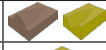


RAKU® TOOL Composite Product Recommendations

Resin	Hardener	Pot life at 25°C (min)			ISO 75 (°C)	Key Properties	hand/ wet lay-up	vacuum bagging/ wet lay-up	resin infusion	vacuum bagging/ prepreg (out of autoclave)	autoclave process	wet com- pression molding	RTM	galvano bath models
		60 min	180 min	360 min										
RAKU® TOOL Epoxy Laminating Systems (500 ml)														
EL-2200	EH-2900		70–90 min		48–53 °C 167–127 °F	viscosity 1000–1300 mPa-s, multipurpose, laminating and back filling resin								
EL-2201	EH-2904-1		25–30 min		55–60 °C 131–140 °F	viscosity 700–1100 mPa-s, high mechanical properties at room temperature cure								
	EH-2905-1		60–70 min		53–58 °C 140–136 °F									
	EH-2906-1		120–140 min		50–55 °C 122–131 °F									
EL-2203	EH-2952-1		50–60 min		115–120 °C 239–248 °F	viscosity 400–700 mPa-s, low-viscosity, excellent wetting proper- ties, good gelation at room temperature								
	EH-2953-1		70–80 min		115–120 °C 239–248 °F									
EL-2204	EH-2954-2		90–110 min		180–190 °C 356–374 °F	viscosity 1300–2000 mPa-s, high temperature applications								
	EH-2955-2		180–210 min		180–190 °C 356–374 °F									
RAKU® TOOL Epoxy Infusion Systems (500 ml)														
EL-2203	EH-2970-1		50–60 min		115–120 °C 239–248 °F	low-viscosity 400–600 mPa-s, no out gassing under vacuum, excellent wetting and flow properties, good cure at room temperature								
EI-2500	EH-2953-1		60–80 min		110–115 °C 230–239 °F	RTM injection system for medium to large parts								
	EH-2970-1		50–60 min		110–115 °C 230–239 °F	low-viscosity 500–1000 mPa-s, no out gassing under vacuum, excellent wetting and flow properties								
	EH-2971		70–80 min		100–110 °C 212–230 °F	low-viscosity 300–700 mPa-s, no out gassing under vacuum, excellent wetting and flow properties								
	EH-2973		70–80 min		133–138 °C 271–280 °F	medium temperature applications, low viscosity 300–700 mPa-s, no out gassing under vacuum, excellent wetting and flow properties								
EI-2504	EH-2974		210–270 min		160–165 °C 320–329 °F	viscosity 550–750 mPa-s, high temperature applications, prepreg lay-up tools								
EI-2510	EH-2990		120 min at 40 °C		210 °C (T _g) 410 °F (T _g)	high temperature applications, very low viscosity 200 mPa-s, excellent hot wet properties, excellent fracture toughness								
EI-2511	EH-2990		at 60°C 110–150 min		155 °C 311 °F	high temperature applications, excellent FST properties, non-halogenated, low viscosity, excellent high wet tg								
EI-2518	EH-2991		at 60°C 80–120 min		131 °C (T _g) 268 °F (T _g)	high temperature applications, excellent FST performance, non-halogenated, low viscosity								
	EH-2992		at 60°C 190–230 min											
RAKU® TOOL Epoxy Laminating Paste Systems (500 ml)														
EL-2207-3	EH-2907-3		30-35 min		60 – 65 °C 140 – 149 °F	laminating paste, layer thickness 15 mm								
EL-2207-3	EH-2912		80–100 min		58 – 63 °C 136 – 145 °F	laminating paste, layer thickness 15 mm and lower exothermic than with EH-2907-3								
RAKU® TOOL Epoxy Close Contour Pastes (machine applied) (1000 ml)														
CP-6060 R	CP-6060 H		30–40 min		60–65 °C 140–149 °F	ca. 0.6 g/cm³ (37.5 lb/ft³) gray, modeling paste, specially suited for large parts, easy to machine								
CP-6070 R	CP-6072 H		50–60 min		60–65 °C 140–149 °F	ca. 0.75 g/cm³ (46.8 lb/ft³) light blue, model and tooling paste, high surface hardness, low CTE, easy to machine								
CP-6100-1 R	CP-6100-1 H		50–60 min		85–90 °C 185–194 °F	ca. 0.75 g/cm³ (46.8 lb/ft³) light blue, model and tooling paste, high surface hardness, low CTE, easy to machine								



= mold



= model



= part

**Temperature
resistance**

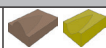
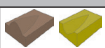
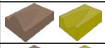
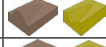
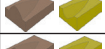
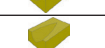
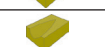
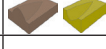
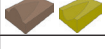
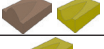
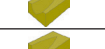
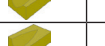
50–80 °C

80–120 °C

120–160 °C

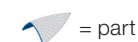
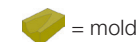
160–200 °C

RAKU® TOOL Composite Product Recommendations

Resin	Hardener	Density (g/cm³)/(lb/ft³) approx.	ISO 75 (°C/°F)	Key Properties	hand/ wet lay-up	vacuum bagging/ wet lay-up	resin infusion	vacuum bagging/ prepreg (out of autoclave)	autoclave process	wet com- pression molding	RTM	galvano bath models
RAKU® TOOL Boards												
SB-0240	Light green	0,24 g/cm³ (15 lb/ft³)	55–65 °C 131–149 °F	very simple molds for laminating								
SB-0320	Apricot	0,32 g/cm³ (20 lb/ft³)	60–70 °C 140–158 °F	very simple molds for laminating, optimized compressive strength								
SB-0470	Apricot	0,47 g/cm³ (29.3 lb/ft³)	60–70 °C 140–158 °F	simple molds for laminating								
MB-0600	Brown	0,60 g/cm³ (37.5 lb/ft³)	70–75 °C 158–167 °F	models, molds for laminating								
MB-0670	Brown	0,67 g/cm³ (41.8 lb/ft³)	75–80 °C 167–176 °F	models, molds for laminating, low coefficient of thermal expansion								
MB-0720	Brown	0,72 g/cm³ (45 lb/ft³)	75–80 °C 167–176 °F	high quality models, molds for laminating, low coefficient of thermal expansion								
WB-0700	Light green	0,70 g/cm³ (43.8 lb/ft³)	130–140 °C 275–284 °F	epoxy board, prepreg lay-up tools, low linear coefficient of thermal expansion								
WB-0890	Dark blue	0,89 g/cm³ (56 lb/ft³)	100–110 °C 230–239 °F	epoxy board, lay-up tools for low temperature prepreps, very fine surface structure, good dimensional stability								
WB-1223	Red	1,22 g/cm³ (76.3 lb/ft³)	80–90 °C 176–194 °F	can be polished to a high gloss, high impact strength, chemical resistant								
WB-1700	Dark gray	1,7 g/cm³ (106 lb/ft³)	120–125 °C 248–257 °F									
RAKU® TOOL Close Contour Casting (CCC) / Close Contour Blocks (CB)												
CC/CB-6010	Brown	0,8 g/cm³ (50 lb/ft³)	75–80 °C 167–176 °F	models, molds for laminating, high compressive strength								
CC/CB-6503	Blue	1,85 g/cm³ (115.5 lb/ft³)	80–85 °C 176–185 °F	dense structure, galvano bath models								
CC/CB-6506	Dark gray	1,9 g/cm³ (118.6 lb/ft³)	110–115 °C 230–239 °F	can be polished to a high gloss, chemical resistant, lay-up tools for low temperature prepreg , linear coefficient of thermal expansion								
CC/CB-6507	Olive	1,4 g/cm³ (87.4 lb/ft³)	75–80 °C 167–176 °F	can be polished to a high gloss, good impact strength, good styrene resistance								
CB-6700	Light green	0,7 g/cm³ (43.7 lb/ft³)	135–140 °C 275–284 °F	epoxy material, prepreg lay-up tools, low linear coefficient of thermal expansion								

The mechanical properties and temperature resistance are only obtained through the post cure according to the recommended cure schedule.

For physical and mechanical properties please refer to the individual product technical data sheets.


**Temperature
resistance**

50–80 °C

80–120 °C

120–160 °C

160–200 °C

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