

# RAKU-TOOL<sup>®</sup> EI-2504 / EH-2974

## Epoxy Infusion System

### Temperature resistant

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

Page 1 of 2

**Key Properties**

- Excellent wetting properties
- Flows very well
- Temperature resistant up to 170°C

**Applications**

- Resin Infusion

**Processing Properties**

|                    |          |                   | EI-2504 | EH-2974 |
|--------------------|----------|-------------------|---------|---------|
| Color              | visual   |                   | Clear   | Clear   |
| Mix ratio          |          | pbw               | 100     | 32      |
| Density            | ISO 1183 | g/cm <sup>3</sup> | 1.14    | 0.95    |
| Viscosity at 25 °C | ISO 2555 | m Pa.s            | 700-900 | 10-20   |

|                        |          |        | EI-2504 / EH-2974 |
|------------------------|----------|--------|-------------------|
| Mix viscosity at 25 °C | ISO 2555 | m Pa.s | 550-750           |
| Pot life at 25 °C      | 500 ml   | min    | 240-300           |
| Max. layer thickness   |          | mm     | 8                 |
| Demold time            |          | h      | 24                |

**Cured / Mechanical Properties**

| <b>Cure:<br/>after initial hardening cure in steps up to 160°C</b> |          |                   | EI-2504 / EH-2974 |
|--|----------|-------------------|-------------------|
| Appearance   | visual   |                   | Clear             |
| Density  | ISO 1183 | g/cm <sup>3</sup> | 1.1               |
| Deflection temperature, HDT  | ISO 75   | °C                | 160-165           |
| Glass Transition Temperature, Tg                                   | DSC      | °C                | 168-173           |
| Flexural strength  | ISO 178  | MPa               | 110-120           |
| Flexural modulus   | ISO 178  | MPa               | 3300-3800         |

**Processing**

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

Mix the two components thoroughly in the ratio indicated.

Post-curing will improve final properties.

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### Packaging

|                                |      |
|--------------------------------|------|
| RAKU-TOOL <sup>®</sup> EI-2504 | 25kg |
| RAKU-TOOL <sup>®</sup> EH-2974 | 4 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.