# **RAKU® TOOL**



## EG-2101 / EH-2901-2, EH-2950-1

## **Epoxy Gelcoat Resin**

Thixotropic, room temperature curing

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## **Key Properties**

## **Applications**

- Can be sanded and polished
- Adjustable reactivity
- Easy to process
- Good chemical resistance

- Negatives
- Models
- Jigs and fixtures
- Plaster working molds for the ceramics industry

## **Processing Properties**

|           |          | Unit  | EG-2101  | EH-2901-2 | EH-2950-1 |
|-----------|----------|-------|----------|-----------|-----------|
| Color     | visual   |       | white    | yellowish | yellowish |
| Mix ratio |          | pbw   | 100      | 15        | -         |
| Mix ratio |          | pbw   | 100      | -         | 12        |
| Density   | ISO 1183 | g/cm³ | ca. 1.45 | ca. 1.07  | ca. 1.01  |

|                   |        | Unit | EG-2101 / EH-2901-2 | EG-2101 / EH-2950-1 |
|-------------------|--------|------|---------------------|---------------------|
| Pot life at 25 °C | 250 ml | min  | 30 - 35             | 50 - 60             |
| Demold time       |        | h    | 12                  | 16                  |

## **Cured / Mechanical Properties**

| Cure                             |          | Unit     | EG-2101 / EH-2901-2<br>7 days at RT or 14h at 40°C | EG-2101 / EH-2950-1<br>16h at RT + 14h at 80°C |
|----------------------------------|----------|----------|--|--|
| Color                            |          | visual   | white  | white  |
| Density                          | ISO 1183 | g/cm³    | ca. 1.40   | ca. 1.40                                       |
| Hardness                         | ISO 868  | Shore D  | 85 - 90  | 85 - 90  |
| Deflection temperature, HDT      | ISO 75   | °C       | 55 - 60  | 88 - 93  |
| Glass transition temperature, Tg | DSC      | °C       | 55 - 60  | 88 - 93  |
| Abrasion                         | Taber    | mm³/100R | 90 - 100   | 75 - 85  |

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## Processing

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

Mix the two components thoroughly in the ratio indicated.

Apply in thin layers with a brush. Wait until the gelcoat has gelled, but ensure that it is still slightly tacky before proceeding.

EG-2101 / EH-2950-1

The mechanical properties and temperature resistance are only obtained through a post cure according to the recommended cure schedule.

#### Recommended cure schedule

Recommended cure schedule (EG-2101 / EH-2950-1)

After initial curing at room temperature for 12-24 hours depending on the size and thickness of the parts, the parts must be heated up to 80°C in steps and post cured for 14 hours at 80°C, then cooled down gradually. The curing time at room temperature, heating and cooling rate depend on the size and thickness of the parts.

| Packaging            |                |
|----------------------|----------------|
| RAKU® TOOL EG-2101   | 5 kg           |
| RAKU® TOOL EH-2901-2 | 6 x 1 kg       |
| RAKU® TOOL EH-2950-1 | 2 kg, 6 x 1 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.

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Our recommendations on the use of the material are based on many years of experience and current scientific and practical knowledge. They are, however, provided without any obligation on our part and do not relieve the buyer of the need for suitability tests. They do not constitute a legal relationship, nor are any protected third party rights whatsoever affected thereby. The technical data sheet is not a specification, but contains only approximate values.