

TECHNICAL DATASHEET

Lijmset voor Epoxyboard WB-0691 en WB-0890



MALLENBOUW | COMPOSITEN | LIJMEN

Adhesive for epoxy board WB-0691

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Key Properties

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

Applications

- Bonding of epoxy board WB-0691

Processing properties Adhesive

			EP-2303	EH-2934-1
Color	visual		Blue	Yellowish
Mix ratio		pb weight	100	20
		pb volume	100	17
Density	ISO 1183	g/cm ³	ca. 0.86	ca. 1.02
			EP-2303 / EH-2934-1	
Pot life at 25 °C	500 ml	min	50 – 60	
Max. layer thickness		mm	-	
Minimal curing time at 25 °C		h	16	

Cured / Mechanical Properties

Cure: 16h at RT + 14h at 100°C			EP-2303 / EH-2934-1
Aspect	visual		Blue
Density	ISO 1183	g/cm ³	ca. 0.9
Shore hardness D	ISO 868		75 – 80
Coefficient of thermal expansion	ISO 11359	10 ⁻⁶ K ⁻¹	35 – 45
Deflection temperature, HDT	ISO 75	°C	105 – 110
Glass Transition Temperature, Tg	DSC	°C	105 – 110
Compressive strength	ISO 604	MPa	62 – 68
Compressive modulus	ISO 604	MPa	3,000 – 3,500
Flexural strength	ISO 178	MPa	40 – 45
Flexural modulus	ISO 178	MPa	3,000 – 3,500

Processing

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

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 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 EP-2303	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). 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.
