

## PF-3701-2 / PH-3977, AC-9004

### Fast Cast Resin

Two component polyurethane system, processable filled or unfilled

#### Key Properties

- Fast cure and short demold time
- Unfilled, very low viscosity
- Excellent heat resistance
- Improved moisture resistance
- High fill rate possible
- Very high strength

#### Applications

- Foundry patterns, core boxes, negatives, pattern plates
- Checking casts
- Copy models
- Thermoforming tools
- Cutting jigs for prototype parts

#### Processing Properties

		Unit	PF-3701-2	PH-3977	AC-9004
Color	visual		opaque	yellowish	white
Mix ratio		pbw	100	100	-
Mix ratio		pbw	100	100	300
Density	DIN 2811-1	g/cm <sup>3</sup>	ca. 0.95	ca. 1.10	ca. 2.40
Viscosity at 25 °C	DIN 53019-1	mPa·s	115 - 130	30 - 50	-

		Unit	PF-3701-2 / PH-3977	PF-3701-2 / PH-3977 AC-9004
Pot life at 25 °C	1000 ml	min	5 - 6	6 - 7
Max. layer thickness		mm	20	80
Demold time		h	1	2

#### Cured / Mechanical Properties

		Unit	PF-3701-2 / PH-3977 7 days at RT or 14h at 40°C	PF-3701-2 / PH-3977 AC-9004 7 days at RT or 14h at 40°C
Cure				
Color		visual	white	beige
Density	ISO 1183	g/cm <sup>3</sup>	ca. 1.10	ca. 1.60
Hardness	ISO 868	Shore D	70 - 75	80 - 85
Deflection temperature, HDT	ISO 75	°C	60 - 70	70 - 80
Compressive strength	ISO 604	MPa	30 - 40	45 - 50
Compressive modulus	ISO 604	MPa	800 - 900	3,000 - 3,100
Flexural strength	ISO 178	MPa	30 - 40	35 - 45
Linear shrinkage*		mm/m	-	ca. 0.40



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**Processing**

The processing temperature and material temperature should be between 20-25°C.

The A component needs to be stirred well before use as some fillers might be prone to sedimentation.

The fillers should first be mixed into the individual A and B components, ensuring that the two components have roughly the same viscosity. This allows for easier and better mixing of the two components afterwards. With a bit of practice it is possible to mix small quantities of unfilled A and B and then add the filler without the pot life being too short for the casting process.

**Packaging**

RAKU® TOOL PF-3701-2	20 kg, 4,5 kg, 6 x 1 kg
RAKU® TOOL PH-3977	20 kg, 4,5 kg, 6 x 1 kg
RAKU® TOOL AC-9004	1.000 kg, 20 kg

**Storage**

Original containers should be kept tightly sealed and stored at ambient temperatures (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.