RAKU[®] TOOL

WB-1250

Board material

Polyurethane Board for Molds and Tools

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Key Properties	Applications
 Easy to mill Low wear of milling tools Resistant to dry ice cleaning Excellent abrasion resistance Excellent amine resistance 	Foundry core boxesFoundry modelsFoundry pattern plates

Mechanical Properties

		Unit	WB-1250
Color		visual	light green
Density	ISO 1183	g/cm³	ca. 1.25
Hardness	ISO 868	Shore D	77 - 83
Coefficient of thermal expansion	ISO 11359	10^-6K^-1	70 - 75
Deflection temperature, HDT	ISO 75	°C	80 - 85
Compressive strength	ISO 604	MPa	70 - 80
Flexural strength	ISO 178	MPa	90 - 100
Abrasion	Taber	mm ³ /100R	65 - 70

Processing

The material should be processed at a temperature of $20^{\circ}C - 25^{\circ}C$.

Dimensions	
RAKU® TOOL WB-1250	1000 x 500 x 30 mm 1000 x 500 x 50 mm 1000 x 500 x 75 mm 1000 x 500 x100 mm

Storage

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

E tooling.solutions@rampf-group.com WWW.rampf-group.com





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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.

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

E tooling.solutions@rampf-group.com www.rampf-group.com 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. The technical data sheet is not a specification, but contains only approximate values.