

# RAKU<sup>®</sup> TOOL

## EI-2504 / EH-2974

### Epoxy Infusion System

High heat resistance



**RAMPF**<sup>®</sup>  
discover the future

#### Key Properties

- Excellent flow properties
- High temperature resistance (170°C)

#### Applications

- Resin infusion

#### Processing Properties

		Unit	EI-2504	EH-2974
Color	visual		yellowish	colorless
Mix ratio		pbw	100	32
Density	ISO 1183	g/cm <sup>3</sup>	ca. 1.14	ca. 0.95
Viscosity at 25 °C	DIN 53019-1	mPa·s	700 - 900	10 - 20

		Unit	EI-2504 / EH-2974
Mix viscosity at 25 °C	DIN 53019-1	mPa·s	550 - 750
Pot life at 25 °C	500 ml	min	210 - 270
Max. layer thickness		mm	8
Demold time		h	24

#### Cured / Mechanical Properties

		Unit	EI-2504 / EH-2974 16h at RT + 14h at 160°C
Cure			
Color		visual	yellowish
Density	ISO 1183	g/cm <sup>3</sup>	ca. 1.10
Deflection temperature, HDT	ISO 75	°C	160 - 165
Glass transition temperature, Tg	DSC	°C	168 - 173
Flexural strength	ISO 178	MPa	110 - 120
Flexural modulus	ISO 178	MPa	3,300 - 3,800



### 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 160°C in steps and post cured for 14 hours at 160°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-2504	25 kg
RAKU® TOOL EH-2974	4 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.