

RAKU-TOOL[®] EL-2209 / EH-2950

Epoxy Coupling Coat

Prefabricated, two component coupling coat

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

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Key Properties

- Universally applicable coupling coat
- Very good temperature resistance
- Excellent interlayer adhesion
- Consistent thixotropy

Applications

- Production of tools, molds and tooling aids with various systems like Epoxy and Polyurea Systems
- Coupling layer between gelcoat and backing structure (e.g. casting, laminating, tamping)

Processing Properties

			EL-2209	EH-2950
Color	visual		Gray	Clear
Mix ratio		pb weight	100	10
Density	ISO 1183	g/cm ³	1.79	1.01
Viscosity at 25 °C	ISO 2555	m Pa.s	100000-200000	200-400

			EL-2209 / EH-2950
Mix viscosity at 25 °C	ISO 2555	m Pa.s	80000-160000
Pot life at 25 °C	500 ml	min	30
Max. layer thickness		mm	-
Demold time		h	16

Cured / Mechanical Properties

Cure: 7 days at RT or 14h at 40°C			EL-2209 / EH-2950
Appearance	visual		Gray
Density	ISO 1183	g/cm ³	1.6
Deflection temperature, HDT	ISO 75	°C	110-115*
Glass Transition Temperature, Tg	DSC	°C	110-115*
Flexural strength	ISO 178	MPa	95-105
Flexural modulus	ISO 178	MPa	6800-7300

*The values for HDT and Tg have been measured after post cure at 80°C.

Processing

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

Mix the two components thoroughly in the ratio indicated. Apply the coupling coat with a spatula/brush in thin, even layers. Post-curing will improve final properties.

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Packaging

RAKU-TOOL [®] EL-2209	10 kg
RAKU-TOOL [®] EH-2950	1 kg / 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.