

## Epoxy Casting System

With metal fillers

### Key Properties

- Universally applicable
- Low sedimentation
- Good mechanical properties
- Easy to pour
- Workable, hard surface

### Applications

- Foundry patterns
- Copy models
- Metal forming
- General modeling

### Processing Properties

|                          |             |                                         | EC-2402            | EH-2902-1         |
|--------------------------|-------------|-----------------------------------------|--------------------|-------------------|
| Color                    | visual      |                                         | Black              | Yellowish         |
| Mix ratio                |             | parts by weight                         | 100                | 15                |
| Density                  | ASTM D-792  | lb/ft <sup>3</sup> (g/cm <sup>3</sup> ) | ca. 177 (ca. 2.84) | ca. 60 (ca. 0.96) |
| Viscosity at 77°F (25°C) | ASTM D-2393 | cP                                      | 100,000-200,000    | 1,000-2,000       |

|                              |             |     | EC-2402 / EH-2902-1 |
|------------------------------|-------------|-----|---------------------|
| Mix viscosity at 77°F (25°C) | ASTM D-2393 | cP  | 25,000-30,000       |
| Pot life at 77°F (25°C)      | 4.2 lbs     | min | 180 - 210           |
| Max. Layer thickness         |             | in  | 1.6                 |
| Demold time                  |             | h   | 18                  |

### Cured / Mechanical Properties

| Cure: 7 days at RT or 14h at 40°C (104 °F) |             |                                                                         | EC-2402 / EH-2902-1 |
|--------------------------------------------|-------------|-------------------------------------------------------------------------|---------------------|
| Aspect                                     | visual      |                                                                         | Black               |
| Density                                    | ASTM D-792  | lb/ft <sup>3</sup> (g/cm <sup>3</sup> )                                 | ca. 137 (ca. 2.2)   |
| Shore hardness D                           | ASTM D-2240 |                                                                         | 85-90               |
| Coefficient of thermal expansion           | ASTM D-3386 | 10 <sup>-6</sup> F <sup>-1</sup><br>(10 <sup>-6</sup> K <sup>-1</sup> ) | 28 – 33 (50-60)     |
| Deflection temperature, HDT                | ASTM D-648  | °F (°C)                                                                 | 131-140 (55–60)     |
| Glass Transition Temperature, Tg           | DSC         | °F (°C)                                                                 | 131-140 (55–60)     |
| Compressive strength                       | ASTM D-695  | Psi                                                                     | 14,500 – 15,200     |
| Compressive modulus                        | ASTM D-695  | Psi                                                                     | 798,000 – 870,000   |
| Flexural strength                          | ASTM D-790  | Psi                                                                     | 10,900 – 11,600     |
| Flexural modulus                           | ASTM D-790  | Psi                                                                     | 725,000 – 798,000   |
| Linear shrinkage*                          | ASTM D-2566 | in / in                                                                 | 0.0006              |

\*measured on maximum layer thickness as stated above



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### Processing

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

Mix the two components thoroughly in the ratio indicated.

Degassing is recommended.

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### Packaging

RAKU® TOOL EC-2402

6 x 4.1 lbs / 29.7 lbs (6 x 1.86 kg / 13.5 kg)

RAKU® TOOL EH-2902-1

48.5 lbs (22 kg)

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### 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.

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### 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.

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