RAKU[®] TOOL FM-7020

Rigid 25-30 PCF Foam

Rigid polyurethane foam

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Key Properties

• Excellent physical properties after RT cure

Applications

• For hand-batch and meter-mix dispensing methods

• Free of mercury, MOCA or TDI

Processing Properties

			Resin (Isocyanate)	Hardener (Polyol)
Mix ratio		pbw	100	97
		pbv	100	100
Density	ASTM D-792	g/cm ³	ca. 1.20	ca. 1.16
Viscosity at 77°F (25°C)	ASTM D-2393	сP	ca. 100	ca. 675

			Mixture
Mix viscosity at 77°F (25°C)	ASTM D-2393	cP	ca. 250
Cream time at 77°F (25°C)		sec	40-60
Rise time at 77°F (25°C)		sec	90-150
Tack Free time at 77°F (25°C)		sec	170-230
Demold time at 77°F (25°C)		min	5-15

Cured Properties

Cure 1: 7 days at 77°F			Cure 1
Aspect	visual		Light Tan
Density	ASTM D-792	g/cm ³	0.388-0.471
Density	ASTM D-792	lb/in ³	0.014-0.017
Density	ASTM D-792	lb/ft ³	25-30



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Processing

The processing and material temperature should be between 68-77°F (20-25°C).

FM-7020 can be dispensed using drill mixing methods. Use a high speed drill with a paint mixer attached and mix for ten seconds before pouring directly into the mold. Do not hand mix only, as the material does not receive the required shear and will not form the proper cell structure.

Agitate the hardener and resin before use to ensure that the formula is homogeneous.

Packaging	
FM-7020 Quart Kit	3.94 lbs.
FM-7020 1 Gal. Kit	15.76 lbs.
FM-7020 5 Gal. Kit	78.8 lbs.
FM-7020 Drum Kit	886.5 lbs.

Storage

Original containers should be kept tightly sealed and stored at ambient temperatures 59-86°F (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.

RAMPF Group, Inc. 49037 Wixom Tech Drive Wixom, MI 48393 T +1 248. 295.0223 F +1 248. 295.0224 E info@rampf-group.com www.rampf-group.com **www.rampf-gruppe.de** 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.