

EP-2304 / EH-2934-1

Adhesive for epoxy boards

Two component epoxy

Key Properties

- Similar color, density, hardness, temperature resistance and coefficient of thermal expansion to epoxy board material

Applications

- Bonding of epoxy working board WB-0700

Processing Properties

		Unit	EP-2304	EH-2934-1
Color	visual		green	yellowish
Mix ratio		pbw	100	20
Mix ratio		pbv	100	10
Density	ISO 1183	g/cm ³	ca. 0.88	ca. 1.02

		Unit	EP-2304 / EH-2934-1
Pot life at 25 °C	500 ml	min	50 - 60
Minimum curing time	25°C	h	16

Cured / Mechanical Properties

		Unit	EP-2304 / EH-2934-1 16h at RT + 14h at 120°C
Cure			
Color		visual	light green
Density	ISO 1183	g/cm ³	ca. 0.90
Hardness	ISO 868	Shore D	75 - 80
Coefficient of thermal expansion	ISO 11359	10 ⁻⁶ K ⁻¹	35 - 45
Deflection temperature, HDT	ISO 75	°C	115 - 120
Glass transition temperature, Tg	DSC	°C	115 - 120
Compressive strength	ISO 604	MPa	65 - 70
Compressive modulus	ISO 604	MPa	3,000 - 3,500
Flexural strength	ISO 178	MPa	45 - 50
Flexural modulus	ISO 178	MPa	3,000 - 3,500

Processing

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

Mix the two components thoroughly in the ratio indicated.

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 EP-2304	5 kg
RAKU® TOOL EH-2934-1	1 kg, 6 x 1 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.