RAKU[®] TOOL IE-3031



Rapid Demold / Rigid

Rigid polyurethane

© RAMPF Tooling Solutions GmbH & Co. KG

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

Page 1 of 2

Key Properties

- · Excellent physical properties after RT cure
- Free of mercury, MOCA or TDI
- Excellent green strength yielding enhanced demold characteristics
- Yields easy to paint surfaces requiring little preparation

Applications

• For room temperature hand-batch or meter-mix equipment

Processing Properties

			Resin (Isocyanate)	Hardener (Polyol)
NAin matic		pbw	100	91
Mix ratio		pbv	100	100
Density	ASTM D-792	g/cm ³	ca. 1.19	ca. 1.08
Viscosity at 77°F (25°C)	ASTM D-2393	cР	ca. 75	ca. 450

			Mixture
Mix viscosity at 77°F (25°C)	ASTM D-2393	cР	ca. 150
Gel time at 77°F (25°C)		min	1:30-2:30
Peak Exotherm	200gr	°F (°C)	260 (127)
Demold time at 77°F (25°C)		min	7:30-12:30

Cured / Mechanical Properties (approximate values)

Cure 1: 7 days at 77°F			Cure 1	
Aspect	visual		White	
Density	ASTM D-792	g/cm ³	1.08	
Shore hardness D	ASTM D-2240		70-80	
Deflection temperature, HDT (66psi)	ASTM D-648	°F (°C)	158 (70)	
Tensile strength	ASTM D-638	psi	5,000	
Elongation at Break	ASTM D-638	%	20	
Tensile modulus	ASTM D-638	psi	165,000	
Flexural strength	ASTM D-790	psi	10,200	
Flexural modulus	ASTM D-790	psi	270,000	
Notched Izod	ASTM D-256	ft-lbf/in	0.5	
Linear shrinkage	ASTM D-2566	in/in	0.001-0.005	

RAKU® TOOL IE-3031

Rapid Demold / Rigid

Rigid polyurethane





© RAMPF Tooling Solutions GmbH & Co. KG

Page 2 of 2

Processing

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

This product will slightly separate upon storage.

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

_					
Pa	^	ro		m	\sim
гα	·	na	ч	ш	ч

ı ackagırığ		
IE-3031 Quart Kit	3.82 lbs.	
IE-3031 1 Gal. Kit	15.28 lbs.	
IE-3031 5 Gal. Kit	76.4 lbs.	
IE-3031 Drum Kit	859.5 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.us@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.