RAKU® TOOL PP-3323 RGIC-600 / PH-3905



Adhesive for working boards

Polyurethane Paste

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Key Properties

- Good flow and easy application
- Rigid and good adhesion
- RT curing

Applications

- Color matched adhesive for bonding WB-1258
- Bonding of working boards

Processing Properties

| | | | PP-3323 | PH-3905 |
|-----------|------------|---|---------------------|---------------------|
| Color | visual | | Orange | Brown |
| Mix ratio | | pb weight | 100 | 50 |
| Density | ASTM D-792 | lb/ft ³ (g/cm ³) | ca. 72.4 (ca. 1.16) | ca. 76.8 (ca. 1.23) |

| | | | PP-3323 / PH-3905 |
|-------------------------------------|--------|-----|-------------------|
| Pot life at 25 °C (77°F) | 500 ml | min | 40-50 |
| Minimal curing time at 25 °C (77°F) | | h | 8 |

Cured / Mechanical Properties

| Cure: 7 days at RT or 14h at 40°C | | | PP-3323 / PH-3905 | | |
|-----------------------------------|-------------|---|---------------------------------|--|--|
| Aspect | visual | | Orange | | |
| Density | ASTM D-792 | lb/ft³ (g/cm³) | ca. 74.9 (ca. 1.2) | | |
| Shore hardness D | ASTM D-2240 | | 75-80 | | |
| Coefficient of thermal expansion | ASTM D-3386 | 10 ⁻⁶ F ⁻¹ (10 ⁻⁶ K ⁻¹) | 44 – 50 (80-90) | | |
| Deflection temperature, HDT | ASTM D-648 | °F (°C) | 122-131 (50-55) | | |
| Glass Transition Temperature, Tg | DSC | °F (°C) | 113-122 (45-50) | | |
| Compressive strength | ASTM D-695 | psi (MPa) | 7,000 – 7,700 (48-53) | | |
| Flexural strength | ASTM D-790 | psi (MPa) | 8,000 - 8,700 (55-60) | | |
| Flexural modulus | ASTM D-790 | psi (MPa) | 261,000 – 290,000 (1,800-2,000) | | |

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Processing

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

Mix the two components thoroughly in the ratio indicated and apply to both sides of the surface to be bonded.

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|----|----|----------|---|--------|
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| RAKU [®] TOOL PP-3323 | 1 kg |
|--------------------------------|--------|
| RAKU® TOOL PH-3905 | 0.5 kg |

Storage

Original containers should be kept tightly sealed and stored at ambient temperatures (15°C to 30°C) (59-86 °F). 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.