

RAKU® TOOL Close Contour Products

Resin	Hardener	Stock level	Mix ratio (pbw)	Color	Pot life 25°C (min)	Max. layer thickness (mm)	Density g/cm ³ (ISO 1183) ca.		Key Properties	Applications
RAKU® TOOL Close Contour Pastes (machine applied) 1000 ml										
CP-6060	CP-6060	A	100 : 100	gray	30 – 40	25	0.6		Very fine and homogeneous surface, easy to machine, low dust, low exotherm, can be machined after 9 h RT cure	Large-scale models, wind turbine blade models, boat models
CP-6070	CP-6070	A	100 : 100	brown	30 – 40	40	0.75		Fine, homogeneous surface, easy to machine, can be machined after 10 h RT cure	Design and styling models, master models, molds
CP-6070	CP-6072	A	100 : 100	brown	100 – 120	40	0.75		Very smooth, homogeneous surface, easy to machine, very little dust, can be machined after 18 h RT cure	Design and styling models, master models, molds
CP-6083	CP-6083	B	100 : 100	gray	50 – 60	25	0.85		Good edge strength, high compressive strength, high temperature resistance, fine and homogeneous surface, easy to machine, little dust, low exotherm, can be machined after 10 h RT cure	Large-scale models, wind turbine blade models, boat models
CP-6083	CP-6084	B	100 : 100	gray	60 – 70	25	0.85		Good edge and high compressive strength, easy to machine, little dust, low exothermic, slump resistant on vertical surfaces in layers up to 25 mm thickness	Large-scale models, wind turbine blade models, boat models
CP-6102	CP-6102	B	100 : 100	gray	50 – 60	25	1.0		Closed, very fine and homogeneous surface, good edge strength, high compressive strength, good temperature resistance, easy to machine, little dust, low exotherm, can be machined after 10h RT cure. Suitable for direct tooling.	Large-scale models, wind turbine blade models, boat models
RAKU® TOOL Repair Systems for Epoxy Close Contour Pastes 100 ml										
CP-6060	EH-2936-2	B	100 : 60	gray	15 – 20		0.7		> Slump resistant on vertical surfaces in layers up to 20 mm thickness > Sufficient pot life with rapid cure > Similar mechanical properties to those of cured Close Contour Pastes	Repair of Close Contour Paste CP-6060 R/H
CP-6070	EH-2936-2	B	100 : 50	brown	15 – 20		0.75			Repair of Close Contour Paste CP-6070 R/H
CP-6083	EH-2936-2	B	100 : 45	gray	15 – 20		0.85			Repair of Close Contour Paste CP-6083 R/H
CP-6102	EH-2936-2	B	100 : 40	gray	15 – 20		1.00			Repair of Close Contour Paste CP-6102 R/H
RAKU® TOOL Epoxy Pastes (hand applied) 500 ml										
EP-2301	EH-2931	A	100 : 100	brown	40 – 45	40	0.7		Easily shaped with wood working tools, good adhesion to most supporting structures	Styling and design models, master models, patterns

A = available in stock, B = please check with customer service
 CP Close Contour Paste (R= Resin, H= Hardener)
 EH Epoxy Hardener
 EP Epoxy Paste/Resin

RAKU® TOOL Close Contour Casting (CCC) / Close Contour Blocks (CB)										
	Color	Stock level	Density g/cm ³ (ISO 1183) ca.	Shore Hardness D (ISO 868)	Coefficient of thermal expansion 10 ⁻⁶ K ⁻¹ (ISO 11359)	Deflection temperature °C (ISO 75)	Compressive strength MPa (ISO 604)	Compressive modulus MPa (ISO 604)	Key Properties	Applications
CC-6010 / CB-6010	brown	A	0.80	65 – 70	65 – 70	75 – 80	35 – 40	1300 – 1600	<ul style="list-style-type: none"> > Fine surface structure > Easily machined > Similar properties to RAKU® TOOL modeling boards 	Master models, cubing models, patterns
CC-6503 / CB-6503	blue	A	1.85	85 – 90	40 – 45	80 – 85	95 – 105	9500	<ul style="list-style-type: none"> > Very dense structure > Very homogeneous, fine surface and as a result, very good surface of nickel bowl, i.e. little finishing required and therefore large cost savings > Easily machined like board material WB-1600 > Low coefficient of thermal expansion > Good abrasion resistance 	Galvanobath models, lay-up tools, RIM tools
CC-6504 / CB-6504	beige	B	1.87	85 – 90	40	80	90 – 100	10000	<ul style="list-style-type: none"> > Very dense structure > Easily machined like board material WB-1600 > Low coefficient of thermal expansion > High compressive strength / stiffness > Good abrasion resistance > Tools do not need to be polished = time saving > Tools weigh less (vs Zamak) = easy handling and transport > Changes are easily possible 	Metal sheet forming, Jigs
CC-6506 / CB-6506	dark gray	A	1.90	90 – 95	35	110 – 115	120 – 130	13000	<ul style="list-style-type: none"> > Very dense surface structure > Can be polished > Good heat resistance > High compressive strength > Good resistance to chemicals > Time savings through direct milling of mold via surface data > Better pressing of sheet metal parts 	Molds for ceramic pressure casting, Metal sheet forming, vacuum forming tools, Lay-up tools
CC-6507 / CB-6507	olive	A	1.40	85 – 90	50 – 55	75 – 80	85 – 95	3500 – 4000	<ul style="list-style-type: none"> > Dense surface structure > Very easily machined > Good dimensional stability > Good abrasion resistance and impact strength 	Pattern plates and core boxes, Machined negatives and positives, Models, molds and tools, Hammer forms and jigs
CB-6691	blue	B	0.69	70 – 75	35 – 45	100 – 110	55 – 60	2000 – 2500	<ul style="list-style-type: none"> > Epoxy based material > Very fine surface structure > Excellent machinability > Good dimensional stability > Heat resistant up to 110 °C 	Lay-up tools for low temperature tooling prepregs Vacuum forming molds Medium temperature applications
CB-6700	light green	A	0.70	70 – 75	35 – 45	130 – 140	60 – 70	2300 – 2800	<ul style="list-style-type: none"> > Epoxy based material > Very fine surface structure > Excellent machinability > Good dimensional stability > Heat resistant up to 130 °C 	Lay-up tools for prepreg, vacuum forming molds, high temperature applications

CB Close Contour Block is supplied as a customized size of a rectangular, unmachined block.

CC Close Contour Casting is supplied as a three dimensional shape which is already a close contour of your final shape.

Offset requirements for CB products: The general rule is that RAMPF Tooling Solutions only adds an offset for shrinkage to the dimensions indicated on the customer's order. The customer has to assess how many mm machining/processing offset is needed for the unmachined block he receives. We recommend a machining/processing offset of minimum 10 mm. Dimensions ordered = dimensions supplied, within the specifications. Close Contour Blocks are unmachined, only basic cleaned cast blocks. Some release agent residue on the surface is possible. Sharp edges are milled due to risk of injury.

Offset requirements for CC products: For a dimension of up to 1000 mm, an offset of 20 mm per surface to be worked on must be added. All larger dimensions need to have a shrinkage offset of 0.5-2 % (dependant on product) + offset for processing of minimum + 10 mm per surface. However, each project still needs to be discussed with the responsible project manager at RAMPF Tooling Solutions.

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