

RAKU-TOOL® Boards	RAKU-TOOL SB-0064		RAKU-TOOL SB-0096		RAKU-TOOL SB-0130		RAKU-TOOL SB-0160	
Styling and Design with RAKU-TOOL								
Color	beige		aqua		light yellow		light gray	
Density (ISO 1183) g/cm <sup>3</sup>   lb/ft <sup>3</sup> (ca.)	0.064   <b>4.0</b>		0.096   <b>6.0</b>		0.13   <b>8.0</b>		0.16   <b>10.0</b>	
Applications	<ul style="list-style-type: none"> <li>&gt; Design studies</li> <li>&gt; CNC program checking</li> <li>&gt; Supporting structures for tooling pastes</li> <li>&gt; Negative mold for casting</li> </ul>		<ul style="list-style-type: none"> <li>&gt; Design studies</li> <li>&gt; CNC program checking</li> <li>&gt; Supporting structures for tooling pastes</li> <li>&gt; Negative mold for casting</li> </ul>		<ul style="list-style-type: none"> <li>&gt; Design studies</li> <li>&gt; CNC program checking</li> <li>&gt; Supporting structures for tooling pastes</li> <li>&gt; Negative mold for casting</li> </ul>		<ul style="list-style-type: none"> <li>&gt; Styling &amp; design models</li> <li>&gt; Data control models</li> <li>&gt; Supporting structures for Close Contour Paste</li> </ul>	
Key Properties	<ul style="list-style-type: none"> <li>&gt; Very light weight with good surface</li> <li>&gt; Easily shaped</li> <li>&gt; Good heat resistance</li> <li>&gt; Resistant to organic solvents</li> </ul>		<ul style="list-style-type: none"> <li>&gt; Very light weight with good surface</li> <li>&gt; Easily shaped</li> <li>&gt; Good heat resistance</li> <li>&gt; Resistant to organic solvents</li> </ul>		<ul style="list-style-type: none"> <li>&gt; Very light weight with good surface</li> <li>&gt; Easily shaped</li> <li>&gt; Good heat resistance</li> <li>&gt; Resistant to organic solvents</li> </ul>		<ul style="list-style-type: none"> <li>&gt; Light weight and smooth surface</li> <li>&gt; Easily shaped, low dust</li> <li>&gt; Resistant to organic solvents</li> </ul>	
Hardness (ISO 868) Shore D	-		-		-		-	
Coefficient of thermal expansion (ISO 11359) 10 <sup>-6</sup> K <sup>-1</sup>   in/in/°Fx10 <sup>-6</sup>	-		-		-		25 – 35   <b>14 – 19</b>	
Deflection temperature (ISO 75) °C   °F	-		-		-		-	
Compressive strength (ISO 604) MPa   psi	0.5 – 0.8   <b>72 – 116</b>		0.8 – 1.0   <b>116 – 145</b>		1.5 – 2   <b>217 – 290</b>		2 – 3   <b>290 – 440</b>	
Flexural strength (ISO 178) MPa   psi	-		-		-		2 – 3   <b>290 – 440</b>	
Dimensions mm   in	2 x 24 x 96 4 x 24 x 96 6 x 24 x 96 8 x 24 x 96 2 x 48 x 96 4 x 48 x 96 6 x 48 x 96 8 x 48 x 96 Other thicknesses are available.		2 x 24 x 96 4 x 24 x 96 6 x 24 x 96 8 x 24 x 96 2 x 48 x 96 4 x 48 x 96 6 x 48 x 96 8 x 48 x 96 Other thicknesses are available.		2 x 24 x 96 4 x 24 x 96 6 x 24 x 96 8 x 24 x 96 2 x 48 x 96 4 x 48 x 96 6 x 48 x 96 8 x 48 x 96 Other thicknesses are available.		2 x 24 x 96 4 x 24 x 96 6 x 24 x 96 8 x 24 x 96 2 x 48 x 96 4 x 48 x 96 6 x 48 x 96 8 x 48 x 96 Other thicknesses are available.	
Bonding with RAKU-TOOL	> PE-3804	> PF-3708/ PH-3978	> PE-3804	> PF-3708/ PH-3978	> PE-3804	> PF-3708/ PH-3978	> PE-3804	> PF-3708/ PH-3978
Mixing ratio (pbw)	1 part	100 : 100	1 part	100 : 100	1 part	100 : 100	1 part	100 : 100
Color	beige	beige	beige	beige	beige	beige	beige	beige
Pot life (min.)	5 – 10	4 – 5	5 – 10	4 – 5	5 – 10	4 – 5	5 – 10	4 – 5
Minimum curing time (h)	2 – 4	0.5 – 1	2 – 4	0.5 – 1	2 – 4	0.5 – 1	2 – 4	0.5 – 1
Repair with RAKU-TOOL								
Mix ratio (pbw)								
Color								
Pot life (min)								
Minimum curing time (min)								

SB = Styling Board | MB = Modeling Board | WB = Working Board. Special sizes available on request.

RAKU-TOOL® Boards	RAKU-TOOL SB-0240	RAKU-TOOL SB-0320	RAKU-TOOL SB-0470	RAKU-TOOL SB-0497
<b>Styling and Design with RAKU-TOOL</b>				
<b>Color</b>	light green	apricot	apricot	brown
<b>Density (ISO 1183) g/cm³   lb/ft³ (ca.)</b>	0.24   <b>15.0</b>	0.32   <b>20.0</b>	0.47   <b>29.3</b>	0.497   <b>31.0</b>
<b>Applications</b>	> Styling & design models > Data control models	> Styling & design models > Data control models	> Styling & master models	> Styling models > Master models > Data control models
<b>Key Properties</b>	> Good surface structure > Easily shaped and machined > Resistant to organic solvents	> Very good surface structure > Easily shaped and machined	> Very good surface structure > Easily machined	> Very fine and smooth surface structure > Easily machined > Low coefficient of thermal expansion > Good dimensional stability
<b>Hardness (ISO 868) Shore D</b>	–	–	–	45 – 50
<b>Coefficient of thermal expansion (ISO 11359) 10<sup>-6</sup> K<sup>-1</sup>   in/in/°F x 10<sup>-6</sup></b>	60 – 70   <b>33 – 39</b>	60 – 65   <b>33 – 36</b>	60 – 65   <b>33 – 36</b>	45 – 50   <b>25 – 28</b>
<b>Deflection temperature (ISO 75) °C   °F</b>	55 – 65   <b>130 – 150</b>	60 – 70   <b>140 – 158</b>	60 – 70   <b>140 – 158</b>	100 – 115   <b>212 – 239</b>
<b>Compressive strength (ISO 604) MPa   psi</b>	2 – 4   <b>290 – 580</b>	5 – 7   <b>730 – 1,020</b>	10 – 15   <b>1,500 – 2,200</b>	12 – 16   <b>1,700 – 2,300</b>
<b>Flexural strength (ISO 178) MPa   psi</b>	5 – 6   <b>730 – 870</b>	6 – 8   <b>870 – 1,200</b>	10 – 15   <b>1,500 – 2,200</b>	17 – 19   <b>2,500 – 2,800</b>
<b>Dimensions mm   in</b>	<b>2 x 24 x 96</b> <b>4 x 24 x 96</b> <b>6 x 24 x 96</b> <b>8 x 24 x 96</b> <b>2 x 48 x 96</b> <b>4 x 48 x 96</b> <b>6 x 48 x 96</b> <b>8 x 48 x 96</b> Other thicknesses are available.	<b>2 x 24 x 96</b> <b>4 x 24 x 96</b> <b>6 x 24 x 96</b> <b>8 x 24 x 96</b> <b>2 x 48 x 96</b> <b>4 x 48 x 96</b> <b>6 x 48 x 96</b> <b>8 x 48 x 96</b>	50 x 500 x 1500   <b>2.0 x 19.7 x 59.1</b> 100 x 500 x 1500   <b>3.9 x 19.7 x 59.1</b> 150 x 500 x 1500   <b>5.9 x 19.7 x 59.1</b> 200 x 500 x 1500   <b>7.9 x 19.7 x 59.1</b>	<b>2 x 48 x 96</b> <b>4 x 48 x 96</b> <b>6 x 48 x 96</b>
<b>Bonding with RAKU-TOOL</b>	> EP-2305/EH-2904-1	> EP-2305/EH-2904-1	> EP-2305/EH-2904-1	> EP-2306/EH-2904-1
<b>Mixing ratio (pbw)</b>	100 : 30	100 : 30	100 : 30	100 : 30
<b>Color</b>	apricot	apricot	apricot	brown
<b>Pot life (min.)</b>	25	25	25	35
<b>Minimum curing time (h)</b>	16	16	16	16
<b>Repair with RAKU-TOOL</b>				
<b>Mix ratio (pbw)</b>				
<b>Color</b>				
<b>Pot life (min)</b>				
<b>Minimum curing time (min)</b>				
SB = Styling Board   MB = Modeling Board   WB = Working Board. Special sizes available on request.				

3-3-0017/US. Errors excepted. Subject to change.

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RAKU-TOOL® Boards	RAKU-TOOL MB-0600	RAKU-TOOL MB-0670	RAKU-TOOL MB-0720	RAKU-TOOL WB-0691
	Modeling with RAKU-TOOL			Tool Making with RAKU-TOOL
Color	brown <i>eco-friendly</i>	brown <i>eco-friendly</i>	brown <i>eco-friendly</i>	light blue
Density (ISO 1183) g/cm <sup>3</sup>   lb/ft <sup>3</sup> (ca.)	0.60   <b>37.5</b>	0.67   <b>41.8</b>	0.72   <b>45.0</b>	0.69   <b>43.1</b>
Applications	> Master & cubing models > Patterns	> Master & cubing models > Patterns	> Master & cubing models > Patterns	> Lay-up tools for low temperature tooling prepregs, vacuum forming molds, medium temperature applications
Key Properties	> Fine surface structure > Easily shaped and machined > Low coefficient of thermal expansion > Good dimensional stability	> Fine surface structure > Easily shaped and machined > Low coefficient of thermal expansion > Good dimensional stability	> Excellent surface structure > Low coefficient of thermal expansion > Good dimensional stability > Good compressive and flexural strength	> Very fine surface structure > Excellent machinability > Good dimensional stability > Heat resistant up to 90°C
Hardness (ISO 868) Shore D	50 – 55	60 – 65	60 – 65	70 – 75
Coefficient of thermal expansion (ISO 11359) 10 <sup>-6</sup> K <sup>-1</sup>   in/in/°F x 10 <sup>-6</sup>	50 – 55   <b>28 – 31</b>	50 – 55   <b>28 – 31</b>	50 – 55   <b>28 – 31</b>	35 – 45   <b>19 – 25</b>
Deflection temperature (ISO 75) °C   °F	70 – 75   <b>158 – 167</b>	75 – 80   <b>167 – 176</b>	75 – 80   <b>167 – 176</b>	100 – 110   <b>212 – 230</b>
Compressive strength (ISO 604) MPa   psi	15 – 20   <b>2,200 – 2,900</b>	15 – 20   <b>2,200 – 2,900</b>	20 – 25   <b>2,900 – 3,600</b>	50 – 60   <b>7,300 – 8,700</b>
Flexural strength (ISO 178) MPa   psi	15 – 20   <b>2,200 – 2,900</b>	20 – 25   <b>2,900 – 3,600</b>	25 – 30   <b>3,600 – 4,400</b>	25 – 35   <b>3,600 – 5,100</b>
Dimensions mm   in	25 x 500 x 1500   <b>1.0 x 19.7 x 59.1</b> 50 x 500 x 1500   <b>2.0 x 19.7 x 59.1</b> 75 x 500 x 1500   <b>3.0 x 19.7 x 59.1</b> 100 x 500 x 1500   <b>3.9 x 19.7 x 59.1</b> 150 x 500 x 1500   <b>5.9 x 19.7 x 59.1</b>	25 x 500 x 1500   <b>1.0 x 19.7 x 59.1</b> 50 x 500 x 1500   <b>2.0 x 19.7 x 59.1</b> 75 x 500 x 1500   <b>3.0 x 19.7 x 59.1</b> 100 x 500 x 1500   <b>3.9 x 19.7 x 59.1</b> 150 x 500 x 1500   <b>5.9 x 19.7 x 59.1</b>	25 x 500 x 1500   <b>1.0 x 19.7 x 59.1</b> 50 x 500 x 1500   <b>2.0 x 19.7 x 59.1</b> 75 x 500 x 1500   <b>3.0 x 19.7 x 59.1</b> 100 x 500 x 1500   <b>3.9 x 19.7 x 59.1</b> 150 x 500 x 1500   <b>5.9 x 19.7 x 59.1</b> 200 x 500 x 1500   <b>7.9 x 19.7 x 59.1</b>	50 x 500 x 1500   <b>2.0 x 19.7 x 59.1</b> 75 x 500 x 1500   <b>3.0 x 19.7 x 59.1</b> 100 x 500 x 1500   <b>3.9 x 19.7 x 59.1</b> 150 x 500 x 1500   <b>5.9 x 19.7 x 59.1</b> 51 x 610 x 1524   <b>2.0 x 24.0 x 60.0</b> 76 x 610 x 1524   <b>3.0 x 24.0 x 60.0</b> 102 x 610 x 1524   <b>4.0 x 24.0 x 60.0</b> 152 x 610 x 1524   <b>6.0 x 24.0 x 60.0</b> 203 x 610 x 1524   <b>8.0 x 24.0 x 60.0</b>
Bonding with RAKU-TOOL	> EP-2306/EH-2904-1	> EP-2306/EH-2904-1	> EP-2306/EH-2904-1	> EP-2303/EH-2934
Mixing ratio (pbw)	100 : 30	100 : 30	100 : 30	100 : 20
Color	brown	brown	brown	light blue
Pot life (min.)	35	35	35	80 – 90
Minimum curing time (h)	16	16	16	16
Repair with RAKU-TOOL				
Mix ratio (pbw)				
Color				
Pot life (min)				
Minimum curing time (min)				

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RAKU-TOOL® Boards	RAKU-TOOL WB-0700	RAKU-TOOL WB-0801	RAKU-TOOL WB-1223	RAKU-TOOL WB-1700
	<b>Tool Making with RAKU-TOOL</b>			
<b>Color</b>	light green	gray	red	dark gray
<b>Density (ISO 1183) g/cm³   lb/ft³ (ca.)</b>	0.70   <b>43.8</b>	0.80   <b>49.9</b> <i>eco-friendly</i>	1.22   <b>76.3</b>	1.70   <b>106.0</b>
<b>Applications</b>	<ul style="list-style-type: none"> <li>&gt; Lay up tools for pre-preg</li> <li>&gt; High temperature applications</li> <li>&gt; Vacuum forming molds</li> </ul>	<ul style="list-style-type: none"> <li>&gt; Master models</li> <li>&gt; Cubing models</li> <li>&gt; Tooling jigs and fixtures</li> <li>&gt; Vacuum forming tools</li> </ul>	<ul style="list-style-type: none"> <li>&gt; Foundry pattern plates</li> <li>&gt; Hammer tools</li> <li>&gt; Checking fixtures for metal parts</li> </ul>	<ul style="list-style-type: none"> <li>&gt; Metal forming tools</li> <li>&gt; Vacuum forming molds, jigs</li> <li>&gt; Foam molds, rapid prototyping molds</li> </ul>
<b>Key Properties</b>	<ul style="list-style-type: none"> <li>&gt; Very fine surface structure</li> <li>&gt; Very easily machined</li> <li>&gt; Good dimensional stability</li> <li>&gt; Temperature resistance up to 130° C</li> </ul>	<ul style="list-style-type: none"> <li>&gt; Fine surface structure</li> <li>&gt; High HDT and very low CTE</li> <li>&gt; Good dimensional stability</li> <li>&gt; Good compressive and flexural strength</li> </ul>	<ul style="list-style-type: none"> <li>&gt; Low wear of milling tools</li> <li>&gt; Resistant to amine</li> <li>&gt; Most proven working board on the foundry market</li> <li>&gt; Resistant to dry ice cleaning</li> <li>&gt; Good abrasion resistance</li> </ul>	<ul style="list-style-type: none"> <li>&gt; Very dense surface structure, can be polished</li> <li>&gt; Easily machined</li> <li>&gt; Good temperature resistance</li> <li>&gt; Excellent compressive strength</li> <li>&gt; High abrasion resistance</li> </ul>
<b>Hardness (ISO 868) Shore D</b>	65 – 70	65 – 70	75 – 85	85 – 90
<b>Coefficient of thermal expansion (ISO 11359) 10<sup>-6</sup> K<sup>-1</sup>   in/in/°F x 10<sup>-6</sup></b>	35 – 45   <b>19 – 25</b>	45 – 50   <b>25 – 28</b>	80 – 85   <b>44 – 47</b>	45 – 50   <b>25 – 28</b>
<b>Deflection temperature (ISO 75) °C   °F</b>	130 – 140   <b>266 – 284</b>	85 – 90   <b>185 – 194</b>	80 – 90   <b>176 – 194</b>	120 – 125   <b>248 – 257</b>
<b>Compressive strength (ISO 604) MPa   psi</b>	50 – 55   <b>7,300 – 8,000</b>	40 – 45   <b>5,800 – 6,500</b>	60 – 70   <b>8,700 – 10,000</b>	125 – 130   <b>18,000 – 19,000</b>
<b>Flexural strength (ISO 178) MPa   psi</b>	30 – 40   <b>4,400 – 5,800</b>	35 – 40   <b>5,100 – 5,800</b>	70 – 80   <b>10,000 – 12,000</b>	80 – 85   <b>11,000 – 12,000</b>
<b>Dimensions mm   in</b>	50 x 500 x 1500   <b>2.0 x 19.7 x 59.1</b> 75 x 500 x 1500   <b>3.0 x 19.7 x 59.1</b> 100 x 500 x 1500   <b>3.9 x 19.7 x 59.1</b> 150 x 500 x 1500   <b>5.9 x 19.7 x 59.1</b>	25 x 500 x 1500   <b>1.0 x 19.7 x 59.1</b> 50 x 500 x 1500   <b>2.0 x 19.7 x 59.1</b> 75 x 500 x 1500   <b>3.0 x 19.7 x 59.1</b> 100 x 500 x 1500   <b>3.9 x 19.7 x 59.1</b> 150 x 500 x 1500   <b>5.9 x 19.7 x 59.1</b>	<b>1.2 x 20 x 40</b> <b>2 x 24 x 60</b> <b>3 x 24 x 60</b> <b>4 x 24 x 60</b>	50 x 500 x 750   <b>2.0 x 19.7 x 29.5</b> 100 x 500 x 750   <b>3.9 x 19.7 x 29.5</b>
<b>Bonding with RAKU-TOOL</b>	> <b>EP-2304/EH-2934</b>	> <b>EL-2210/EH-2910-1*</b>	> <b>EL-2210/EH-2910-1*</b>	> <b>EL-2210/EH-2910-1*</b>
<b>Mixing ratio (pbw)</b>	100 : 20	100 : 60	100 : 60	100 : 60
<b>Color</b>	light green	transparent	transparent	transparent
<b>Pot life (min.)</b>	90	60	60	60
<b>Minimum curing time (h)</b>	16	16	16	16
<b>Repair with RAKU-TOOL</b>				
<b>Mix ratio (pbw)</b>				
<b>Color</b>		Repair with adhesive bonded inserts	Repair with adhesive bonded inserts	Repair with adhesive bonded inserts
<b>Pot life (min)</b>				
<b>Minimum curing time (min)</b>				

SB = Styling Board | MB = Modeling Board | WB = Working Board. \* Different mix ratios for special mixtures see technical data sheet.