

RAKU-TOOL[®] EG-2103 / EH-2903

Epoxy Gelcoat System

RT curing, iron filled

PC - Rev.-Status: 01- 2006/05/10

Page 1 of 2

Key Properties

- Hard but still workable surface
- Thixotropic, holds well on vertical surfaces
- Low sedimentation
- Abrasion resistant

Applications

- Foundry patterns
- Metal forming tools
- General abrasion resistant tooling aids

Processing Properties

			EG-2103	EH-2903
Color	visual		Black	Clear
Mix ratio		parts by weight	100	11
Density	ISO 1183	g/cm ³	2.84	1.09

			EG-2103 / EH-2903
Pot life at 25 °C	250 ml	min	25
Demold time		h	16

Cured / Mechanical Properties

Cure: 7 days at RT or 14h at 40°C			EG-2103 / EH-2903
Appearance	visual		Black
Density	ISO 1183	g/cm ³	2.2
Hardness Shore D	ISO 868		85
Glass Transition Temperature, Tg	DSC	°C	85
Abrasion	Taber	mm ³ /100R	50-55

Processing

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

Mix the two components thoroughly in the ratio indicated.

Apply in thin layers with a brush.

Wait until gelcoat has gelled, but ensure that it is still slightly tacky before proceeding.

Post curing will improve final properties.

RAKU-TOOL[®] EG-2103 / EH-2903

Epoxy Gelcoat System

RT curing, iron filled

PC - Rev.-Status: 01- 2006/05/10

Page 2 of 2

Packaging

RAKU-TOOL [®] EG-2103	6 x 0.56 kg / 6.8 kg
RAKU-TOOL [®] EH-2903	6 x 0.75 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.