

RAKU®TOOL

Close Contour Paste

			CP-6050JP R CP-6052JP H	CP-6070JP R CP-6070JP H	EP-2343JP EH-2943JP	CP-6083 R CP-6084 H	CP-6100JP R CP-6100JP H	CP-6161JP R CP-6161JP H	CP-6130JP R CP-6130JP H
Mix Ratio (by wt.)			100:100	100:100	100:50	100:100	100:100	100:100	100:100
Color			Light brown	Brown	Light brown	Light gray	Light blue	Dark gray	Gray
Density	ISO1183	g/cm ³	ca. 0.53	ca. 0.75	ca.0.55	ca. 0.85	ca. 1.3	ca. 1.75	ca. 1.25
Applications			Design models Styling models	Master models Molds	Repair	Vacuum forming FRP molds	Tooling jigs Molds	Tooling jigs Sheet metal forming	Lay-up tools High temperature applications
Features			Low exotherm	Easily shaped & machined	Fast cure	Low exotherm	Low CTE	Very dense surface	Heat resistant up to 130°C
Hardness	ISO868	Shore D	40-45	55-60	40-45	65-70	85-90	88-90	88-90
Pot life	500ml	min	70-90	30-40	5-10	ca. 60	40-50	30-40	30-40
CTE	ISO11359	$\times 10^{-6}K^{-1}$	55-60	70-75	45-50	70-80	35-40	40-50	45-50
Deflection Temperature	HDT/ISO75	°C	40-45	60-65	60-65	50-55	70-75	55-60	130-140
Compressive Strength	ISO604	Mpa	5-10	18-20	-	35-40	110-120	100-110	150-160
Compressive Modulus	ISO604	Mpa	150-200	900-1000	-	1800-2300	6500-7500	7500-8000	5000-5500
Flexural Strength	ISO178	Mpa	5-10	16-18	-	25-30	60-70	63-68	65-70
Flexural Modulus	ISO178	Mpa	150-200	800-900	-	1500-2000	6500-7500	6800-7300	5500-6000
Layer Thickness		mm	40	40	20	40	40	20	20
Cure			3 hr/20-25°C +12 hr/50°C	7 days/20-25°C or 14 hr/40°C	4 hr/20-25°C	7 days/20-25°C or 14 hr/40°C	16 hr/20-25°C +8hr/60°C	7 days/20-25°C or 14 hr/40°C	16 hr/20-25°C +14 hr/130°C
Packging			21kg (50L drum) 84kg (200L drum)	32kg (50L drum) 130kg (200L drum)	EP-2343JP : 8kg EH-2943JP : 4kg	38kg (50L drum)	50kg (50L drum) 200kg (200L drum)	50kg (50L drum) 200kg (200L drum)	50kg (50L drum) 200kg (200L drum)
Remarks			The curing agent CP-6050JP H, which does not require heat treatment, is made to order.	The gray resin CP-6071JP R is made to order.	Use by hand mixing or mechanical mixing instead of mechanical discharge.	After cure (14 hr/80°C) Deflection Temperature 90-95°C			