

## Board Material

### Polyurethane Board for Tools and Molds

#### Key Properties

- Easy to mill
- Low wear of milling tools
- Very good amine resistance
- Very good abrasion resistance
- Resistant to dry ice cleaning

#### Applications

- Foundry models
- Foundry pattern plates
- Foundry core boxes

#### Mechanical Properties

			WB-1250
Color	visual		Light Green
Density	ISO 1183	g/cm <sup>3</sup>	ca. 1.25
Shore hardness D	ISO 868		77 – 83
Coefficient of thermal expansion	ISO 11359	10 <sup>-6</sup> K <sup>-1</sup>	70 – 75
Deflection temperature, HDT	ISO 75	°C	80 – 85
Compressive strength	ISO 604	MPa	70 – 80
Flexural strength	ISO 178	MPa	90 – 100

#### Processing

The product should have a temperature of 20°C – 25°C during processing.

#### Packaging

RAKU® TOOL WB-1250	1000 x 500 x 30 mm
	1000 x 500 x 50 mm
	1000 x 500 x 75 mm
	1000 x 500 x 100 mm

#### Storage

The material should be stored flat and in a dry place. Temperature variations should be avoided during storage and transportation.

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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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**For information on adhesives and repair pastes see the corresponding individual technical data sheets.**