RAKU® TOOL EP-2303 / EH-2934-1



Adhesive for epoxy board WB-0691 and WB-0890

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Key Properties

 Similar color, density, hardness, temperature resistance and coefficient of thermal expansion to epoxy board material

Applications

- Bonding of epoxy board WB-0691
- Bonding of epoxy board WB-0890

Processing properties Adhesive

			EP-2303	EH-2934-1
Color	visual		Blue	Yellowish
Minutia		pb weight	100	20
Mix ratio		pb weight 100 pb volume 100	100	17
Density	ASTM D-792	lb/ft³ (g/cm³)	ca. 54.9 (ca. 0.88)	ca. 63.7 (ca. 1.02)

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Pot life at 25 °C (77°F)	500 ml	min	50 – 60
Max. layer thickness		in (mm)	-
Minimal curing time at 25 °C (77°F)		h	16

Cured / Mechanical Properties

16h at RT + 14h at 100°C (212°F)	at RT + 14h at 100°C (212°F)		EP-2303 / EH-2934-1	
Aspect	visual		Blue	
Density	ASTM D-792	lb/ft³ (g/cm³)	ca. 56.2 (ca. 0.9)	
Shore hardness D	ASTM D-2240		75 – 80	
Coefficient of thermal expansion	ASTM D-3386	10 ⁻⁶ F ⁻¹ (10 ⁻⁶ K ⁻¹)	19 – 25 (35 – 45)	
Deflection temperature, HDT	ASTM D-648	°F (°C)	221 – 230 (105 – 110)	
Glass Transition Temperature, Tg	DSC	°F (°C)	212 – 221 (100 – 105)	
Compressive strength	ASTM D-695	psi (MPa)	9,800 - 10,500 (68 - 72)	
Compressive modulus	ASTM D-695	psi (MPa)	406,000 - 478,700 (2,800 - 3,300)	
Flexural strength	ASTM D-790	psi (MPa)	8,000 - 8,700 (55 - 60)	
Flexural modulus	ASTM D-790	psi (MPa)	420,600 - 348,000 (2,900 - 3,400)	

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Processing

The processing and material temperature should be between 20-25 °C (68-77 °F).

Mix the two components thoroughly in the ratio indicated and apply to both sides of the surface to be bonded. The mechanical properties and temperature resistance are only obtained through the 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 (212°F) in steps and post cured for 14 hours at 100°C (212°F), then cooled down gradually. The curing time at room temperature, heating and cooling rate depend on the size and thickness of the parts.

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RAKU® TOOL EP-2303	5 kg	
RAKU [®] TOOL EH-2934-1	1 kg	

Storage

Original containers should be kept tightly sealed and stored at ambient temperatures (15°C to 30°C) (59-86 °F). 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.