

## EL-2207-3 / EH-2907-3

### Laminating paste

Laminate replacement for models, molds, production aids

#### Key Properties

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

#### Applications

- Reinforcement for molds and tooling aids
- Laminated shells
- Production of jigs and fixtures

#### Processing Properties

		Unit	EL-2207-3	EH-2907-3
Color	visual		gray - green	blue
Mix ratio		pbw	100	12
Density	DIN 2811-1	g/cm <sup>3</sup>	ca. 1.02	ca. 1.03

		Unit	EL-2207-3 / EH-2907-3
Pot life at 25 °C	500 ml	min	30 - 35
Max. layer thickness		mm	15
Demold time		h	20

#### Cured / Mechanical Properties

		Unit	EL-2207-3 / EH-2907-3
Cure			7 days at RT or 14h at 40°C
Color		visual	gray - green
Density	ISO 1183	g/cm <sup>3</sup>	ca. 1.00
Deflection temperature, HDT	ISO 75	°C	60 - 65
Glass transition temperature, Tg	DSC	°C	60 - 65
Flexural strength	ISO 178	MPa	35 - 40
Flexural modulus	ISO 178	MPa	5,200 - 5,700



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**Laminating paste**

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**Processing**

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

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 simple 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.

**Packaging**

RAKU® TOOL EL-2207-3	16 kg
RAKU® TOOL EH-2907-3	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.