

## Epoxy Gelcoat System

RT curing, abrasion resistant

### Key Properties

- Reduced hazard rating
- High mechanical properties
- Excellent abrasion resistance
- Good resistance to chemicals
- Good temperature resistance

### Applications

- Foundry patterns
- Foam molds
- UP forming tools
- Tools and tooling aids

### Processing Properties

			EG-2102	EH-2901-2	EH-2950-1
Color	visual		Blue	Yellowish	Yellowish
Mix ratio		parts by weight	100	10	
			100		8
Density	ISO 1183	g/cm <sup>3</sup>	ca. 1.90	ca. 1.07	ca. 1.01

			EG-2102 / EH-2901-2	EG-2102 / EH-2950-1
Pot life at 25 °C	250 ml	min	25-30	50-60
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-2102 / EH-2901-2	EG-2102 / EH-2950-1
Appearance	visual		Blue	Blue
Density	ISO 1183	g/cm <sup>3</sup>	ca. 1.8	ca. 1.8
Hardness Shore D	ISO 868		90-95	90-95
Deflection temperature, HDT	ISO 75	°C	60-65	95-100
Glass Transition Temperature, Tg	DSC	°C	60-65	100-105
Abrasion	Taber	mm <sup>3</sup> /100R	15-20	5-10

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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-2102 / 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-2102 / 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-2102	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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