

Key Properties

- Temperature resistant up to 110°C
- Good flow properties
- Unfilled, low viscosity
- Good wetting properties

Applications

- Resin infusion
- RTM

Processing Properties

		Unit	EI-2500	EH-2971
Color	visual		colorless	yellowish
Mix ratio		pbw	100	30
Density	ISO 1183	g/cm ³	ca. 1.17	ca. 0.97
Viscosity at 25 °C	DIN 53019-1	mPa·s	800 - 1,300	15 - 25

		Unit	EI-2500 / EH-2971
Mix viscosity at 25 °C	DIN 53019-1	mPa·s	300 - 700
Pot life at 25 °C	500 ml	min	70 - 80
Max. layer thickness		mm	8
Demold time		h	16

Cured / Mechanical Properties

		Unit	EI-2500 / EH-2971
Cure			16h at RT + 14h at 120°C
Color		visual	yellowish
Density	ISO 1183	g/cm ³	ca. 1.10
Deflection temperature, HDT	ISO 75	°C	100 - 110
Glass transition temperature, Tg	DSC	°C	110 - 115
Flexural strength	ISO 178	MPa	120 - 130
Flexural modulus	ISO 178	MPa	2,800 - 3,300



Processing

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

Mix the two components thoroughly in the ratio indicated.

Degassing is recommended.

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 120°C in steps and post cured for 14 hours at 120°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 EI-2500	200 kg, 20 kg
RAKU® TOOL EH-2971	3 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.