












































































**RAKU-TOOL® Composite Product Recommendations**

Resin	Hardener	Pot life at 25°C (min)			ISO 75 (°C)	Key Properties	hand/ wet lay-up	vacuum bagging/ wet lay-up	resin infusion	vacuum bagging/ prepreg (out of autoclave)	autoclave process	wet com- pression molding	RTM	galvano bath models	
		60 min	180 min	360 min											
<b>RAKU-TOOL® Epoxy Gelcoat Systems (250 ml)</b>															
EG-2100	EH-2901-2	15–20 min		60–65°C	can be sanded and polished										
	EH-2950-1	35–40 min		95–100°C	can be sanded and polished, good interlayer adhesion, even with gelation over night										
EG-2101	EH-2901-2	20–25 min		55–60°C	can be sanded and polished, good covering power, good machinability										
	EH-2950-1	40–50 min		88–93°C											
EG-2102	EH-2901-2	20–25 min		60–65°C	abrasion and chemical resistant										
	EH-2950-1	40–50 min		95–100°C											
EG-2104	EH-2950-1	35–45 min		100–105°C	can be polished to a high gloss										
EG-2105	EH-2950-1	25–35 min		125–130°C	excellent styrene resistance, can be polished to a high gloss										
EG-2107	EH-2950-1	120–150 min		180–190°C	high temperature applications										
<b>RAKU-TOOL® Epoxy Coupling Layer (500 ml)</b>															
EL-2209-1	EH-2950-1	20–30 min		100–105°C	ready-made coupling layer, excellent interlayer adhesion										
<b>RAKU-TOOL® Epoxy Laminating Systems (500 ml)</b>															
EL-2200	EH-2900	70 min		48–53°C	viscosity 1000–1300 mPa/s, multipurpose, laminating and back filling resin										
EL-2201	EH-2904-1	35 min		55–60°C	viscosity 700–1100 mPa/s, high mechanical properties at room temperature cure										
	EH-2905-1	65 min		53–58°C											
	EH-2906-1	145 min		50–55°C											
EL-2203	EH-2952-1	60 min		115–120°C	viscosity 400–700 mPa/s, low-viscosity, excellent wetting properties, good gelation at room temperature										
	EH-2953-1	100 min		115–120°C											
EL-2204	EH-2954-2	110 – 130 min		180–190°C	viscosity 1300–2000 mPa/s, high temperature applications										
	EH-2955-2	230–250 min		180–190°C											
<b>RAKU-TOOL® Epoxy Casting Systems (1000 ml)</b>															
EC-2404	EH-2952-1	130 min		115–120°C	high temperature resistance, easy to cast										
EC-2461	EH-2961 AC-9061	120–180 min		95–100°C	backing material with a coefficient of thermal expansion of 10 (10 <sup>-6</sup> K <sup>-1</sup> ), very high compressive strength 150 MPa, minimal shrinkage										

 = mold   
  = model   
  = part

**Temperature  
resistance**

50–80°C	80–120°C	120–160°C	160–200°C
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## RAKU-TOOL® Composite Product Recommendations

Resin	Hardener	Pot life at 25°C (min)			ISO 75 (°C)	Key Properties	hand/ wet lay-up	vacuum bagging/ wet lay-up	resin infusion	vacuum bagging/ prepreg (out of autoclave)	autoclave process	wet com- pression molding	RTM	galvano bath models
		60 min	180 min	360 min										
<b>RAKU-TOOL® Epoxy Infusion Systems (500 ml)</b>														
EL-2203	EH-2970-1	60 min			115–120°C	low-viscosity 400–600 mPa/s, no out gassing under vacuum, excellent wetting and flow properties, good cure at room temperature								
EI-2500	EH-2953-1	60–80 min			110–115°C	RTM injection system for medium to large parts								
EI-2500	EH-2970-1	70 min			110–115°C	low-viscosity 500–1000 mPa/s, no out gassing under vacuum, excellent wetting and flow properties								
EI-2500	EH-2971	90–100 min			100–110°C	low-viscosity 300–700 mPa/s, no out gassing under vacuum, excellent wetting and flow properties								
EI-2500	EH-2972	20–25 min			95–100°C	RTM injection resin for small to medium parts								
EI-2500	EH-2973	80–90 min			133–138°C	Medium temperature applications, low viscosity 300–700 mPa/s, no out gassing under vacuum, excellent wetting and flow properties								
EI-2504	EH-2974	210–270 min			160–165°C	viscosity 550–750 mPa/s, high temperature applications, prepreg lay-up tools								
<b>RAKU-TOOL® Epoxy Laminating Paste Systems (500 ml)</b>														
EL-2207-2	EH-2907-2	45 min			50–55°C	laminating paste, layer thickness 15 mm								
EL-2207-2	EH-2971	120–150 min			70–75°C	laminating paste with increased temperature resistance								
<b>RAKU-TOOL® Epoxy Close Contour Pastes (machine applied) (1000 ml)</b>														
CP-6060 R	CP-6060 H	30–40 min			60–65°C	ca. 0.6 g/cm³, gray, modeling paste, specially suited for large parts								
CP-6070 R	CP-6070 H	30–40 min			70–75°C	ca. 0.75 g/cm³, brown, modeling paste								
CP-6070 R	CP-6072 H	50–60 min			60–65°C	ca. 0.75 g/cm³, brown, modeling paste, less shrinkage than with CP-6070 hardener								
CP-6083 R	CP-6083 H	50–60 min			80–85°C	ca. 0.85 g/cm³, gray, dimensionally stable models and molds with a fine, homogeneous and seamless surface for all part sizes.								
CP-6083 R	CP-6084 H	50–60 min			90–95°C	ca. 0.85 g/cm³, gray, dimensionally stable models and molds with a fine, homogeneous and seamless surface for all part sizes. Reduced reactivity and shrinkage with CP-6083 H.								
CP-6102 R	CP-6102 H	50–60 min			70–75°C	ca. 1.0 g/cm³, gray, dimensionally stable models and molds with a fine, homogeneous and seamless surface for all part sizes.								

= mold    = model    = part

Temperature resistance	50–80°C	80–120°C	120–160°C	160–200°C

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**RAKU-TOOL® Composite Product Recommendations**

Resin	Hardener	Density (g/cm <sup>3</sup> ) ca.	ISO 75 (°C)	Key Properties	hand/ wet lay-up	vacuum bagging/ wet lay-up	resin infusion	vacuum bagging/ prepreg (out of autoclave)	autoclave process	wet com- pression molding	RTM	galvano bath models
<b>RAKU-TOOL® Boards</b>												
SB-0240	Apricot	ca. 0.24 g/cm <sup>3</sup>	55–65 °C	very simple molds for laminating								
SB-0351	Apricot	ca. 0.35 g/cm <sup>3</sup>	60–70 °C	very simple molds for laminating, optimized compressive strength								
SB-0470	Apricot	ca. 0.47 g/cm <sup>3</sup>	60–70 °C	simple molds for laminating								
MB-0600	Brown	ca. 0.60 g/cm <sup>3</sup>	70–75 °C	models, molds for laminating								
MB-0670	Brown	ca. 0.67 g/cm <sup>3</sup>	75–80 °C	models, molds for laminating, low coefficient of thermal expansion								
MB-0720	Brown	ca. 0.72 g/cm <sup>3</sup>	75–80 °C	high quality models, molds for laminating, low coefficient of thermal expansion								
WB-0691	Light blue	ca. 0.69 g/cm <sup>3</sup>	100–110 °C	epoxy board, lay-up tools for low temperature prepreg								
WB-0700	Light green	ca. 0.70 g/cm <sup>3</sup>	130–140 °C	epoxy board, prepreg lay-up tools, low linear coefficient of thermal expansion								
WB-1404	Olive	ca. 1.40 g/cm <sup>3</sup>	75–80 °C	can be polished to a high gloss, good impact strength, good styrene resistance								
WB-1700	Dark gray	ca. 1.70 g/cm <sup>3</sup>	120–125 °C	can be polished to a high gloss, chemical resistant								
<b>RAKU-TOOL® Close Contour Casting (CCC) / Close Contour Blocks (CB)</b>												
CC/CB-6010	Brown	ca. 0.80 g/cm <sup>3</sup>	75–80 °C	models, molds for laminating, high compressive strength								
CC/CB-6503	Blue	ca. 1.85 g/cm <sup>3</sup>	80–85 °C	dense structure, galvano bath models								
CC/CB-6506	Dark gray	ca. 1.90 g/cm <sup>3</sup>	110–115 °C	can be polished to a high gloss, chemical resistant, lay-up tools for low temperature prepreg, linear coefficient of thermal expansion								
CC/CB-6507	Olive	ca. 1.40 g/cm <sup>3</sup>	75–80 °C	can be polished to a high gloss, good impact strength, good styrene resistance								
CB-6691	Light blue	ca. 0.69 g/cm <sup>3</sup>	100–110 °C	epoxy material, lay-up tools for low temperature prepreps								
CB-6700	Light green	ca. 0.70 g/cm <sup>3</sup>	135–140 °C	epoxy material, prepreg lay-up tools, low linear coefficient of thermal expansion								

The mechanical properties and temperature resistance are only obtained through the post cure according to the recommended cure schedule.

For physical and mechanical properties please refer to the individual product technical data sheets.

 = mold

 = model

 = part

**Temperature  
resistance**

50–80 °C	80–120 °C	120–160 °C	160–200 °C
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