

RAKU-TOOL[®] EP-2304 / EH-2934 and UP-4320 / UH-4920

Adhesive and Repair paste for working board WB-0700

PC - Rev.-Status: 01- 2006/05/11

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Key Properties

- Color matched
- Similar density and hardness to working board WB-0700

Applications

- Bonding and repair of working board WB-0700

Processing properties Adhesive

			EP-2304	EH-2934
Color	visual		Green	Yellowish
Mix ratio		pb weight	100	20
		pb volume	100	10
Density	ISO 1183	g/cm ³	0.88	1.02
			EP-2304/EH-2934	
Mix viscosity at 25°C	ISO 2555	mPas	-	
Pot life at 25 °C	500 ml	min	90	
Minimal curing time		h	18	

Cured / Mechanical Properties

After initial hardening, cure in steps up to 120°C			EP-2304/EH-2934	
Aspect	visual		Green	
Density	ISO 1183	g/cm ³	0.9	
Shore hardness D	ISO 868		75	
Coefficient of thermal expansion	ISO 11359	10 ⁻⁶ K ⁻¹	35-45	
Glass Transition Temperature, Tg	DSC	°C	120-125	
Compressive strength	ISO 604	MPa	80	
Compressive modulus	ISO 604	MPa	3100-3500	
Flexural strength	ISO 178	MPa	50	
Flexural modulus	ISO 178	MPa	3300-3600	

Processing

The processing 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 the relevant post cure.

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Processing Properties Repair Paste

		UP-4320 / UH-4920	
Color	visual		Green
Mix ratio		pbw	100 : 3-5
Pot life at 25 °C		min	4 – 6
Minimal curing time		min	25 – 30

Processing

The processing and material temperature should be between 20-25 °C.
 Mix the two components thoroughly and apply by spatula.

Packaging

RAKU-TOOL® EP-2304	1 x 9.00 kg
RAKU-TOOL® EH-2934	1 x 1.80 kg
RAKU-TOOL® UP-4320	6 x 0.80 kg
RAKU-TOOL® UH-4920	6 x 0.05 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.

Supplied by

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