

RAKU-TOOL[®] EL-2201 / EH-2904-1, EH-2905-1, EH-2906-1

Epoxy Laminating System

Unfilled epoxy with variable reactivity (fast / medium / slow)

PC - Rev.-Status: 01- 2009/06/25

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Key Properties

- Reduced hazard rating
- Pot life and curing time can be adjusted through choice of hardener
- High mechanical properties at RT curing
- Excellent compatibility with fibers, fabrics and fillers
- Backing resin with mineral and metal fillers

Applications

- Jigs and foundry patterns
- General tools and tooling aids
- UP Lay up tools
- Backing structures

Processing Properties

			EL-2201	EH-2904-1	EH-2905-1	EH-2906-1
Color	visual		Clear	Clear	Clear	Clear
Mix ratio		pbw	100	50		
			100		50	50
Density	ISO 1183	g/cm ³	1.17	1.00	1.01	1.01
Viscosity at 25 °C	ISO 2555	m Pa.s	7000-9000	90-130	80-120	40-80

			EL-2201 / EH-2904-1	EL-2201 / EH-2905-1	EL-2201 / EH-2906-1
Mix viscosity at 25 °C	ISO 2555	m Pa.s	900-1100	700-800	700-800
Pot life at 25 °C	500 ml	min	35	65	145
Max. layer thickness		mm	8	8	8
Demold time		h	12	16	18

Cured / Mechanical Properties

Cure: 7 days at RT or 14h at 40°C			EL-2201 / EH-2904-1	EL-2201 / EH-2905-1	EL-2201 / EH-2906-1
Appearance	visual		Clear	Clear	Clear
Density	ISO 1183	g/cm ³	1.16	1.16	1.16
Deflection temperature, HDT	ISO 75	°C	55-60	53-58	45-50
Glass Transition Temperature, Tg	DSC	°C	55-60	50-55	50-55
Flexural strength	ISO 178	MPa	100-105	100-105	110-115
Flexural modulus	ISO 178	MPa	2800-3300	3000-3500	3000-3500

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Processing

The processing and material temperature should be between 20-25 °C.

Mix the two components thoroughly in the ratio indicated.

Impregnate each layer of cloths to construct the laminate layer by layer.

Post-curing will improve final properties.

Packaging

RAKU-TOOL [®] EL-2201	25 kg / 200 kg
RAKU-TOOL [®] EH-2904-1	6 x 0.28 / 2 kg / 25 kg
RAKU-TOOL [®] EH-2905-1	6 x 0.28 / 2 kg / 25 kg
RAKU-TOOL [®] EH-2906-1	6 x 0.28 / 2 kg / 25 kg

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.
