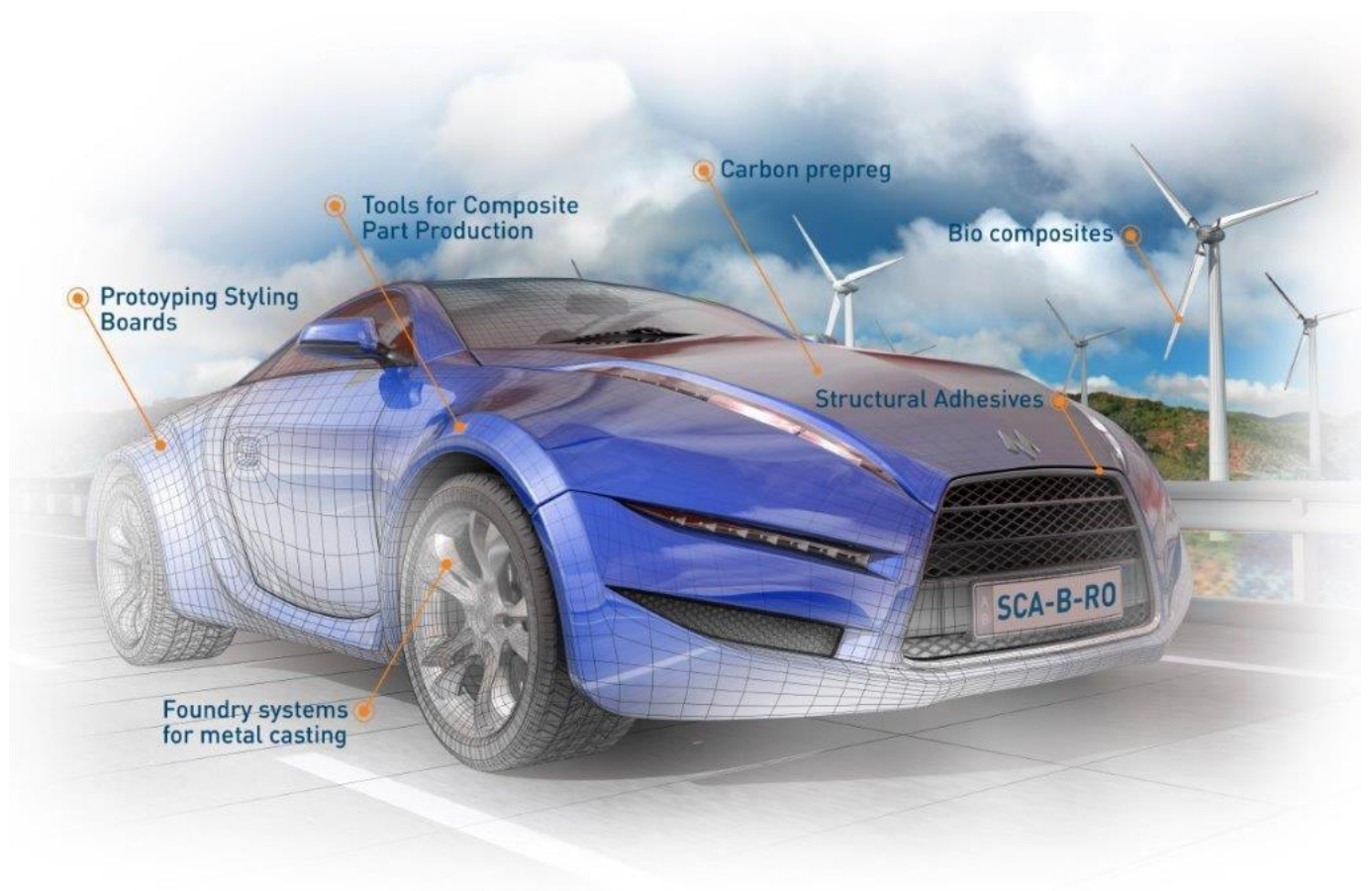


# TECHNICAL DATASHEET

## RAKU-TOOL EL-2200

Epoxy



MALLENBOUW | COMPOSITEN | LIJMEN

## Epoxy Laminating and Multipurpose System

80°C temperature resistant, unfilled epoxy

### Key Properties

- Long pot life
- Good wetting properties
- Room temperature curing
- Temperature resistant up to 80 °C

### Applications

- General tool building and tooling aids
- Does not attack EPS, supporting structures for Close Contour Pastes

### Processing Properties

			EL-2200	EH-2950-1
Color	visual		Clear	Yellowish
Mix ratio		parts by weight	100	16
Density	ISO 1183	g/cm <sup>3</sup>	ca. 1.10	ca. 1.01
Viscosity at 25 °C	DIN 53019-1	mPa·s	2000-2300	200-400

			EL-2200 / EH-2950-1
Mix viscosity at 25 °C	DIN 53019-1	mPa·s	1000-1200
Pot life at 25 °C	500 ml	min	60-70
Max. layer thickness		mm	8
Demold time		h	24

### Cured / Mechanical Properties

Cure: 16h at RT + 14h at 100°C			EL-2200 / EH-2950-1
Appearance	visual		Clear
Density	ISO 1183	g/cm <sup>3</sup>	ca. 1.1
Deflection temperature, HDT	ISO 75	°C	75-80
Glass Transition Temperature, Tg	DSC	°C	75-80
Flexural strength	ISO 178	MPa	100-110
Flexural modulus	ISO 178	MPa	2500-3000

## Processing

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

Mix the two components thoroughly in the ratio indicated. Degassing is recommended.

Impregnate each layer of cloths to construct the laminate layer by layer.

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® EL-2200	5 kg / 25 kg / 220 kg / 1000 kg
RAKU-TOOL® EH-2950-1	2 kg / 6 x 1 kg / 25 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.