

## Close Contour Casting

Cast Polyurethane, density <math><1.0 \text{ g/cm}^3</math> (<math><62 \text{ lb/ft}^3</math>)

### Key Properties

- Fine surface structure
- Very easily machined
- Similar quality to RAKU® TOOL Modeling Boards without bonding lines

### Applications

- Master models
- Cubing models
- Data control models

### Advantages of Close Contour Casting

- Quicker machining, less tool wear and less wastage through close contour shape
- Less manual finishing required as the surface is seamless, smooth and very dense.
- 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-6010
Color	visual		Brown
Density	ASTM D-792	$\text{g/cm}^3$ (lb/ft <sup>3</sup> )	ca. 0.80 (ca. 50)
Shore hardness D	ASTM D-2240		65 – 70
Coefficient of thermal expansion	ASTM D-3386	$10^{-6}\text{K}^{-1}$ (in/in/°F x 10 <sup>-6</sup> )	65 – 70 (36 – 39)
Deflection temperature, HDT	ASTM D-648	°C (°F)	75 – 80 (167 – 176)
Compressive strength	ASTM D-695	MPa (psi)	35 – 40 (5,100 – 5,800)
Compressive modulus	ASTM D-695	MPa (psi)	1,300 – 1,600 (189,000 – 232,000)

### Processing

The product should have a temperature of 20°C – 25°C (68-77°F) during processing.

### Storage

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

**RAKU® TOOL CC-6010**

**Close Contour Casting**

Cast Polyurethane, density <math><1.0 \text{ g/cm}^3</math> (<math><62 \text{ lb/ft}^3</math>)



**RAMPF®**

discover the future

---

### **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.

---

RAMPF Group, Inc.  
49037 Wixom Tech Drive  
Wixom, MI 48393  
T +1 248. 295.0223  
F +1 248. 295.0224  
E info.us@rampf-group.com

**[www.rampf-group.com](http://www.rampf-group.com)**

Our recommendations on the use of the material are based on many years of experience and current scientific and practical knowledge. They are, however, provided without any obligation on our part and do not relieve the buyer of the need for suitability tests. They do not constitute a legal relationship, nor are any protected third party rights whatsoever affected thereby.