

RAKU-TOOL[®] CP-6090 Polyol / Isocyanate

Close Contour Paste

Machine dispensed polyurethane paste

PC - Rev.-Status: 01- 2009/06/25

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Key Properties

- Very fine and homogeneous surface
- Easy to machine, low dust
- Low exotherm, can be machined after 12 h RT curing
- Can be applied in thick layers without slump on vertical surfaces

Applications

- Master models for the marine industry
- Molds

Processing Properties

			CP-6090 Polyol	CP-6090 Isocyanate
Color	visual		Light Brown	Brown
Mix ratio		parts by weight	100	40
		parts by volume	100	26
Density	ISO 1183	g/cm ³	0.80	1.23
Viscosity at 25 °C	ISO 2555	m Pa.s	20,000-30,000	600-750

			CP-6090 Polyol / Isocyanate
Pot life at 25 °C	1000 ml	min	40 - 50
Layer thickness		mm	20
Machineable after (at 25°C)		h	12

Cured / Mechanical Properties**Cure: 7 days at RT or 14h at 40°C**

			CP-6090 Polyol / Isocyanate
Appearance	visual		Brown
Density	ISO 1183	g/cm ³	0.9
Shore hardness D	ISO 868		65 – 75
Coefficient of thermal expansion	ISO 11359	10 ⁻⁶ K ⁻¹	70 - 80
Deflection temperature, HDT	ISO 75	°C	50
Glass Transition Temperature, Tg	DSC	°C	50 - 55
Compressive strength	ISO 604	MPa	30 - 35
Compressive modulus	ISO 604	MPa	1200 - 1400
Flexural strength	ISO 178	MPa	25 – 30
Flexural modulus	ISO 178	MPa	1500 - 1700
Linear shrinkage*		mm / m	-

*measured on maximum layer thickness as stated above

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Processing

The processing and material temperature should be between 20-25 °C, never below 18 °C.

Set up parameters for dispensing machine are available on request.

Check the mixing ratio before you start with the application.

Please ensure the constant supply of compressed air.

The longer the hose the higher the material pressure.

Avoid applying over 20 mm at once, for thicker layers it is recommended to apply the 2nd layer after the first one has gelled.

Packaging

RAKU-TOOL® CP-6090 Polyol	20 kg, 150 kg
RAKU-TOOL® CP-6090 Isocyanate	30 kg, 250 kg

Storage

Original containers should be kept tightly sealed and stored at ambient temperatures (15°C to 30°C). If properly stored the products have the shelf-life indicated on the product label.

Partly used containers should always be sealed appropriately and used up as soon as possible.

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.