

RAKU-TOOL[®] EL-2208 / EH-2952

Epoxy Laminating Paste

Low density and high temperature resistance

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

Page 1 of 2

Key Properties

- Low density
- Very easy to mix
- High stiffness
- High temperature resistance

Applications

- Backing structure for molds and tooling aids
- Production of laminated shells (fabric replacement)
- Production of jigs and fixtures

Processing Properties

			EL-2208	EH-2952
Color	visual		Black	Clear
Mix ratio		parts by weight	100	10
Density	ISO 1183	g/cm ³	0.80	0.95

			EL-2208 / EH-2952
Mix viscosity at 25 °C	ISO 2555	m Pa.s	fibrous paste
Pot life at 25 °C	500 ml	min	120
Max. layer thickness		mm	15-25
Demold time		h	18

Cured / Mechanical Properties

Cure: after initial hardening post cure in steps up to 120°C			EL-2208 / EH-2952
Appearance	visual		Black
Density	ISO 1183	g/cm ³	0.8
Deflection temperature, HDT	ISO 75	°C	120-125
Glass Transition Temperature, Tg	DSC	°C	115-120
Flexural strength	ISO 178	MPa	30-40
Flexural modulus	ISO 178	MPa	4000-4500

RAKU-TOOL® EL-2208 / EH-2952

Epoxy Laminating Paste

Low density and high temperature resistance

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

Page 2 of 2

Processing

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

Small quantities can be mixed by hand (wearing protective rubber gloves) until a homogeneous color is obtained. For larger quantities it is necessary to use a mixing machine. When a mixing machine is used the mixing time should be kept short (under 2 minutes).

The paste can be applied by hand (wearing protective rubber gloves) layer by layer, slightly overlapping and pushed together or it is rolled out in the desired layer thickness using spacing layers. With easy shapes the paste can be evened out and compressed by hand (wearing protective rubber gloves) or using a roller. With more complicated shapes it is recommended to use pressing with steel wool to even out and compress the paste.

Packaging

RAKU-TOOL® EL-2208	15 kg
RAKU-TOOL® EH-2952	4.5 kg / 22.5 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.