

#### Key Properties

- Easily shaped with wood working tools
- Good adhesion to most substructures

#### Applications

- Design and styling models
- Master models
- Molds

#### Processing Properties

		Unit	EP-2301	EH-2931
Color	visual		brown	white
Mix ratio		pbw	100	100
Mix ratio		pbv	100	100
Density	ISO 1183	g/cm <sup>3</sup>	ca. 0.68	ca. 0.73

		Unit	EP-2301 / EH-2931
Pot life at 25 °C	500 ml	min	40 - 45
Max. layer thickness		mm	40
Machinable		h	16

#### Cured / Mechanical Properties

		Unit	EP-2301 / EH-2931 7 days at RT or 14h at 40°C
Cure			
Color		visual	brown
Density	ISO 1183	g/cm <sup>3</sup>	ca. 0.70
Hardness	ISO 868	Shore D	50 - 55
Coefficient of thermal expansion	ISO 11359	10 <sup>-6</sup> K <sup>-1</sup>	30 - 40
Deflection temperature, HDT	ISO 75	°C	45 - 50
Glass transition temperature, Tg	DSC	°C	45 - 50
Compressive strength	ISO 604	MPa	15 - 20
Compressive modulus	ISO 604	MPa	1,300 - 1,800
Flexural strength	ISO 178	MPa	8 - 13
Flexural modulus	ISO 178	MPa	1,000 - 1,500



## Processing

The processing temperature and material temperature should be between 20-25°C, never below 18°C.

Mix the two components thoroughly in the ratio indicated.

Avoid applying over 40 mm at once, for thicker layers it is recommended to apply the 2nd layer after the first one has gelled.

Small quantities can be mixed by hand. For larger quantities the use of a mixing machine is recommended.

## Packaging

RAKU® TOOL EP-2301	5 kg
RAKU® TOOL EH-2931	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.