

## Board Material

### Polyurethane Board for Tools and Molds

#### Key Properties

- Low wear of milling tools
- Resistant to amine
- Most proven working board on the foundry market
- Resistant to dry ice cleaning
- Good abrasion resistance

#### Applications

- Foundry pattern plates
- Hammer tools
- Checking fixtures for metal parts

#### Mechanical Properties

		WB-1223	
Color	visual		Red
Density	ASTM D-792	g/cm <sup>3</sup> (lb/ft <sup>3</sup> )	ca. 1.22 (ca. 76.3)
Shore hardness D	ASTM D-2240		75 – 85
Coefficient of thermal expansion	ASTM D-3386	10 <sup>-6</sup> K <sup>-1</sup> (in/in/°F x 10 <sup>-6</sup> )	80 – 85 (44 – 47)
Deflection temperature, HDT	ASTM D-648	°C (°F)	80 – 90 (176 – 194)
Compressive strength	ASTM D-695	MPa (psi)	60 – 70 (8,700 – 10,000)
Flexural strength	ASTM D-790	MPa (psi)	70 – 80 (10,000 – 12,000)

#### Processing

The product should have a temperature of 20°C – 25°C (68-77°F) during processing.

#### Packaging

RAKU® TOOL WB-1223	1.2 x 20 x 40 in 2 x 24 x 60 in 3 x 24 x 60 in 4 x 24 x 60 in
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#### Storage

The material should be stored flat and in a dry place. Temperature variations should be avoided during storage and transportation.

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### **Handling Precautions**

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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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**For information on adhesives and repair pastes see the corresponding individual technical data sheets.**