

# RAKU-TOOL<sup>®</sup> EC-2404 / EH-2952

## Epoxy Casting System

High temperature resistance, aluminum filled

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

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### Key Properties

- High temperature resistance after post cure
- Room temperature hardening and demoldable
- Easily workable
- Good chemical resistance

### Applications

- Vacuum forming molds
- Jigs
- Injection molds
- Foam molding tools

### Processing Properties

			EC-2404	EH-2952
Color	visual		Gray	Clear
Mix ratio		parts by weight	100	9
Density	ISO 1183	g/cm <sup>3</sup>	1.74	0.95
Viscosity at 25 °C	ISO 2555	m Pa.s	20000-30000	20-50

			EC-2404 / EH-2952
Mix viscosity at 25 °C	ISO 2555	m Pa.s	3300-4800
Pot life at 25 °C	1000 ml	min	145
Max. layer thickness		mm	60
Demold time		h	18

### Cured / Mechanical Properties

Cure: after initial hardening post cure in steps up to 120°C			EC-2404 / EH-2952
Appearance	visual		Gray
Density	ISO 1183	g/cm <sup>3</sup>	1.7
Shore hardness D	ISO 868		85-90
Coefficient of thermal expansion	ISO 11359	10 <sup>-6</sup> K <sup>-1</sup>	40-45
Deflection temperature, HDT	ISO 75	°C	115-120
Glass Transition Temperature, Tg	DSC	°C	115-120
Compressive strength	ISO 604	MPa	120-125
Compressive modulus	ISO 604	MPa	8500-9000
Flexural strength	ISO 178	MPa	95-100
Flexural modulus	ISO 178	MPa	7300-7800
Linear shrinkage*		mm / m	0.1

\*measured on maximum layer thickness as stated above

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### Processing

Mix the two components thoroughly in the ratio indicated.

Degassing and /or post-curing will improve final properties.

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

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### Packaging

RAKU-TOOL<sup>®</sup> EC-2404

5 kg / 25 kg

RAKU-TOOL<sup>®</sup> EH-2952

4.5 kg / 22.5 kg

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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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