RAKU[®] TOOL FM-7204



Rigid Open-Cell 4 Pound Foam

Rigid 4 pound polyurethane foam

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Key PropertiesExcellent physical properties after RT cureFree of mercury, MOCA or TDI	 Applications For hand-batch and meter-mix proce Helmet inserts, structural castings an blanks 	•	
Processing Properties			

			Resin (Isocyanate)	Hardener (Polyol)
Mix rotio		pbw	100	88
Mix ratio		pbv	100	89
Density	ASTM D-792	g/cm ³	ca. 1.20	ca. 1.19
Viscosity at 77°F (25°C)	ASTM D-2393	cP	ca. 100	ca. 675

			Mixture
Mix viscosity at 77°F (25°C)	ASTM D-2393	сP	ca. 250
Cream time at 77°F (25°C)		sec	15-25
Rise time at 77°F (25°C)		sec	50-70
Tack Free time at 77°F (25°C)		sec	60-80
Demold time at 77°F (25°C)		min	5-15

Cured Properties (approximate value	es)
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Cure 1: 7 days at 77°F			Cure 1
Aspect	visual		Light Tan
Density	ASTM D-792	g/cm ³	0.040-0.080
Density	ASTM D-792	lb/in ³	0.020-0.025
Density	ASTM D-792	lb/ft ³	4-5

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Processing

The processing and material temperature should be between 68-77°F (20-25°C). Quicker demold times can be achieved by warming the tool. The recommended temperature is 120°F. Agitate the hardener before use to ensure that the formula is homogeneous.

Packaging		
FM-7204 Quart Kit	3.76 lbs.	
FM-7204 1 Gal. Kit	15.04 lbs.	
FM-7204 5 Gal. Kit	75.2 lbs.	
FM-7204 Drum Kit	846 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.