RAKU® TOOL EL-2207-2 / EH-2912

Epoxy Laminating Paste

Laminating system replacement for models, molds and tooling aids

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Key Properties

- Room temperature curing
- Can be used with a layer thickness of up to 15 mm
- Easy application by hand

Applications

- Reinforcement of molds and tooling aids
- Laminated shells
- Jigs and Fixtures

Processing Properties

			EL-2207-2	EH-2912
Color	visual		Grey	Blue
Mix ratio		pbw	100	12
Density	ISO 1183	g/cm³	ca. 0.75	ca. 0.95

			EL-2207-2 EH-2912
Mix viscosity at 25 °C	DIN 53019-1	mPa·s	paste
Pot life at 25 °C	500 ml	min	130 – 150
Max. layer thickness		mm	15
Demold time		h	20 – 24

Cured / Mechanical Properties

Cure: 16h at RT + 14h at 40°C			EL-2207-2 EH-2912
Appearance	visual		gray/green
Density	ISO 1183	g/cm³	ca. 0.85
Deflection temperature, HDT	ISO 75	°C	50 – 55
Glass Transition Temperature, Tg	DSC	°C	45 – 50
Flexural strength	ISO 178	MPa	30 – 35
Flexural modulus	ISO 178	MPa	2,800 – 3,300

Processing

The processing and material temperature should be between 20-25 ºC.
Degassing is recommended. Small quantities can be mixed by hand (wearing protective rubber gloves) until a homogeneous color is obtained. For larger quantities it is necessary to use a mixing machine. When a mixing machine is used the mixing time should be kept short (under 2 minutes).
The paste can be applied by hand (wearing protective rubber gloves) layer by layer, slightly overlapping and pushed together or it is rolled out in the desired layer thickness using spacing layers. With easy shapes the paste can be evened out and compressed by hand (wearing protective rubber gloves) or using a roller. With more complicated shapes it is recommended to use pressing with steel wool to even out and compress the paste. The mechanical properties and temperature resistance are only obtained through the post cure according to the recommended cure schedule.

Packaging

RAKU® TOOL EL-2207-2	16 kg
RAKU® TOOL EH-2912	2 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.

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