# RAKU<sup>®</sup> TOOL InnoFR FX-8587

## **Rigid Polyurethane**

Flame Retardant 80D Clear



### **Key Properties**

•Free of Mercury, MOCA, TDI, and Halogens •Easily Pigmentable Applications •Roto-Casting

•Hand batch or vacuum assisted casting

### **Processing Properties**

				Isocyanate	Polyol
Aspect		visual		Clear	Clear
Mix Ratio			pbw	100	50
			pbv	100	56
Density		ASTM D-792	g/ml	1.15	1.02
Viscosity at	25°C (77°F)	ASTM D-2393	сР	1,000	1,000

			Mixture
Mix Viscosity at 25°C (77°F)	ASTM D-2393	сР	1,000
Gel Time at 25°C (77°F)		min	30-40
Demold Time at 25°C (77°F)		hour	6-8

### **Cured / Mechanical Properties**

Cure 1: 7 days @ 77°F (25°C)			Cured	
Aspect	visual		Clear	
Density	ASTM D-792	g/ml	1.10	
Shore D Hardness	ASTM D-2240		80	
HDT at 66psi	ASTM D-638	°F(°C)	47	
Tensile Strength	ASTM D-638	psi	10,200	
Elongation at Break	ASTM D-638	%	6.2	
Flexural Strength	ASTM D-790	psi	12,700	
Flexural Modulus	ASTM D-790	psi	313,000	
Linear Shrinkage	ASTM D-2566	in./in.	.00201	
Notched Izod	ASTM D-256	ft·lb/in	0.9	



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#### Processing

The processing and material temperature should be between 68-77°F (20-25°C). Agitation is required before mixing to ensure homogenization. For best results, de-gas the material prior to casting, then pressurize to 60psi until cured. It is recommended that a dry nitrogen blanket be used to blanket the stored material to prevent oxidation and moisture contamination.

Packaging					
1.5 Quart Kit	3	lbs.	1.36	kg	
1.5 Gal. Kit	12	lbs.	5.44	kg	
7.5 Gal. Kit	60	lbs.	27.21	kg	
1.5 Drum Kit	675	lbs.	306.12	kg	

### Storage

Original containers should be kept tightly sealed and stored at ambient temperatures 59-86°F (15-30°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 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 the be observed. Please take heed of the appropriate safety data sheets.

RAMPF Group, Inc. P.O. Box 930352 49037 Wixom Tech Dr Wixom, MI 48393-2066 T +1 248.295.0223 F +1 248.295.0224 E info@ramp-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 affecter thereby.

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