

## Adhesive for epoxy boards

### Key Properties

- Similar density, hardness, temperature resistance and coefficient of thermal expansion to epoxy board material

### Applications

- Bonding of epoxy boards

### Processing properties Adhesive

			EP-2304	EH-2934-1
Color	visual		Green	Yellowish
Mix ratio		pb weight	100	20
		pb volume	100	10
Density	ASTM D-792	lb/ft <sup>3</sup> (g/cm <sup>3</sup> )	ca. 54.9 (ca 0.88)	ca. 63.7 (ca. 1.02)
			EP-2304 / EH-2934-1	
Pot life at 25 °C (77°F)	500 ml	min	50 – 60	
Max. layer thickness		in (mm)	–	
Minimal curing time at 25 °C (77°F)		h	16	

### Cured / Mechanical Properties

#### 16h at RT + 14h at 120°C (248°F)

			EP-2304 / EH-2934-1
Aspect	visual		Light green
Density	ASTM D-792	lb/ft <sup>3</sup> (g/cm <sup>3</sup> )	ca. 56 (ca. 0.9)
Shore hardness D	ASTM D-2240		75-80
Coefficient of thermal expansion	ASTM D-3386	10 <sup>-6</sup> F <sup>-1</sup> (10 <sup>-6</sup> K <sup>-1</sup> )	19 – 25 (35 – 45)
Deflection temperature, HDT	ASTM D-648	°F (°C)	239 – 248 (115 – 120)
Glass Transition Temperature, Tg	DSC	°F (°C)	239 – 248 (115 – 120)
Compressive strength	ASTM D-695	psi (MPa)	9,400 – 10,200 (65 – 70)
Compressive modulus	ASTM D-695	psi (MPa)	435,000 – 508,000 (3,000 – 3,500)
Flexural strength	ASTM D-790	psi (MPa)	6,500 – 7,300 (45 – 50)
Flexural modulus	ASTM D-790	psi (MPa)	435,000 – 508,000 (3,000 – 3,500)

### Processing

**The processing and material temperature should be between 20-25 °C (68-77 °F).**

Mix the two components thoroughly in the ratio indicated and apply to both sides of the surface to be bonded. The mechanical properties and temperature resistance are only obtained through the 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 120°C (248°F) in steps and post cured for 14 hours at 120°C (248°F), 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 EP-2304	5 kg
RAKU® TOOL EH-2934-1	1 kg, 6 x 1 kg

### Storage

Original containers should be kept tightly sealed and stored at ambient temperatures (15°C to 30°C) (59-86 °F). 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.