

Epoxy Gelcoat System

Temperature resistant Epoxy System

Key Properties

- Can be polished
- Good temperature resistance

Applications

- Gelcoat for laminate structures and other build-up methods
- Vacuum forming molds

Processing Properties

			EG-2105	EH-2901-2
Color	visual		Green	Yellowish
Mix ratio		parts by weight	100	25
Density	ISO 1183	g/cm ³	ca. 1.31	ca. 1.07

			EG-2105 / EH-2901-2
Pot life at 25 °C	250 ml	min	15-20
Demold time		h	16

Cured / Mechanical Properties

Cure: 16h at RT + 14h at 120°C

			EG-2105 / EH-2901-2
Appearance	visual		Green
Density	ISO 1183	g/cm ³	ca. 1.3
Hardness Shore D	ISO 868		90-95
Deflection temperature, HDT	ISO 75	°C	100-105
Glass Transition Temperature, Tg	DSC	°C	105-110
Abrasion	Taber	mm ³ /100R	42-47

Processing

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.

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 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.

Packaging

RAKU-TOOL® EG-2105	5 kg
RAKU-TOOL® EH-2901-2	6 x 1 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.
