

RAKU-TOOL[®] EC-2400 / EH-2909, EH-2952

Epoxy Casting System

Abrasion resistant

Supplied by

AMBERCOMPOSITES

PC - Rev.-Status: 01- 2006/06/14

Page 1 of 2

Key Properties

- Easy to pour
- Low sedimentation
- Good resistance to chemicals
- Reactivity can be adjusted
- Hard surface, abrasion resistant
- Good mechanical properties

Applications

- Foundry patterns
- Copy models
- Metal forming
- Foam molds (face casting)

Processing Properties

			EC-2400	EH-2909	EH-2952
Color	visual		Blue	Clear	Clear
Mix ratio		parts by weight	100	6	
Density	ISO 1183	g/cm ³	2.0	0.87	0.95
Viscosity at 25 °C	ISO 2555	m Pa.s	100000-200000	30-40	20-50

			EC-2400 / EH-2909	EC-2400 / EH-2952
Mix viscosity at 25 °C	ISO 2555	m Pa.s	7500-8500	12000-18000
Pot life at 25 °C	1000 ml		45 min	3.5-4 h
Max. layer thickness		mm	30	60
Demold time		h	12	18

Cured / Mechanical Properties**Cure:**

7 days at RT or 14h at 40°C

after initial hardening post cure in steps up to 120°C

			EC-2400 / EH-2909	EC-2400 / EH-2952
Appearance	visual		Blue	Blue
Density	ISO 1183	g/cm ³	1.9	1.9
Shore hardness D	ISO 868		85-90	85-90
Coefficient of thermal expansion	ISO 11359	10 ⁻⁶ K ⁻¹		
Glass Transition Temperature, T _g	DSC	°C		110-115
Compressive strength	ISO 604	MPa	135-140	165-170
Compressive modulus	ISO 604	MPa	8300-8800	8800-9300
Flexural strength	ISO 178	MPa	93-98	115-120
Flexural modulus	ISO 178	MPa	8500-9500	9000-9500
Linear shrinkage*		mm / m	0.1	0.1
Abrasion	mm ³ /100R	Taber		

*measured on maximum layer thickness as stated above

RAKU-TOOL® EC-2400 / EH-2909 / EH-2952

Epoxy Casting System

Abrasion resistant

PC - Rev.-Status: 01- 2006/06/14

Page 2 of 2

Processing

Mix the two components thoroughly in the ratio indicated.

Degassing and /or post-curing will improve final properties.

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

Packaging

RAKU-TOOL® EC-2400	5 kg / 15 kg
RAKU-TOOL® EH-2909	6x 0.300 kg / 6x 0.900 kg
RAKU-TOOL® EH-2952	4.5 kg / 22.5 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

AMBERCOMPOSITES

94 Station Road, Langley Mill
Nottingham, NG16 4BP United Kingdom
T: +44 (0)1773 530899 F: +44 (0)1773 768687
E: sales@ambercomposites.com
www.ambercomposites.com

RAMPF Tooling GmbH & Co. KG
Albstr. 37 • D-72661 Grafenberg
T +49 (0) 7123 9342-1600
F +49 (0) 7123 9342-1666
E info@rampf-tooling.com

www.raku-tool.com

Our recommendations on the use of the material are based on many years of experience and current scientific and practical knowledge. They are, however, provided without any obligation on our part and do not relieve the buyer of the need for suitability tests. They do not constitute a legal relationship, nor are any protected third party rights whatsoever affected thereby.