

## Multipurpose Adhesive

RT curing, long pot life

### Key Properties

- Room temperature curing
- Long pot life
- Easy to mix
- Slightly thixotropic

### Applications

- Universally applicable adhesive
- Especially suitable for our working boards (WB) (exception WB-700)
- Well suited for bonding metals after respective pre-treatment

### Processing Properties

			EL-2210	EH-2910-1
Color	visual		Opaque	Yellowish
Mix ratio		pb weight	100	60
Density	ASTM D-792	lb/ft <sup>3</sup> (g/cm <sup>3</sup> )	ca. 73 (ca. 1.17)	ca. 60 (ca. 0.96)
Viscosity at 77°F (25°C)	ASTM D-2393	cP	10,000-50,000	20,000-30,000

			EL-2210 / EH-2910-1
Mix viscosity at 77°F (25°C)	ASTM D-2393	cP	10,000-25,000
Pot life at 77°F (25°C)	500 ml	min	50-60
Max. layer thickness		in (mm)	-
Demold time		h	16

### Cured / Mechanical Properties

Cure: 7 days at RT or 14h at 100°F (38 °C)			EL-2210 / EH-2910-1
Appearance	visual		Opaque
Density	ASTM D-792	lb/ft <sup>3</sup> (g/cm <sup>3</sup> )	ca. 69 (ca. 1.1)
Hardness	ISO 868	Shore D	80-85
Deflection temperature, HDT	ASTM D-648	°F (°C)	122-131 (50-55)
Glass Transition Temperature, T <sub>g</sub>	DSC	°F (°C)	127-136 (53-58)
Flexural strength	ASTM D-790	psi (MPa)	12,300-13,800 (85-95)
Flexural modulus	ASTM D-790	psi (MPa)	334,000-406,000 (2,300-2,800)

**Special mixtures**

<b>EL-2210</b>	mix ratio	pbw	100	100	100	100	100
<b>EH-2910-1</b>			40	50	60	80	100
Shore hardness D	ASTM D-2240		80	82	82	81	80
Deflection temperature (B) HDT	ASTM D-648	°F (°C)	109-118 (43-48)	118-127 48-53	122-131 (50-55)	118-127 48-53	109-118 (43-48)
Flexural strength	ASTM D-790	psi	10,200- 11,600	13,100- 14,500	12,300- 13,800	11,600- 13,100	10,200- 11,600
Flexural modulus	ASTM D-790	psi	290,000- 363,000	334,000- 406,000	334,000- 406,00	290,000- 363,000	218,000- 290,000
Tensile shear strength	ASTM D-1002	psi	1,450- 1,890	1,450- 1,890	1,600- 2,030	1,600- 2,030	2,030- 2,470

**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 EL-2210	6 x 1.25 kg
RAKU® TOOL EH-2910-1	6 x 0.75 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.