

RAKU-TOOL[®] EC-2402 / EH-2904, EH-2905, EH-2906, EH-2902

Epoxy Casting System

With metal fillers, variable reactivity

Supplied by

AMBERCOMPOSITES

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

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Key Properties

- Universally applicable
- Low sedimentation
- Good mechanical properties
- Easy to pour
- Workable, hard surface
- Reactivity can be adjusted by using different hardeners

Applications

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

Processing Properties

			EC-2402	EH-2904	EH-2905	EH-2906	EH-2902
Color	visual		Black	Clear	Clear	Clear	
Mix ratio		parts by weight	100	15			
			100		15		
			100			15	
			100				15
Density	ISO 1183	g/cm ³	2.84	1.00	1.01	1.01	0.96
Viscosity at 25 °C	ISO 2555	m Pa.s	100000-200000	60-110	50-100	50-100	1000-2000

			EC-2402 EH-2904	EC-2402 EH-2905	EC-2402 EH-2906	EC-2402 EH-2902
Mix viscosity at 25 °C	ISO 2555	m Pa.s	4000-5000	4000-5000	3000-4000	15000-30000
Pot life at 25 °C	1000 ml	min	45	90	180	140
Max. layer thickness		mm	10	20	80	40
Demold time		h	12	16	18	18

Cured / Mechanical Properties

Cure: 7 days at RT or 14h at 40°C			EC-2402 EH-2904	EC-2402 EH-2905	EC-2402 EH-2906	EC-2402 EH-2902
Appearance	visual		Black	Black	Black	Black
Density	ISO 1183	g/cm ³	2.2	2.2	2.2	2.2
Shore hardness D	ISO 868		85	85	85	85
Coefficient of thermal expansion	ISO 11359	10 ⁻⁶ K ⁻¹	45-50	45-50	45-50	45-50
Glass Transition Temperature, Tg	DSC	°C	70	70	70	70-75
Compressive strength	ISO 604	MPa	95-100	95-100	100-105	100-105
Compressive modulus	ISO 604	MPa				5500-6000
Flexural strength	ISO 178	MPa	95-100	95-100	95-100	75-80
Flexural modulus	ISO 178	MPa	5800	5800	5800	4800-5000
Linear shrinkage*		mm / m	0.2	0.4	0.5	0.6
Abrasion	mm ³ /100R	Taber				

*measured on maximum layer thickness as stated above

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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-2402	6 x 1.86 kg / 13.5 kg
RAKU-TOOL [®] EH-2904	6 x 0.280 kg / 2 kg / 25 kg
RAKU-TOOL [®] EH-2905	6 x 0.280 kg / 2 kg / 25 kg
RAKU-TOOL [®] EH-2906	6 x 0.280 kg / 2 kg / 25 kg
RAKU-TOOL [®] EH-2902	2 kg / 25 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.

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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.