 : 50		100 : 50		100 : 50		
Color	blue		red		orange		
Pot life 100 ml (min.)	15 – 20		5 – 8 (500 ml)		5 – 8 (500 ml)		
Minimum curing time (min)	90 – 120		240		240		

SB = Styling Board | MB = Modeling Board | WB = Working Board. * Different mix ratios for special mixtures see technical data sheet.  Eco-friendly.

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