

## Close Contour Paste

Machine dispensed epoxy paste

### Key Properties

- Very fine and homogeneous surface
- Easy to machine, low dust
- Low exotherm, can be machined after 10 h RT curing
- Layer thickness 40 mm without slump on vertical surfaces

### Applications

- Design and Styling models
- Master models
- Molds

### Processing Properties

|           |          |                   | CP-6070 Resin | CP-6070 Hardener |
|-----------|----------|-------------------|---------------|------------------|
| Color     | visual   |                   | Brown         | White            |
| Mix ratio |          | parts by weight   | 100           | 100              |
|           |          | parts by volume   | 100           | 100              |
| Density   | ISO 1183 | g/cm <sup>3</sup> | ca. 0.70      | ca. 0.70         |

|                            |         |     | CP-6070 Resin / Hardener |
|----------------------------|---------|-----|--------------------------|
| Pot life at 25 °C          | 1000 ml | min | 30 - 40                  |
| Layer thickness            |         | mm  | 40                       |
| Machinable after (at 25°C) |         | h   | 10                       |

### Cured / Mechanical Properties

Cure: 7 days at RT or 14h at 40°C

|                                  |           |                                  | CP-6070 Resin / Hardener        |
|----------------------------------|-----------|----------------------------------|---------------------------------|
| Appearance                       | visual    |                                  | Brown                           |
| Density                          | ISO 1183  | g/cm <sup>3</sup>                | ca. 0.75                        |
| Shore hardness D                 | ISO 868   |                                  | 55 – 60                         |
| Coefficient of thermal expansion | ISO 11359 | 10 <sup>-6</sup> K <sup>-1</sup> | 70 – 75                         |
| Deflection temperature, HDT      | ISO 75    | °C                               | 50 - 55 (70 – 75) <sup>1)</sup> |
| Glass Transition Temperature, Tg | DSC       | °C                               | 55 - 60 (80 – 85) <sup>1)</sup> |
| Compressive strength             | ISO 604   | MPa                              | 18 – 23                         |
| Compressive modulus              | ISO 604   | MPa                              | 900 – 1000                      |
| Flexural strength                | ISO 178   | MPa                              | 15 – 20                         |
| Flexural modulus                 | ISO 178   | MPa                              | 800 – 900                       |
| Linear shrinkage*                |           | mm / m                           | ca. 1.5                         |

\*Measured on 20 mm layer thickness after cure 7 days at RT. / <sup>1)</sup> Test pieces were post cured at 80°C for 14 hours.

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**Processing**

**The processing and material temperature should be between 20-25 °C, never below 18 °C.**

Set up parameters for 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.

Avoid applying over 40 mm at once, for thicker layers it is recommended to apply the 2<sup>nd</sup> layer after the first one has gelled.

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**Packaging**

|   |  |
|---|--|
| RAKU-TOOL <sup>®</sup> CP-6070 Resin    | 32 kg in 50L drum, 130 kg in 200L drum |
| RAKU-TOOL <sup>®</sup> CP-6070 Hardener | 32 kg in 50L drum, 130 kg in 200L drum |

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**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.

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**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.

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