

## Epoxy Gelcoat System

Thixotropic, room temperature curing

### Key Properties

- Reduced hazard rating
- Easy to apply and low odor
- Choice of reactivity
- White surface, can be sanded and polished
- Easy to process

### Applications

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

### Processing Properties

			EG-2101	EH-2901-2	EH-2950-1
Color	visual		White	Yellowish	Yellowish
Mix ratio		parts by weight	100	15	
			100		12
Density	ISO 1183	g/cm <sup>3</sup>	ca. 1.45	ca. 1.07	ca. 1.01

			EG-2101 / EH-2901-2	EG-2101 / EH-2950-1
Pot life at 25 °C	250 ml	min	20-25	40-50
Demold time		h	12	16

### Cured / Mechanical Properties

#### Cure:

			7 days at RT or 14h at 40°C	16h at RT + 14h at 80°C
			EG-2101 / EH-2901-2	EG-2101 / EH-2950-1
Appearance	visual		White	White
Density	ISO 1183	g/cm <sup>3</sup>	ca. 1.4	ca. 1.4
Hardness Shore D	ISO 868		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	mm <sup>3</sup> /100R	90-100	75-85

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## Processing

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**The processing 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 gelcoat has gelled, but ensure that it is still slightly tacky before proceeding.

Degassing will improve mechanical properties.

**EG-2101 / EH-2950-1:** The mechanical properties and temperature resistance are only obtained through the post cure according to the recommended cure schedule.

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

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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.

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## Packaging

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

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## Storage

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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.

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## Handling Precautions

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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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