

Close Contour Paste

Machine dispensed epoxy paste

Key Properties

- 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

Applications

- Large-scale models
- Wind turbine blade models
- Boat models

Processing Properties

			CP-6083 Resin	CP-6084 Hardener
Color	visual		Gray	White
Mix ratio		pbw	100	100
		pbv	100	100
Density	ISO 1183	g/cm ³	ca. 0.80	ca. 0.80

			CP-6083 Resin / CP-6084 Hardener
Pot life at 25 °C	1000 ml	min	60 – 70
Layer thickness		mm	25
Machinable after (at 25°C)		h	14

Cured / Mechanical Properties

			CP-6083 Resin / CP-6084 Hardener	
			Cure: 7 days at RT or 14h at 40°C	Cure: 14h at 80°C
Appearance	visual		Gray	Gray
Density	ISO 1183	g/cm ³	ca. 0.85	ca. 0.85
Shore hardness D	ISO 868		65 – 70	68 – 72
Coefficient of thermal expansion	ISO 11359	10 ⁻⁶ K ⁻¹	65 – 75	57 – 67
Deflection temperature, HDT	ISO 75	°C	55 – 60	85 – 90
Glass Transition Temperature, Tg	DSC	°C	55 – 60	85 – 90
Compressive strength	ISO 604	MPa	40 – 45	48 – 52
Compressive modulus	ISO 604	MPa	1,500 – 2,000	1,800 – 2,300
Flexural strength	ISO 178	MPa	30 – 35	35 – 40
Flexural modulus	ISO 178	MPa	1,700 – 2,200	1,700 – 2,200
Linear shrinkage*		mm / m	<1.0	<1.0

*Measured on 25mm layer thickness.

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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 25 mm at once, for thicker layers it is recommended to apply the 2nd layer after the first one has gelled.

Packaging

RAKU® TOOL CP-6083 Resin	38 kg in 50L drum, 150 kg in 200L drum
RAKU® TOOL CP-6084 Hardener	38 kg in 50L drum, 150 kg in 200L drum

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.
