

RAKU-TOOL[®] EL-2204 / EH-2954-1, EH-2955-1

Epoxy Laminating System

Unfilled Epoxy System with variable reactivity (slow/medium)

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Key Properties

- Pot life and curing time can be adjusted through choice of hardener
- Very high temperature resistance (190°C)
- Excellent wetting properties even with carbon fibres

Applications

- High temperature resistant, glass or carbon fiber impregnated tools
- Prep-reg lay up tools for high temperature curing
- Backing structures
- With corresponding gelcoat also suitable for tools with high temperature resistance

Processing Properties

			EL-2204	EH-2954-1	EH-2955-1
Color	visual		Amber	Yellowish	Yellowish
Mix ratio		parts by weight	100	40	
Density	ISO 1183	g/cm ³	1.17	1.03	1.00
Viscosity at 25 °C	ISO 2555	m Pa.s	4000-4500	150-200	80-100

			EL-2204 / EH-2954-1	EL-2204 / EH-2955-1
Mix viscosity at 25 °C	ISO 2555	m Pa.s	1500-2000	1000-1500
Pot life at 25 °C	500 ml	min	120	240
Max. layer thickness		mm	8	8
Demold time		h	24	48

Cured / Mechanical Properties

Cure: after initial hardening post cure in steps up to 180°C			EL-2204 / EH-2954-1	EL-2204 / EH-2955-1
Appearance	visual		Amber	Amber
Density	ISO 1183	g/cm ³	1.2	1.2
Deflection temperature, HDT	ISO 75	°C	175-185	175-185
Glass Transition Temperature, Tg	DSC	°C	180-190	180-190
Flexural strength	ISO 178	MPa	120-130	130-140
Flexural modulus	ISO 178	MPa	3800-4300	3800-4300

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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-2204	25 kg
RAKU-TOOL [®] EH-2954-1	5 kg
RAKU-TOOL [®] EH-2955-1	5 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.
