

## TECHNICAL DATASHEET

Universele lijmset voor Workingboards



MALLENBOUW | COMPOSITEN | LIJMEN

## Multipurpose Adhesive

RT curing, long pot life

### Key Properties

- Room temperature curing
- Long pot life
- Easy to mix
- Slightly thixotropic

### Applications

- Universally applicable adhesive
- Especially suitable for our working boards (WB) (exception WB-700)
- Well suited for bonding metals after respective pre-treatment

### Processing Properties

			EL-2210	EH-2910-1
Color	visual		White	Yellowish
Mix ratio		pb weight	100	60
Density	ISO 1183	g/cm <sup>3</sup>	ca. 1.17	ca. 0.96
Viscosity at 25 °C	DIN 53019-1	mPa·s	10000-50000	20000-30000

			EL-2210 / EH-2910-1
Mix viscosity at 25 °C	DIN 53019-1	mPa·s	10000-25000
Pot life at 25 °C	500 ml	min	60
Max. layer thickness		mm	-
Demold time		h	16

### Cured / Mechanical Properties

Cure: 7 days at RT or 14h at 40°C			EL-2210 / EH-2910-1
Appearance	visual		Clear
Density	ISO 1183	g/cm <sup>3</sup>	ca. 1.1
Deflection temperature, HDT	ISO 75	°C	50-55
Glass Transition Temperature, Tg	DSC	°C	53-58
Flexural strength	ISO 178	MPa	85-95
Flexural modulus	ISO 178	MPa	2300-2800

### 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.

### Special mixtures

<b>EL-2210</b>	mix ratio	pbw	100	100	100	100	100
<b>EH-2910-1</b>			40	50	60	80	100
Shore hardness D	ISO 868		80	82	82	81	80
Deflection temperature (B) HDT	ISO 75	°C	43-48	48-53	50-55	48-53	43-48
Flexural strength	ISO 178	MPa	70-80	90-100	85-95	80-90	70-80
Flexural modulus	ISO 178	MPa	2000-2500	2300-2800	2300-2800	2000-2500	1500-2000
Tensile shear strength	ISO 4587	N/mm <sup>2</sup>	10-13	10-13	11-14	11-14	14-17

### Packaging

RAKU-TOOL® EL-2210	6 x 1.25 kg
RAKU-TOOL® EH-2910-1	6 x 0.75 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.