

TECHNICAL DATASHEET

Lijmset voor WB-1404



Adhesive for working boards

Polyurethane Paste

© RAMPF Tooling Solutions GmbH & Co. KG

PC - Rev.-Status: 01- 2014/07/01

Page 1 of 2

Key Properties

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

Applications

- Color matched adhesive for bonding WB-1404
- Bonding of working boards

Processing Properties

			PP-3314	PH-3905
Color	visual		Olive	Brown
Mix ratio		parts by weight	100	50
Density	ISO 1183	g/cm ³	ca. 1.16	ca. 1.23

			PP-3314 / 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-3314 / PH-3905
Aspect	visual		Olive
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-3314	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.
