

## EL-2200 / EH-2950-1

### Epoxy Laminating and Multipurpose Resin

Temperature resistant up to 80°C, unfilled

#### Key Properties

- Long pot life
- Good wetting properties
- Room temperature curing
- Temperature resistant up to 80°C

#### Applications

- Universal production of tools and tooling aids
- Production of substructures for Close Contour Pastes (EPS compatible)

#### Processing Properties

		Unit	EL-2200	EH-2950-1
Color	visual		colorless	yellowish
Mix ratio		pbw	100	16
Density	DIN 2811-1	g/cm <sup>3</sup>	ca. 1.10	ca. 1.01
Viscosity at 25 °C	DIN 53019-1	mPa·s	2,000 - 3,000	200 - 400

		Unit	EL-2200 / EH-2950-1
Mix viscosity at 25 °C	DIN 53019-1	mPa·s	1,000 - 1,200
Pot life at 25 °C	500 ml	min	50 - 60
Max. layer thickness		mm	8
Demold time		h	24

#### Cured / Mechanical Properties

		Unit	EL-2200 / EH-2950-1
Cure			16h at RT + 14h at 100°C
Color		visual	yellowish
Density	ISO 1183	g/cm <sup>3</sup>	ca. 1.10
Deflection temperature, HDT	ISO 75	°C	75 - 80
Glass transition temperature, Tg	DSC	°C	75 - 80
Flexural strength	ISO 178	MPa	100 - 110
Flexural modulus	ISO 178	MPa	2,500 - 3,000



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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.

The mechanical properties and temperature resistance are only obtained through a 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 100°C in steps and post cured for 14 hours at 100°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 EL-2200	220 kg, 25 kg
RAKU® TOOL EH-2950-1	25 kg, 2 kg, 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.