RAKU[®] TOOL IE-3025



Rigid polyurethane

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Key Properties	Applications	
Excellent physical properties after RT cure	 For room temperature hand-batch assisted casting methods 	or vacuum
 Free of mercury, MOCA or TDI 	Ū.	
 Very low mixed viscosity 		
Ideal for color-matching due to its neutral sen transparent appearance	ni-	

Contact your RAMPF Group Inc. representative to find out more about custom color-matching services.

Processing Properties

			Resin (Isocyanate)	Hardener (Polyol)
Mix ratio		pbw	100	94
Mix ratio		pbv	100	100
Density	ASTM D-792	g/cm ³	ca. 1.10	ca. 1.03
Viscosity at 77°F (25°C)	ASTM D-2393	cP	ca. 40	ca. 250

			Mixture
Mix viscosity at 77°F (25°C)	ASTM D-2393	cP	ca. 100
Gel time at 77°F (25°C)		min	2:30-3:30
Peak Exotherm	200gr	°F (°C)	240 (116)
Demold time at 77°F (25°C)		min	20-40

Cured / Mechanical Properties (approximate values)

Cure 1: 7 days at 77°F			Cure 1
Aspect	visual		Translucent
Density	ASTM D-792	g/cm ³	1.08
Shore hardness D	ASTM D-2240		65-75
Deflection temperature, HDT (66psi)	ASTM D-648	°F (°C)	131 (55)
Tensile strength	ASTM D-638	psi	4,500
Elongation at Break	ASTM D-638	%	11
Flexural strength	ASTM D-790	psi	7,800
Flexural modulus	ASTM D-790	psi	200,000
Notched Izod	ASTM D-256	ft-lbf/in	0.6
Linear shrinkage	ASTM D-2566	in/in	0.005-0.010



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70 Shore D Translucent

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PC - Rev.-Status: 01- 2016/07/01

Page 2 of 2

Processing

The processing and material temperature should be between 68-77°F (20-25°C). Formulated for hand-batch or vacuum assisted casting equipment. For best results, de-air the material prior to casting, then pressurize to 60 psi until cured.

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

Pack	aging
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IE-3025 Quart Kit	3.88 lbs.
IE-3025 1 Gal. Kit	15.52 lbs.
IE-3025 5 Gal. Kit	77.6 lbs.
IE-3025 Drum Kit	873 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.

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