

## Polyurethane Adhesive

One part moisture curing and expanding

### Key Properties

- Moisture activated one part polyurethane adhesive that expands during cure.
- No mixing required – apply directly from the package
- Low density when cured
- Room temperature curing activated by moisture
- Can be sanded, painted and worked with standard wood working tools
- Good adhesive properties
- Good stability against mechanical influences (vibration etc.)
- Can be used for both indoor and outdoor applications

### Applications

- For bonding lower density tooling boards, polystyrene and wood
- It is also useful on many other surfaces such as many plastics, metals and glass - we recommend you try a test piece to determine if RAKU-TOOL PE-3804 is suitable for your application when bonding these surfaces.

Raw Material Data			RAKU® TOOL PE-3804
Viscosity @ 25°C	ASTM D-2393	cP	5,500 – 7,500
Density	ASTM D-792	g/cm <sup>3</sup>	1.12 – 1.16

Physical Properties			
Working time when applied to moist surface		min	5-10
Clamping time before moving		h	2-4
Full strength		h	16-24

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### Processing

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The processing and material temperature should be between 20-25°C.

For shiny surfaces roughen the surface to give a better bonding surfaces.

All surfaces must be clean, dust free and tight fitting.

Dampen one of the mating surfaces by lightly spraying or wiping with a damp rag immediately before applying the adhesive. Take care to not saturate the surfaces.

Apply the adhesive to the dry surface (application rate is 15-20 grams/ft<sup>2</sup> – approximately ½ liquid ounce).

Clamp the surfaces making sure the pressure is evenly distributed across the surface (alternatively place heavy objects to apply pressure or for small pieces use rubber bands).

Remove any uncured adhesive with acetone or standard paint thinner. Once the adhesive is cured it should be removed mechanically.

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### Packaging

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RAKU® TOOL PE-3804

Case of 6 pint bottles (7.08 lbs), 1 gallon f-style plastic bottle (9.40 lbs),  
3.5 gallon metal pail (33 lbs)

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### Storage

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The material should be stored in a dry place and in the original tightly closed containers. Temperature variations should be avoided during storage and transportation. (not our normal storage guidelines)

Original containers should be kept tightly sealed and stored at ambient temperatures (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.

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### Handling Precautions

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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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