

#### Key Properties

- Universally applicable coupling coat
- Excellent heat resistance
- Excellent layer adhesion
- Consistent thixotropy

#### Applications

- Production of tools, molds and tooling aids
- Coupling layer between gelcoat and backing structure (e.g. casting, laminate, tamping)

#### Processing Properties

		Unit	EL-2209-2	EH-2950-1
Color	visual		gray	yellowish
Mix ratio		pbw	100	10
Density	DIN 2811-1	g/cm <sup>3</sup>	ca. 1.80	ca. 1.01
Viscosity at 25 °C	DIN 53019-1	mPa·s	350,000 - 550,000	200 - 400

		Unit	EL-2209-2 / EH-2950-1
Mix viscosity at 25 °C	DIN 53019-1	mPa·s	40,000 - 100,000
Pot life at 25 °C	500 ml	min	20 - 30
Demold time		h	16

#### Cured / Mechanical Properties

		Unit	EL-2209-2 / EH-2950-1 16h at RT + 14h at 100°C
Cure			
Color		visual	gray
Density	ISO 1183	g/cm <sup>3</sup>	ca. 1.75
Deflection temperature, HDT	ISO 75	°C	100 - 105
Glass transition temperature, Tg	DSC	°C	100 - 105
Flexural strength	ISO 178	MPa	80 - 90
Flexural modulus	ISO 178	MPa	5,500 - 6,000



## Processing

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

Mix the two components thoroughly in the ratio indicated.

Apply the coupling coat with a spatula/brush in thin, even layers.

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

## Recommended cure schedule

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 100°C in steps and post cured for 14 hours at 100°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 EL-2209-2	10 kg
RAKU® TOOL EH-2950-1	25 kg, 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.