

## Epoxy Gelcoat System

Black, temperature resistant Epoxy System

### Key Properties

- Very easy to apply
- Can be polished to a high gloss
- Temperature resistant

### Applications

- For laminate structures and other build-up methods
- Vacuum forming molds
- RTM molds

### Processing Properties

|           |          |                   | EG-2104  | EH-2950-1 |
|-----------|----------|-------------------|----------|-----------|
| Color     | visual   |                   | Black    | Yellowish |
| Mix ratio |          | parts by weight   | 100      | 10        |
| Density   | ISO 1183 | g/cm <sup>3</sup> | ca. 1.70 | ca. 1.01  |

|                   |        |     | EG-2104 / EH-2950-1 |
|-------------------|--------|-----|---------------------|
| Pot life at 25 °C | 250 ml | min | 35-45               |
| Demold time       |        | h   | 16                  |

### Cured / Mechanical Properties

| Cure: 16h at RT + 14h at 120°C   |          |                       | EG-2104 / EH-2950-1 |
|----------------------------------|----------|-----------------------|---------------------|
| Appearance                       | visual   |                       | Black               |
| Density                          | ISO 1183 | g/cm <sup>3</sup>     | ca. 1.6             |
| Hardness Shore D                 | ISO 868  |                       | 90-95               |
| Deflection temperature, HDT      | ISO 75   | °C                    | 100-105             |
| Glass Transition Temperature, Tg | DSC      | °C                    | 98-103              |
| Abrasion                         | Taber    | mm <sup>3</sup> /100R | 60-65               |

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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.

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

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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 120°C in steps and post cured for 14 hours at 120°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-2104   | 5 kg                    |
| RAKU-TOOL® EH-2950-1 | 6 x 1 kg / 2 kg / 25 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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