

RAKU-TOOL[®] EL-2203 / EH-2952, EH-2953

Epoxy Laminating System

Temperature resistant, unfilled epoxy system with slow or fast reactivity

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

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Key Properties

- Low viscosity
- Excellent wetting properties
- Good cure at room temperature
- Temperature resistant up to 120°C

Applications

- Laminated molds
- RTM or RIM tools
- For glass or carbon fiber laminates
- Resin Infusion

Processing Properties

			EL-2203	EH-2952	EH-2953
Color	visual		Clear	Clear	Clear
Mix ratio		pbw	100	25	
			100		25
Density	ISO 1183	g/cm ³	1.16	0.95	0.95
Viscosity at 25 °C			1000-1500	20-50	20-50
			EL-2203 EH-2952	EL-2203 EH-2953	
Mix viscosity at 25 °C	ISO 2555	m Pa.s	300-500	300-500	
Pot life at 25 °C	500 ml	min	60	100	
Max. layer thickness		mm	8	8	
Demold time		h	16	18	

Cured / Mechanical Properties

Cure: after initial hardening post cure in steps up to 120°C			EL-2203 EH-2952	EL-2203 EH-2953
Appearance	visual		Clear	Clear
Density	ISO 1183	g/cm ³	1.1	1.1
Deflection temperature, HDT	ISO 75	°C	115-120	115-120
Glass Transition Temperature, Tg	DSC	°C	115-120	115-120
Flexural strength	ISO 178	MPa	110-120	110-120
Flexural modulus	ISO 178	MPa	2800-3300	2800-3300

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.

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Packaging

RAKU-TOOL [®] EL-2203	4.5 kg / 18 kg / 200 kg / 1000 kg
RAKU-TOOL [®] EH-2952	4.5 kg / 22.5 kg / 200 kg
RAKU-TOOL [®] EH-2953	4.5 kg / 22.5 kg / 200 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.