

## RAKU-TOOL (Styling Boards)

Product		SB-0080	SB-0140	SB-0240	SB-0351	SB-0470
Color		Off - White	Light green	Apricot	Apricot	Apricot
Density		0.08	0.14	0.24	0.35	0.47
Material		Polyurethane	Polyurethane	Polyurethane	Polyurethane	Polyurethane
Applications		Design study Program proving Support structure Negative molds	Design study Program proving Support structure Negative molds	Styling models Epoxy laminating molds Support structure Negative molds	Styling & Design models Support structure Molds for laminating parts	Styling models Master models & date control models
Properties		<ul style="list-style-type: none"> <li>•Very light weight</li> <li>•Smooth surface</li> <li>•Easily shaped and good chip formation</li> <li>•Good heat resistance</li> <li>•Resistant to organic solvents</li> </ul>	<ul style="list-style-type: none"> <li>•Light weight</li> <li>•Smooth surface</li> <li>•Easily shaped, low dust</li> <li>•Resistant to organic solvents</li> </ul>	<ul style="list-style-type: none"> <li>•Very good surface</li> <li>•Easily machined</li> <li>•Good heat resistance</li> <li>•Resistant to organic solvents</li> </ul>	<ul style="list-style-type: none"> <li>•Fine surface structure</li> <li>•Easily shaped &amp; machined</li> <li>•Low dust</li> </ul>	<ul style="list-style-type: none"> <li>•Very smooth surface</li> <li>•Easily machined</li> </ul>
Hardness	ShoreD	—	—	—	—	—
Flexural strength	MPa	—	1.6~2.0	5~6	8~12	10~15
Compressive strength	MPa	0.7~0.9	1.6~2.0	2~4	8~12	10~15
Deflection temperature	°C	—	50~60	55~65	60~70	60~70
CTE	$\times 10^{-6}$	—	—	60~70	45~50	60~65
Size	mm	100 × 1200 × 2500	100 × 1000 × 2000	100 × 500 × 1500	50 × 500 × 1500	50 × 500 × 1500
		200 × 1200 × 2500	200 × 1000 × 2000	200 × 500 × 1500	100 × 500 × 1500	100 × 500 × 1500
		400 × 1200 × 2500		200 × 1000 × 2000	200 × 500 × 1500	200 × 500 × 1500

## RAKU-TOOL (Modeling Boards)

Product		MB-0600	MB-0670	MB-0720
Color		Brown	Brown	Brown
Density		0.60	0.67	0.72
Material		Polyurethane	Polyurethane	Polyurethane
Applications		Master models Cubing models Patterns	Master models Cubing models Patterns	Master models Cubing models Patterns
Properties		<ul style="list-style-type: none"> <li>▪ Fine surface structure</li> <li>▪ Easily shaped &amp; machined</li> <li>▪ Low CTE</li> <li>▪ Good dimensional stability</li> </ul>	<ul style="list-style-type: none"> <li>▪ Fine surface structure</li> <li>▪ Easily shaped &amp; machined</li> <li>▪ Low CTE</li> <li>▪ Good dimensional stability</li> </ul>	<ul style="list-style-type: none"> <li>▪ Fine surface structure</li> <li>▪ Low CTE</li> <li>▪ Good dimensional stability</li> <li>▪ Good compressive &amp; flexural strength</li> </ul>
Hardness	ShoreD	50~55	55~60	60~65
Flexural strength	MPa	15~20	20~25	20~25
Compressive strength	MPa	15~20	15~20	20~25
Deflection temperature	°C	70~75	75~80	75~80
CTE	$\times 10^{-6}$	50~55	50~55	50~55
Size	mm	25 × 500 × 1500	25 × 500 × 1500	25 × 500 × 1500
		30 × 500 × 1500	30 × 500 × 1500	30 × 500 × 1500
		50 × 500 × 1500	50 × 500 × 1500	50 × 500 × 1500
		75 × 500 × 1500	75 × 500 × 1500	75 × 500 × 1500
		100 × 500 × 1500	100 × 500 × 1500	100 × 500 × 1500
				150 × 500 × 1500



## RAKU-TOOL (Working Boards 1/2)

Product		WB-0691	WB-0700	WB-0801	WB-1001
Color		Light blue	Light green	Gray	Gray
Density		0.69	0.70	0.80	1.00
Material		Epoky	Epoky	Polyurethane	Polyurethane
Applications		Lay-up tools for low temperature tooling prepreg Vacuum forming molds Medium temperature applications	Lay-up tools for prepreg Vacuum forming molds High temperature applications	Master models Cubing models Tooling jigs & fixtures Vacuum forming tools	Tooling jigs
Properties		<ul style="list-style-type: none"> <li>•Very fine surface</li> <li>•Excellent machinability</li> <li>•Good dimensional stability</li> <li>•Heat resistant up to 110°C</li> </ul>	<ul style="list-style-type: none"> <li>•Very fine surface</li> <li>•Excellent machinability</li> <li>•Good dimensional stability</li> <li>•Heat resistant up to 130°C</li> </ul>	<ul style="list-style-type: none"> <li>•Fine surface structure</li> <li>•High HDT &amp; low CTE</li> <li>•Good dimensional stability</li> <li>•Good compressive &amp; flexural strength</li> </ul>	<ul style="list-style-type: none"> <li>•Very easily machined</li> <li>•Low CTE</li> <li>•Good abrasion resistance &amp; edge strength</li> </ul>
Hardness	ShoreD	70~75	65~70	65~70	75~80
Flexural strength	MPa	28~33	30~40	35~40	50~55
Compressive strength	MPa	50~55	50~55	40~45	45~50
Deflection temperature	°C	100~110	130~140	85~90	70~80
CTE	$\times 10^{-6}$	35~45	35~45	45~50	55~60
Size	mm	50 × 500 × 1500 75 × 500 × 1500 100 × 500 × 1500	30 × 500 × 1500 50 × 500 × 1500 75 × 500 × 1500 100 × 500 × 1500 150 × 500 × 1500 200 × 500 × 1500	25 × 500 × 1500 50 × 500 × 1500 75 × 500 × 1500 100 × 500 × 1500	25 × 500 × 1500 50 × 500 × 1500 75 × 500 × 1500 100 × 500 × 1500

## RAKU-TOOL (Working Boards 2/2)

Product		WB-1258	WB-1600	WB-1700
Color		Orange	Ivory	Dark gray
Density		1.20	1.60	1.70
Material		Polyurethane	Polyurethane	Polyurethane
Applications		Pattern plates Core boxes	Sheet metal forming Tooling jigs and fixtures	Sheet metal forming Vacuum forming Tooling jigs Molds for form & rapid prototyping
Properties		<ul style="list-style-type: none"> <li>•Very high abrasion resistance whilst good dimensional stability and accuracy</li> <li>•Homogeneous surface</li> <li>•High impact strength</li> <li>•Good edge strength</li> <li>•Very easily machined</li> <li>•Excellent resistance to chemicals, no swelling</li> </ul>	<ul style="list-style-type: none"> <li>•Easily machined</li> <li>•Low CTE</li> <li>•Excellent compressive strength</li> <li>•Good abrasion resistance</li> </ul>	<ul style="list-style-type: none"> <li>•Very dense surface structure, can be polished</li> <li>•Easily machined</li> <li>•Good heat resistance</li> <li>•High abrasion resistance</li> </ul>
Hardness	ShoreD	80~85	85~90	85~90
Flexural strength	MPa	100~110	55~65	80~85
Compressive strength	MPa	90~100	90~100	125~130
Deflection temperature	°C	70~75	75~80	120~125
CTE	$\times 10^{-6}$	70~75	45~50	45~50
Size	mm	30 × 500 × 1000 50 × 500 × 1000 75 × 500 × 1000 100 × 500 × 1000	50 × 500 × 750 100 × 500 × 750	50 × 500 × 750 100 × 500 × 750

