

# RAKU-TOOL® WB-1400

## Board Material

## Polyurethane Board for Tools and Molds

PC - Rev.-Status: 01- 2006/01/24

Page 1 of 2

**Key Properties**

- Dense surface structure
- Very easily machined
- Good dimensional stability
- Good abrasion resistance and impact strength

**Applications**

- Pattern plates and core boxes
- Machined negatives and positives
- Models, molds and tools
- Hammer forms

**Mechanical Properties**

			<b>WB-1400</b>
Color	visual		Olive
Density	ASTM D-790	g/cm <sup>3</sup> (lb/ft <sup>3</sup> )	1.40 (87.5)
Shore hardness D	ASTM D-2240		80 – 85
Coefficient of thermal expansion	ASTM D-3386	10 <sup>-6</sup> K <sup>-1</sup> (in/in/°F x 10 <sup>-6</sup> )	65 – 70 (36 – 39)
Deflection temperature, HDT	ASTM D-648	°C (°F)	80 – 90 (176 – 194)
Compressive strength	ASTM D-695	MPa (psi)	70 – 80 (10,000 – 11,000)
Flexural strength	ASTM D-790	MPa (psi)	80 – 90 (11,000 – 12,500)

**Processing**

The product should have a temperature of 20°C – 25°C (68-77°F) during processing.

**Packaging**

RAKU-TOOL® WB-1400

1000 x 500 x 50 mm  
 (39.4 x 19.7 x 2.0 in)  
 1000 x 500 x 75 mm  
 (39.4 x 19.7 x 3.0 in)  
 1000 x 500 x 100 mm  
 (39.4 x 19.7 x 3.9 in)

**Storage**

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

**RAKU-TOOL® WB-1400**

Board Material

Polyurethane Board for Tools and Molds

---

**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.

---

**Curbell Plastics is a proud supplier  
of Rampf® materials**

**CURBELL**  
CURBELL PLASTICS, INC.

Nationwide  
**1.888.CURBELL**  
[www.curbellplastics.com](http://www.curbellplastics.com)

RAMPF Group, Inc.  
P.O. Box 930352  
50714 Century Ct.  
Wixom, MI 48393-2066  
T: (248) 295-0223  
F: (248) 295-0224  
E: [info@rampf-tooling.com](mailto:info@rampf-tooling.com)

[www.raku-tool.com](http://www.raku-tool.com)

Our recommendations on the use of the material are based on many years of experience and current scientific and practical knowledge. They are, however, provided without any obligation on our part and do not relieve the buyer of the need for suitability tests. They do not constitute a legal relationship, nor are any protected third party rights whatsoever affected thereby.