

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

Epoxy Laminating System

Unfilled Epoxy System with variable reactivity (slow/medium)

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

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Key Properties

- Pot life and curing time can be adjusted through choice of hardener
- Very high temperature resistance (180°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	EH-2955
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	600-700	400-500

			EL-2204 / EH-2954	EL-2204 / EH-2955
Mix viscosity at 25 °C	ISO 2555	m Pa.s	3000-4000	3000-4000
Pot life at 25 °C	500 ml		2 h 15 min	6 h
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	EL-2204 / EH-2955
Appearance	visual		Amber	Amber
Density	ISO 1183	g/cm ³	1.2	1.2
Deflection temperature, HDT	ISO 75	°C	170-180	170-180
Glass Transition Temperature, T _g	DSC	°C	170-180	170-180
Flexural strength	ISO 178	MPa	140-150	140-150
Flexural modulus	ISO 178	MPa	3300-3800	3300-3800

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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	5 kg
RAKU-TOOL [®] EH-2955	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.
