# RAKU<sup>®</sup> TOOL FM-7120



# Soft Open-Cell 20 Pound Foam

## Open-cell polyurethane foam

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<ul><li>Key Properties</li><li>Excellent physical properties after RT cure</li><li>Free of mercury, MOCA or TDI</li></ul>	<ul> <li>Applications</li> <li>For hand-batch and meter-mix dis</li> <li>Particularly suited for low volume rests, seat cushions, training aids, and more</li> </ul>	production of arm

### **Processing Properties**

			Resin (Isocyanate)	Hardener (Polyol)
Mix ratio		pbw	100	100
		pbv	100	100
Density	ASTM D-792	g/cm <sup>3</sup>	ca. 1.08	ca. 1.08
Viscosity at 77°F (25°C)	ASTM D-2393	cP	ca. 1,100	ca. 850

			Mixture
Mix viscosity at 77°F (25°C)	ASTM D-2393	cP	ca. 975
Cream time at 77°F (25°C)		sec	50-70
Rise time at 77°F (25°C)		sec	120-150
Tack Free time at 77°F (25°C)		min	5-7
Demold time at 77°F (25°C)		min	15-25

### **Cured Properties**

Cure 1: 7 days at 77°F			Cure 1
Aspect	visual		Off-white
Density	ASTM D-792	g/cm <sup>3</sup>	0.2878-0.3515
Density	ASTM D-792	lb/in <sup>3</sup>	.0104-0.0127
Density	ASTM D-792	lb/ft <sup>3</sup>	18-22

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#### Processing

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

FM-7120 can be dispensed using drill mixing methods. It is recommended that a drill mixer be used to minimize large air bubble formation and keep the cell structure small and uniform. If hand mixing without a drill mixer, the cell structure at the surface will be porous. If pigment has been added to the hardener component, it will separate during storage.

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

Packaging		
FM-7120 Quart Kit	4 lbs.	
FM-7120 1 Gal. Kit	16 lbs.	
FM-7120 5 Gal. Kit	80 lbs.	
FM-7120 Drum Kit	900 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.