

Adhesive for working boards

Polyurethane Paste

Key Properties

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

Applications

- Color matched adhesive for bonding WB-1223
- Bonding of working boards

Processing Properties

| | | | PP-3323 | PH-3905 |
|-------------------------------------|------------|---|---------------------|---------------------|
| Color | visual | | Red | 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 (104°F)

| | | | PP-3323 / PH-3905 |
|----------------------------------|-------------|---|-------------------------------|
| Aspect | visual | | Red |
| Density | ASTM D-792 | lb/ft ³ (g/cm ³) | 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) |

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.

Packaging

| | |
|--------------------|--------------------|
| RAKU® TOOL PP-3323 | 1 kg, 6 x 1 kg |
| RAKU® TOOL PH-3905 | 0.5 kg, 6 x 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.
