

Board Material

Epoxy Board for Tools & Molds

Key Properties

- Very fine surface structure
- Excellent machinability
- Good dimensional stability
- Heat resistant up to 230°F

Applications

- Lay-up tools for low temperature tooling prepregs
- Vacuum forming molds
- Medium temperature applications

Mechanical Properties

			WB-0691
Color	visual		Blue
Density	ASTM D-792	g/cm ³ (lb/ft ³)	ca. 0.69 (ca. 43.1)
Shore hardness D	ASTM D-2240		70 – 75
Coefficient of thermal expansion	ASTM D-3386	10 ⁻⁶ K ⁻¹ (in/in/°F x 10 ⁻⁶)	35 – 45 (19 – 25)
Tg by DMA, E'	ASTM D-4065	°C (°F)	100 – 110 (212 – 230)
Tg by DMA, E''	ASTM D-4065	°C (°F)	120 – 130 (248 – 266)
Deflection temperature, HDT	ASTM D-648	°C (°F)	100 – 110 (212 – 230)
Compressive strength	ASTM D-695	MPa (psi)	50 – 60 (7,300 – 8,700)
Flexural strength	ASTM D-790	MPa (psi)	25 – 35 (3,600 – 5,100)
Tensile strength	ASTM D-638	MPa (psi)	15 – 20 (2,200 – 2,900)

Processing

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

Packaging

RAKU® TOOL WB-0691	1500 x 500 x 50 mm	(59.1 x 19.7 x 2.0 in)
	1500 x 500 x 75 mm	(59.1 x 19.7 x 3.0 in)
	1500 x 500 x 100 mm	(59.1 x 19.7 x 3.9 in)
	1500 x 500 x 150 mm	(59.1 x 19.7 x 5.9 in)
	1500 x 500 x 200 mm	(59.1 x 19.7 x 7.9 in)
	1524 x 610 x 50.8 mm	(60 x 24 x 2 in)
	1524 x 610 x 76.2 mm	(60 x 24 x 3 in)
	1524 x 610 x 101.6 mm	(60 x 24 x 4 in)
	1524 x 610 x 152.4 mm	(60 x 24 x 6 in)
	1524 x 610 x 203.2 mm	(60 x 24 x 8 in)

Storage

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

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 the corresponding individual technical data sheets.