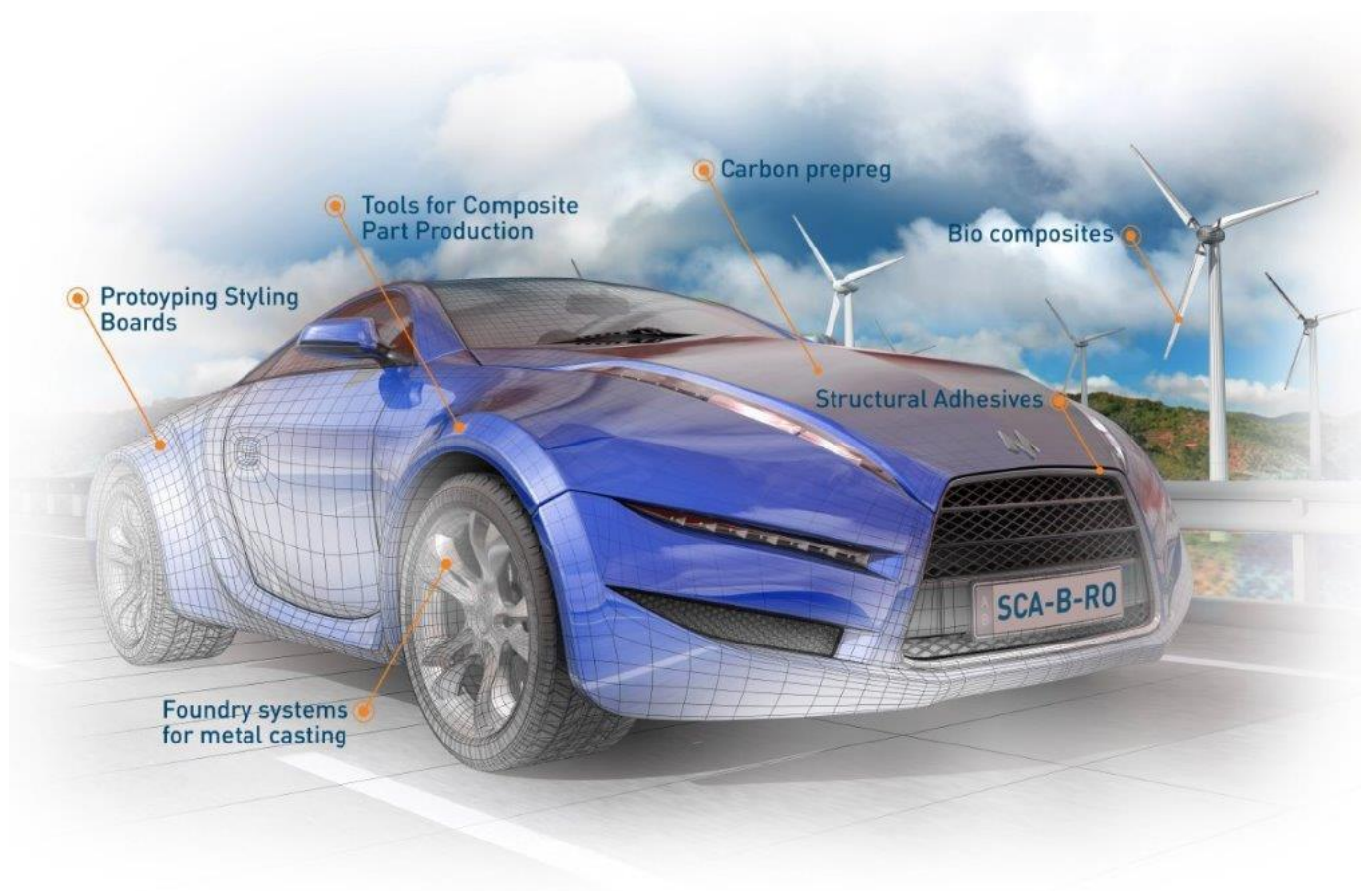


TECHNICAL DATASHEET

RAKU-TOOL EI-2500

Epoxy



MALLENBOUW | COMPOSITEN | LIJMEN

Epoxy Infusion System

Temperature resistant

Key Properties

- Room temperature curing
- Fast cure
- Good wetting properties
- Temperature resistant up to 100°C

Applications

- Resin Infusion, RTM

Processing Properties

			EI-2500	EH-2972
Color	visual		Transparent	Yellowish
Mix ratio		parts by weight	100	30
		parts by volume	100	35
Density	ISO 1183	g/cm ³	ca. 1.17	ca. 1.00
Viscosity at 25 °C	DIN 53019-1	mPa·s	800 - 1300	60 - 90

			EI-2500 / EH-2972
Mix viscosity at 25 °C	DIN 53019-1	mPa·s	600 – 900
Pot life at 25 °C	500 ml	min	20 – 25
Max. layer thickness		mm	4
Demold time		h	16

Cured / Mechanical Properties

Cure: 16h at RT + 14h at 100°C			EI-2500 / EH-2972
Appearance	visual		Clear
Density	ISO 1183	g/cm ³	ca. 1.2
Deflection temperature, HDT	ISO 75	°C	95-100
Glass Transition Temperature, Tg	DSC	°C	90-95
Flexural strength	ISO 178	MPa	135-145
Flexural modulus	ISO 178	MPa	3000-3500

Processing

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

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

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® EI-2500	20 kg / 200 kg
RAKU-TOOL® EH-2972	4.5 kg / 20 kg / 180 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.