

Adhesive for working boards

Polyurethane Paste

Key Properties

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

Applications

- Color matched adhesive for bonding working board WB-1250
- Bonding of working boards

Processing Properties

| | | | PP-3350 | PH-3905 |
|------------------------------|----------|-------------------|-------------------|----------|
| Color | visual | | Light green | Brown |
| Mix ratio | | parts by weight | 100 | 50 |
| Density | ISO 1183 | g/cm ³ | ca. 1.16 | ca. 1.23 |
| | | | PP-3350 / PH-3905 | |
| Pot life at 25 °C | 500 ml | min | 5-8 | |
| Minimum curing time at 25 °C | | h | 4 | |

Cured / Mechanical Properties

Cure: 7 days at RT or 14h at 40°C

| | | | PP-3350 / PH-3905 |
|----------------------------------|-----------|----------------------------------|-------------------|
| Aspect | visual | | Light green |
| Density | ISO 1183 | g/cm ³ | ca. 1.2 |
| Shore hardness D | ISO 868 | | 75-80 |
| Coefficient of thermal expansion | ISO 11359 | 10 ⁻⁶ K ⁻¹ | 80-90 |
| Deflection temperature, HDT | ISO 75 | °C | 50-55 |
| Glass Transition temperature, Tg | DSC | °C | 45-50 |
| Compressive strength | ISO 604 | MPa | 48-53 |
| Flexural strength | ISO 178 | MPa | 55-60 |
| Flexural modulus | ISO 178 | MPa | 1800-2000 |

Processing

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

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

Packaging

| | |
|--------------------|----------------|
| RAKU-TOOL® PP-3350 | 6 x 1 kg, 1 kg |
| RAKU-TOOL® PH-3905 | 6 x 0.5 kg |

Storage

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.

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.
