

## Adhesive for bonding styling boards

### RT curing

#### Key Properties

- Reduced hazard rating
- Color matched
- Similar density and hardness to board material
- RT curing
- Thixotropic or low viscosity depending on choice of hardener

#### Applications

- For bonding styling boards with a density < 0,50 g/cm<sup>3</sup>

#### Processing Properties

			EP-2305	EH-2903-1	EH-2904-1
Color	visual		Apricot	Orange	Clear
Mix ratio		parts by weight	100	25	
			100		30
Density	ASTM D-792	lb/ft <sup>3</sup> (g/cm <sup>3</sup> )	ca. 37 (ca. 0.60)	ca. 68 (ca. 1.09)	ca. 62 (ca. 1.00)
Viscosity at 77°F (25°C)	ASTM D-2393	cP	paste	thixotropic paste	90 -130

			EP-2305 / EH-2903-1	EP-2305 / EH-2904-1
Pot life at 77°F (25°C)	500 ml	Min	15	25
Max. layer thickness		in (mm)	-	-
Minimum curing time		h	16	16

#### Cured / Mechanical Properties

##### Cure: 7 days at RT or 14h at 100°F (38 °C)

			EP-2305 / EH-2903-1	EP-2305 / EH-2904-1
Aspect	visual		Apricot	Apricot
Density	ASTM D-792	lb/ft <sup>3</sup> (g/cm <sup>3</sup> )	ca. 41 (ca. 0.66)	ca. 42 (ca. 0.68)
Shore hardness D	ASTM D-2240		58-63	55-60
Coefficient of thermal expansion	ASTM D-3386	10 <sup>-6</sup> F <sup>-1</sup> (10 <sup>-6</sup> K <sup>-1</sup> )	28-33 (50-60)	28-33 (50-60)
Deflection temperature, HDT	ASTM D-648	°F (°C)	113-122 (45-50)	113-122 (45-50)
Glass Transition Temperature, Tg	DSC	°F (°C)	122-131 (50-55)	122-131 (50-55)
Compressive strength	ASTM D-695	psi	2,600-3,300	2,200-2,900
Compressive modulus	ASTM D-695	psi	145,000-218,000	116,000-189,000
Flexural strength	ASTM D-790	psi	2,900-3,600	2,600-3,300
Flexural modulus	ASTM D-790	psi	145,000-218,000	116,000-189,000

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### Processing

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**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.

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### Packaging

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RAKU® TOOL EP-2305	3 kg
RAKU® TOOL EH-2904-1	1 kg, 2 kg, 6 x 1 kg
RAKU® TOOL EH-2903-1	6 x 0.75 kg

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### Storage

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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.

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### Handling Precautions

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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.

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