

TECHNICAL DATASHEET

RAKU-TOOL® WB-1250



TOOLING

COMPOSITES

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 ³ | ca. 1.25 |
| Shore hardness D | ISO 868 | | 77 – 83 |
| Coefficient of thermal expansion | ISO 11359 | 10 ⁻⁶ K ⁻¹ | 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.

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.

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