

EP-2303 / 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-0691
- Bonding of epoxy working board WB-0890

Processing Properties

		Unit	EP-2303	EH-2934-1
Color	visual		blue	yellowish
Mix ratio		pbw	100	20
Mix ratio		pbv	100	17
Density	DIN 2811-1	g/cm ³	ca. 0.88	ca. 1.02

		Unit	EP-2303 / 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-2303 / EH-2934-1 16h at RT + 14h at 100°C
Cure			
Color		visual	blue
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	105 - 110
Glass transition temperature, Tg	DSC	°C	100 - 105
Compressive strength	ISO 604	MPa	68 - 72
Compressive modulus	ISO 604	MPa	2,800 - 3,300
Flexural strength	ISO 178	MPa	55 - 60
Flexural modulus	ISO 178	MPa	2,900 - 3,400



Processing

The processing temperature and material temperature should be between 20-25°C.
 Mix the two components thoroughly in the ratio indicated and apply to both sides of the surface to be bonded.
 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 100°C in steps and post cured for 14 hours at 100°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-2303	5 kg
RAKU® TOOL EH-2934-1	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.