

EL-2200 / EH-2904-1

Epoxy Laminating and Multipurpose Resin

Room temperature curing, unfilled, low viscosity, impact resistant

Key Properties

- Room temperature curing
- Good impregnation of glass fibers and fillers
- Impact resistant

Applications

- Universal production of tools and tooling aids
- Laminating resin for fibers
- Binding agent for various fillers

Processing Properties

| | | Unit | EL-2200 | EH-2904-1 |
|--------------------|-------------|-------------------|---------------|-----------|
| Color | visual | | colorless | yellowish |
| Mix ratio | | pbw | 100 | 40 |
| Density | DIN 2811-1 | g/cm ³ | ca. 1.10 | ca. 1.00 |
| Viscosity at 25 °C | DIN 53019-1 | mPa·s | 2,000 - 3,000 | 90 - 130 |

| | | Unit | EL-2200 / EH-2904-1 |
|------------------------|-------------|-------|---------------------|
| Mix viscosity at 25 °C | DIN 53019-1 | mPa·s | 400 - 500 |
| Pot life at 25 °C | 500 ml | min | 40 - 50 |
| Max. layer thickness | | mm | 8 |
| Demold time | | h | 24 |

Cured / Mechanical Properties

| | | Unit | EL-2200 / EH-2904-1 7 days at RT or 14h at 40°C |
|-----------------------------|----------|-------------------|--|
| Cure | | | |
| Color | | visual | yellowish |
| Density | ISO 1183 | g/cm ³ | ca. 1.10 |
| Deflection temperature, HDT | ISO 75 | °C | 35 - 40 |
| Flexural strength | ISO 178 | MPa | 35 - 40 |
| Flexural modulus | ISO 178 | MPa | 900 - 1,000 |



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Processing

The processing temperature and material temperature should be between 20-25°C.

Degassing is recommended.

Impregnate each layer of cloths to construct the laminate layer by layer.

Post curing will improve final properties.

Packaging

| | |
|----------------------|------------------------|
| RAKU® TOOL EL-2200 | 1000 kg, 220 kg, 25 kg |
| RAKU® TOOL EH-2904-1 | 25 kg, 2 kg, 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.