

# RAKU-TOOL<sup>®</sup> CP-6080 Resin / Hardener

## Close Contour Paste

### Machine dispensed epoxy paste

PC - Rev.-Status: 01- 2010/09/01

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#### Key Properties

- Very fine and homogeneous surface
- Easy to machine, low dust
- Low exotherm, can be machined after 24 h RT curing
- Layer thickness 40mm without slump on vertical surfaces

#### Applications

- Master models
- Data control models
- Molds

#### Processing Properties

			CP-6080 Resin	CP-6080 Hardener
Color	visual		Gray	White
Mix ratio		parts by weight	100	100
		parts by volume	100	100
Density	ISO 1183	g/cm <sup>3</sup>	0.80	0.80

			CP-6080 Resin / Hardener
Pot life at 25 °C	1000 ml	min	30 - 40
Layer thickness		mm	40
Machineable after (at 25°C)		h	24

#### Cured / Mechanical Properties

##### Cure: 7 days at RT or 14h at 40°C

			CP-6080 Resin / Hardener
Appearance	visual		Gray
Density	ISO 1183	g/cm <sup>3</sup>	0.85
Shore hardness D	ISO 868		65 – 70
Coefficient of thermal expansion	ISO 11359	10 <sup>-6</sup> K <sup>-1</sup>	65 – 70
Deflection temperature, HDT	ISO 75	°C	60 – 65 <sup>1)</sup>
Glass Transition Temperature, Tg	DSC	°C	70 – 75 <sup>2)</sup>
Compressive strength	ISO 604	MPa	35 – 40
Compressive modulus	ISO 604	MPa	2,500 – 3,000
Flexural strength	ISO 178	MPa	18 – 23
Flexural modulus	ISO 178	MPa	2,300 – 2,800
Linear shrinkage*		mm / m	0.1

\*measured on maximum layer thickness as stated above / <sup>1)</sup>+<sup>2)</sup> Test pieces were post cured at 70°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® CP-6080 Resin	38 kg in 50 L drums
RAKU-TOOL® CP-6080 Hardener	38 kg in 50 L drums

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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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