# RAKU<sup>®</sup> TOOL EP-2305 / EH-2903-1, EH-2904-2



## Adhesive for bonding styling boards

### RT curing

© RAMPF Advanced Polymers GmbH & Co. KG

Page 1 of 2

#### **Key Properties**

- · Reduced hazard rating
- Color matched
- Similar density and hardness to board material
- RT curing
- Thixotropic or low viscosity depending on choice of hardener

#### **Applications**

PC - Rev.-Status: 01- 2025/01/17

For bonding styling boards with a density < 0.50 g/cm³</li>

#### **Processing Properties**

|                          |             | EP-2305                                 | EH-2903-1         | EH-2904-2         |                   |
|--------------------------|-------------|---|-------------------|-------------------|-------------------|
| Color                    | visual      |   | Apricot           | Orange            | Yellowish         |
| Mix ratio                |             | parts by weight                         | 100               | 25                |                   |
|                          |             |   | 100               |                   | 30                |
| Density                  | ASTM D-792  | lb/ft <sup>3</sup> (g/cm <sup>3</sup> ) | ca. 37 (ca. 0.60) | ca. 68 (ca. 1.09) | ca. 62 (ca. 1.00) |
| Viscosity at 77°F (25°C) | ASTM D-2393 | cР                                      | paste             | thixotropic paste | 90 -130           |

|                         |        |         | EP-2305 / EH-2903-1 | EP-2305 / EH-2904-2 |
|-------------------------|--------|---------|---------------------|---------------------|
| Pot life at 77°F (25°C) | 500 ml | Min     | 10-20               | 25-35               |
| Max. layer thickness    |        | in (mm) | -                   | -                   |
| Minimum curing time     |        | h       | 16                  | 16                  |

#### **Cured / Mechanical Properties**

| Cure: 7 days at RT or 14h at 100°F (38 °C) |             | EP-2305 / EH-2903-1   | EP-2305 / EH-2904-2 |                   |
|--|-------------|---|---------------------|-------------------|
| Aspect                                     | visual      |   | Apricot             | Apricot           |
| Density                                    | ASTM D-792  | lb/ft³ (g/cm³)  | ca. 41 (ca. 0.66)   | ca. 42 (ca. 0.68) |
| Shore hardness D                           | ASTM D-2240 |   | 58-63               | 55-60             |
| Coefficient of thermal expansion           | ASTM D-3386 | 10 <sup>-6</sup> F <sup>-1</sup><br>(10 <sup>-6</sup> K <sup>-1</sup> ) | 28-33 (50-60)       | 28-33 (50-60)     |
| Deflection temperature, HDT                | ASTM D-648  | °F (°C)   | 113-122 (45-50)     | 122-131 (50-55)   |
| Glass Transition Temperature, Tg           | DSC         | °F (°C)   | 122-131 (50-55)     | 122-131 (50-55)   |
| Compressive strength                       | ASTM D-695  | psi   | 2,600-3,300         | 2,200-2,900       |
| Compressive modulus                        | ASTM D-695  | psi   | 145,000-218,000     | 116,000-189,000   |
| Flexural strength                          | ASTM D-790  | psi   | 2,900-3,600         | 2,800-3,600       |
| Flexural modulus                           | ASTM D-790  | psi   | 145,000-218,000     | 116,000-189,000   |

#### RAKU® TOOL EP-2305 / EH-2903-1, EH-2904-2

#### Adhesive for bonding styling boards

RT curing



© RAMPF Advanced Polymers GmbH & Co. KG

PC - Rev.-Status: 01- 2025/01/17

Page 2 of 2

#### **Processing**

The processing and material temperature should be between 68-77°F (20-25°C). Mix the two components thoroughly in the ratio indicated and apply to both sides of the surface to be bonded.

#### **Packaging**

| RAKU® TOOL EP-2305   | 3 kg      |
|----------------------|-----------|
| RAKU® TOOL EH-2903-1 | 0.75 kg   |
| RAKU® TOOL EH-2904-2 | 2 kg, 1kg |

#### **Storage**

Original containers should be kept tightly sealed and stored at ambient temperatures 59-86°F (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.

RAMPF Group, Inc. 49037 Wixom Tech Drive Wixom, MI 48393 T +1 248. 295.0223 F +1 248. 295.0224 E info.us@rampf-group.com Our recommendations on the use of the material are based on many years of experience and current scientific and practical knowledge. They are, however, provided without any obligation on our part and do not relieve the buyer of the need for suitability tests. They do not constitute a legal relationship, nor are any protected third party rights whatsoever affected thereby.