

RAKU-TOOL[®] CC-6508 & CB-6508

Close Contour Casting & Close Contour Block

Filled, Cast Polyurethane

PC - Rev.-Status: 01- 2010/02/25

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Key Properties

- Very dense, homogeneous and fine surface
- Easily machined
- Good abrasion resistance

Applications

- Bath model for electroforming process
- Lay up tools
- RIM tools

Advantages of Close Contour Casting

- Close Contour Casting (CC-6508) is supplied as a three dimensional shape which is already a close contour of your final shape
- Close Contour Block (CB-6508) is supplied as a customized size of a rectangular, unmachined block
- Quicker machining, less tool wear and less wastage through close contour shape
- Less manual finishing required as the surface is seamless, smooth, very dense and free from bubbles through our vacuum casting process
- No handling of liquid chemistry, concentration on milling technology
- Good dimensional stability as the material exhibits little stresses and is isotropic like board material
- High quality standard

Mechanical Properties

| | | | CC-6508 & CB-6508 |
|----------------------------------|-----------|----------------------------------|-------------------|
| Color | visual | | Gray |
| Density | ISO 1183 | g/cm ³ | 1.90 |
| Shore hardness D | ISO 868 | | 88 – 93 |
| Coefficient of thermal expansion | ISO 11359 | 10 ⁻⁶ K ⁻¹ | 40 – 45 |
| Deflection temperature, HDT | ISO 75 | °C | 80 – 85 |
| Compressive strength | ISO 604 | MPa | 105 – 115 |
| Compressive modulus | ISO 604 | MPa | 11,000 |

Processing

The product should have a temperature of 20°C – 25°C during processing.

Storage

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

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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.
