

**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										
<b>RAKU® TOOL Epoxy Gelcoat Systems (250 ml)</b>														
EG-2100	EH-2901-2	15–20 min			60–65 °C	can be sanded and polished								
	EH-2950-1	30–35 min			95–100 °C	can be sanded and polished, good interlayer adhesion, even with gelation over night								
EG-2101	EH-2901-2	30–35 min			55–60 °C	can be sanded and polished, good covering power, good machinability								
	EH-2950-1	50–60 min			88–93 °C									
EG-2102	EH-2901-2	25–30 min			60–65 °C	abrasion and chemical resistant								
	EH-2950-1	50–60 min			95–100 °C									
EG-2104	EH-2950-1	35–45 min			100–105 °C	can be polished to a high gloss								
EG-2105-1	EH-2950-1	40–50 min			125–130 °C	excellent styrene resistance, can be polished to a high gloss								
EG-2107-1	EH-2950-1	70–90 min			190–200 °C	high temperature applications								
<b>RAKU® TOOL Epoxy Coupling Layer (500 ml)</b>														
EL-2209-2	EH-2950-1	20–30 min			100–105 °C	ready-made coupling layer, excellent interlayer adhesion								
<b>RAKU® TOOL Epoxy Laminating Systems (500 ml)</b>														
EL-2200	EH-2900	70–90 min			48–53 °C	viscosity 1000–1300 mPa-s, multipurpose, laminating and back filling resin								
EL-2201	EH-2904-1	25–30 min			55–60 °C	viscosity 700–1100 mPa-s, high mechanical properties at room temperature cure								
	EH-2905-1	60–70 min			53–58 °C									
	EH-2906-1	120–140 min			50–55 °C									
EL-2203	EH-2952-1	50–60 min			115–120 °C	viscosity 400–700 mPa-s, low-viscosity, excellent wetting properties, good gelation at room temperature								
	EH-2953-1	70–80 min			115–120 °C									
<b>RAKU® TOOL Epoxy Casting Systems (1000 ml)</b>														
EC-2404	EH-2952-1	100–120 min			115–120 °C	high temperature resistance, easy to cast								

 = mold     = model     = part

**Temperature  
resistance**

50–80 °C	80–120 °C	120–160 °C	160–200 °C
----------	-----------	------------	------------

**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										
<b>RAKU® TOOL Epoxy Infusion Systems (500 ml)</b>														
EL-2203	EH-2970-1	50–60 min	115–120°C	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	RTM injection system for medium to large parts										
EI-2500	EH-2970-1	50–60 min	110–115°C	low-viscosity 500–1000 mPa-s, no out gassing under vacuum, excellent wetting and flow properties										
EI-2500	EH-2971	70–80 min	100–110°C	low-viscosity 300–700 mPa-s, no out gassing under vacuum, excellent wetting and flow properties										
EI-2500	EH-2973	70–80 min	133–138°C	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	viscosity 550–750 mPa-s, high temperature applications, prepreg lay-up tools										
<b>RAKU® TOOL Epoxy Laminating Paste Systems (500 ml)</b>														
EL-2207-3	EH-2907-3	30–35 min	60–65°C	laminating paste, layer thickness 15 mm										
EL-2207-3	EH-2912	80–100 min	58–63°C	laminating paste, layer thickness 15 mm and lower exothermic than with EH-2907-3										
<b>RAKU® TOOL Epoxy Close Contour Pastes (machine applied) (1000 ml)</b>														
CP-6060 R	CP-6060 H	30–40 min	60–65°C	ca. 0.6 g/cm³, gray, modeling paste, specially suited for large parts										
CP-6070 R	CP-6070 H	30–40 min	70–75°C	ca. 0.75 g/cm³, brown, modeling paste										
CP-6070 R	CP-6072 H	50–60 min	60–65°C	ca. 0.75 g/cm³, brown, modeling paste, less shrinkage than with CP-6070 hardener										
CP-6083 R	CP-6083 H	50–60 min	80–85°C	ca. 0,85 g/cm³, gray, dimensionally stable models and molds with a fine, homogeneous and seamless surface for all part sizes.										
CP-6083 R	CP-6084 H	60–70 min	85–90°C	ca. 0,85 g/cm³, gray, dimensionally stable models and molds with a fine, homogeneous and seamless surface for all part sizes, less shrinkage than with CP-6083 hardener.										
































































= mold    = model    = part

Temperature resistance	50–80°C	80–120°C	120–160°C	160–200°C

**RAMPF** Advanced Polymers GmbH & Co. KG

Robert-Bosch-Str. 8-10 | 72661 Grafenberg | Germany  
 T +49.7123.9342-0  
 E advanced.polymers@rampf-group.com

**RAKU® TOOL Composite Product Recommendations**

Resin	Hardener	Density (g/cm <sup>3</sup> ) ca.	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
<b>RAKU® TOOL Boards</b>												
SB-0240	Apricot	0.24 g/cm <sup>3</sup>	60–70 °C	very simple molds for laminating								
SB-0351	Apricot	0.35 g/cm <sup>3</sup>	65–75 °C	very simple molds for laminating, optimized compressive strength								
SB-0470	Apricot	0.47 g/cm <sup>3</sup>	75–80 °C	simple molds for laminating								
MB-0600	Brown	0.60 g/cm <sup>3</sup>	70–75 °C	models, molds for laminating								
MB-0670	Brown	0.67 g/cm <sup>3</sup>	75–80 °C	models, molds for laminating, low coefficient of thermal expansion								
MB-0720	Brown	0.72 g/cm <sup>3</sup>	75–80 °C	high quality models, molds for laminating, low coefficient of thermal expansion								
WB-0691	Blue	0.69 g/cm <sup>3</sup>	100–110 °C	epoxy board, lay-up tools for low temperature prepreg								
WB-0700	Light green	0.70 g/cm <sup>3</sup>	130–140 °C	epoxy board, prepreg lay-up tools, low linear coefficient of thermal expansion								
WB-0890	Dark blue	0.89 g/cm <sup>3</sup>	100–110 °C	epoxy board, lay-up tools for low temperature prepregs, very fine surface structure, good dimensional stability								
WB-1404	Olive	1.40 g/cm <sup>3</sup>	75–80 °C	can be polished to a high gloss, good impact strength, good styrene resistance								
WB-1700	Dark gray	1.70 g/cm <sup>3</sup>	120–125 °C	can be polished to a high gloss, chemical resistant								
<b>RAKU® TOOL Close Contour Casting (CCC) / Close Contour Blocks (CB)</b>												
CC/CB-6010	Brown	0.80 g/cm <sup>3</sup>	75–80 °C	models, molds for laminating, high compressive strength								
CC/CB-6503	Blue	1.85 g/cm <sup>3</sup>	80–85 °C	dense structure, galvano bath models								
CC/CB-6506	Dark gray	1.90 g/cm <sup>3</sup>	110–115 °C	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	1.40 g/cm <sup>3</sup>	75–80 °C	can be polished to a high gloss, good impact strength, good styrene resistance								
CB-6700	Light green	0.70 g/cm <sup>3</sup>	130–140 °C	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
----------	-----------	------------	------------

**RAMPF** Advanced Polymers GmbH & Co. KG

 Robert-Bosch-Str. 8-10 | 72661 Grafenberg | Germany  
 T +49.7123.9342-0  
 E advanced.polymers@rampf-group.com

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