

## Epoxy Laminating Paste

Laminating system replacement for models, molds and tooling aids

### Key Properties

- Room temperature curing
- Can be used with a layer thickness of up to 0.6 inch
- Easy application by hand

### Applications

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

### Processing Properties

			EL-2207-3	EH-2907-3
Color	visual		Gray/Green	Blue
Mix ratio		pbw	100	12
Density	ASTM D-792	lb/ft <sup>3</sup> (g/cm <sup>3</sup> )	ca. 62 (1.02)	ca. 64 (1.03)

			EL-2207-3 EH-2907-3
Mix viscosity at 77°F (25°C)	ASTM D-2393	cP	paste
Pot life at 77°F (25°C)	1.1 lbs (500 ml)	min	30 – 35
Max. layer thickness		in (mm)	0.6 (15)
Demold time		h	20

### Cured / Mechanical Properties

Cure: 7 days at RT or 14h at 104°F (40°C)			EL-2207-3 EH-2907-3
Appearance	visual		Gray/Green
Density	ASTM D-792	lb/ft <sup>3</sup> (g/cm <sup>3</sup> )	ca. 63 (1.00)
Deflection temperature, HDT	ASTM D-648	°F (°C)	140 – 149 (60 – 65)
Glass Transition Temperature, T <sub>g</sub>	DSC	°F (°C)	140 – 149 (60 – 65)
Flexural strength	ASTM D-790	psi (MPa)	5,000 – 5,800 (35 – 40)
Flexural modulus	ASTM D-790	psi (MPa)	754,000 – 827,000 (5,200 – 5,700)

**Processing**

**The processing temperature and material temperature should be between 68-77 °F (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	35.3 lbs (16 kg)
RAKU® TOOL EH-2907-3	4.4 lbs (2 kg)

**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.