






# RAKU® TOOL for the Foundry Industry

Build-up method		RAKU® TOOL Products	Models	Negatives	Pattern Plates	Core Boxes	approx. number of parts that can be produced (dependent on the forming process)							Key Property
							<500	<1000	<5000	>10000	>20000	>50000	>100000	
Full Casting	Polyurethane Fastcast	PF-3701-2/PH-3977/AC-9004		•	•									Fast cure
	Polyurethane Casting System	PC-3414/PH-3915		•	•									Little shrinkage
	Epoxy Casting System	EC-2402/EH-2905-1			•	•								Hard, workable surface
		EC-2400/EH-2952-1			•	•								High resistance to chemicals
Face Casting	Polyurethane Fastcast	PF-3701-2/PH-3977		•	•									Fast cure
	Epoxy Casting System	EC-2402/EH-2904-1			•	•								Hard, workable surface
		PC-3459/PH-3958			•	•								High impact strength
	Polyurea Casting System	PC-3458/PH-3958			•	•								High temperature resistance 90–95 °C HDT, high impact strength
Surfaces for lay-up techniques		EG-2101/EH-2950-1		•										Easy to sand, good resistance to chemicals
	Epoxy Gelcoat	EG-2103/EH-2903-1			•	•								Hard, workable surface
		EG-2102/EH-2950-1			•	•								Good chemical resistance
	Polyurea Gelcoat	PG-3159-1/PH-3958			•	•								High abrasion resistance
Milling	Modeling Board	MB-0670 	•											Easily shaped and machined
		MB-0720 	•		•									Good dimensional stability
	Working Board	WB-0801 		•	•	•								Very low coefficient of thermal expansion
		WB-1000	•		•									Also available in gray (WB-1001)
		WB-1460 			•	•								Made out of recycling polyol
		WB-1404			•	•								Low coefficient of thermal expansion
		WB-1222			•	•								Most proven working board on the foundry market
		WB-1250 			•	•								Excellent amine and abrasion resistance
		WB-1258 			•	•								Very high abrasion resistance whilst good dimensional stability and accuracy
CCC & CB	Close Contour Casting (CCC)/	CC-6010/CB-6010	•		•									Excellent surface structure
	Close Contour Block (CB)	CC-6507/CB-6507			•	•								Mechanical properties like WB-1404
Backfilling for lay-up techniques														
	Epoxy Coupling Coat	EL-2209-2/EH-2950-1		•	•	•								
	Polyurethane Casting System	PC-3414/PH-3915		•	•	•								
		PC-3403/PH-3903/AC-9004		•	•	•								
	Epoxy Casting System	EC-2401/EH-2904-1		•	•	•								
	Epoxy Laminating System	EL-2200/EH-2900		•	•	•								
	Epoxy Laminating Paste	EL-2207-3/EH-2907-3		•	•	•								

**The indicated number of parts are dependent on the respective forming process and part geometry and are not binding.**

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. No liability accepted for misprints.

