

RAKU® TOOL Close Contour Products

| Resin | Hardener | Mix ratio (pbw) | Color | Pot life 25°C (min) | Layer thickness (mm) | Density g/cm ³ (ISO 1183) ca. | | Key Properties | Applications |
|---|-----------|--------------------------------------|----------------------------|---|------------------------------------|--|-----------------------------------|---|---|
| RAKU® TOOL Close Contour Pastes (machine applied) 1000 ml | | | | | | | | | |
| CP-6060 | CP-6060 | 100 : 100 | gray | 30 – 40 | 25 | 0.6 | | Very fine and homogeneous surface, easy to machine, low dust, low exotherm, can be machined after 9 h RT curing | Large-scale models, wind turbine blade models, boat models |
| CP-6070 | CP-6072 | 100 : 100 | brown | 100 – 120 | 40 | 0.75 | | Very smooth, homogeneous surface, easy to machine, very little dust, can be machined after 18 h RT curing | Design and styling models, master models, molds |
| CP-6100-1 | CP-6100-1 | 100 : 100 | light blue | 50 – 60 | 25 | 1.2 | | Easy to machine, low dust, very fine and homogeneous surface, high surface hardness and low CTE, can be machined after 14 h RT curing | Jigs and checking fixtures, data control models, tools, molds for direct tooling |
| RAKU® TOOL Repair Systems for Epoxy Close Contour Pastes 100 ml | | | | | | | | | |
| CP-6060 | EH-2936-2 | 100 : 60 | gray | 15 – 20 | | 0.7 | | <ul style="list-style-type: none"> > Slump resistant on vertical surfaces in layers up to 20 mm thickness > Sufficient pot life with rapid curing > Similar mechanical properties to those of cured Close Contour Pastes | Repair of Close Contour Paste CP-6060 R/H |
| CP-6070 | EH-2936-2 | 100 : 50 | brown | 15 – 20 | | 0.75 | | | Repair of Close Contour Paste CP-6070 R/H |
| RAKU® TOOL Epoxy Hand Pastes 500 ml | | | | | | | | | |
| EP-2344 | EH-2944 | 100 : 80 | light brown | 100 – 140 | | 0.90 | | <ul style="list-style-type: none"> > Flame retardant > E-84 Class A > Easy to sculpt | Sculptures and design models |
| RAKU® TOOL Close Contour Casting (CCC*) / Close Contour Blocks (CB*) | | | | | | | | | |
| | Color | Density g/cm ³ (ISO 1183) | Shore Hardness D (ISO 868) | Coefficient of thermal expansion 10 ⁻⁶ K ⁻¹ (ISO 11359) | Deflection temperature °C (ISO 75) | Compressive strength MPa (ISO 604) | Compressive modulus MPa (ISO 604) | Key Properties | Applications |
| CC-6010 / CB-6010 | brown | 0.80 | 65 – 70 | 65 – 70 | 75 – 80 | 35 – 40 | 1300 – 1600 | <ul style="list-style-type: none"> > Fine surface structure > Easily machined > Similar properties to RAKU® TOOL modeling boards | Master models, cubing models, patterns |
| CC-6503 / CB-6503 | blue | 1.85 | 85 – 90 | 40 – 45 | 80 – 85 | 95 – 105 | 9500 | <ul style="list-style-type: none"> > Very dense structure > Very homogeneous, fine surface and as a result, very good surface of nickel bowl, i.e. little finishing required and therefore large cost savings > Easily machined like board material WB-1700 > Low coefficient of thermal expansion | Galvanobath models, lay up tools, vacuum trim fixtures, stretch form dies, RIM tools |
| CC-6506 / CB-6506 | dark gray | 1.9 | 90 – 95 | 35 | 110 – 115 | 120 – 130 | 13000 | <ul style="list-style-type: none"> > Very dense surface structure > Can be polished > Good heat resistance > High compressive strength > Good resistance to chemicals > Time savings through direct milling of mold via surface data > Better pressing of sheet metal parts | Molds for ceramic pressure casting, metal stamping, vacuum forming tools, lay up tools, prepreg tools |

*CC Close Contour Casting is supplied as a three dimensional shape which is already a close contour of your final shape.
 *CB Close Contour Block is supplied as a customized size of a rectangular, unmachined block.
 *CP Close Contour Paste (R= Resin, H= Hardener)

CB: The general rule is that RAMPF Tooling only adds an offset for shrinkage to the dimensions indicated on the customer's order. The customer has to assess how many mm machining/processing offset is needed for the unmachined block he receives. We recommend a machining/processing offset of 10 mm. Dimensions ordered = dimensions supplied, within the specifications. Close Contour Blocks are unmachined, only basic cleaned cast blocks. Some release agent residue on the surface is possible. Sharp edges are milled due to risk of injury.

CC: For a dimensions of up to 1000 mm, an offset of 20 mm per surface to be worked on must be added. All larger dimensions need to have a shrinkage offset of 0.5-2 % (dependent on product) + offset for processing of minimum + 10 mm per surface. However, each project still needs to be discussed with the responsible project manager at RAMPF Tooling.