

CP-6102 R / CP-6102 H

Close Contour Paste

Machine applied epoxy paste

Key Properties

- Dense, very fine and homogeneous surface
- Good edge strength
- High compressive strength
- Good heat resistance
- Easy to process
- Low exothermic, can be machined after 10 h room temperature curing

Applications

- Large-scale models
- Wind turbine blade models
- Boat models
- Molds for direct tooling

Processing Properties

		Unit	CP-6102-R	CP-6102-H
Color	visual		gray	white
Mix ratio		pbw	100	100
Mix ratio		pbv	100	100
Density	ISO 1183	g/cm ³	ca. 1.00	ca. 1.00

		Unit	CP-6102-R / CP-6102-H
Pot life at 25 °C	1000 ml	min	50 - 60
Max. layer thickness		mm	25
Machinable		h	10

Cured / Mechanical Properties

		Unit	CP-6102-R / CP-6102-H 7 days at RT or 14h at 40°C	CP-6102-R / CP-6102-H 16h at RT + 8h at 80°C
Cure				
Color		visual	gray	gray
Density	ISO 1183	g/cm ³	ca. 1.00	ca. 1.00
Hardness	ISO 868	Shore D	60 - 70	70 - 75
Coefficient of thermal expansion	ISO 11359	10 ⁻⁶ K ⁻¹	75 - 80	70 - 75
Deflection temperature, HDT	ISO 75	°C	50 - 55	70 - 75
Glass transition temperature, Tg	DSC	°C	60 - 65	80 - 85
Compressive strength	ISO 604	MPa	35 - 40	45 - 50
Compressive modulus	ISO 604	MPa	1,600 - 1,700	1,700 - 1,800
Flexural strength	ISO 178	MPa	25 - 30	30 - 35
Flexural modulus	ISO 178	MPa	1,200 - 1,300	2,000 - 2,100
Linear shrinkage*		mm/m	ca. 1.50	ca. 1.50

*Measured on 20 mm layer thickness after cure for 7 days at RT.

CP-6102 R / CP-6102 H

Close Contour Paste

Machine applied epoxy paste

Processing

The processing temperature and material temperature should be between 20-25°C, never below 18°C. Avoid applying over 25 mm at once, for thicker layers it is recommended to apply the 2nd layer after the first one has gelled.

Set up parameters for the 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.

Packaging

RAKU® TOOL CP-6102-R	180 kg, 40 kg
RAKU® TOOL CP-6102-H	180 kg, 40 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.