

# RAKU-TOOL<sup>®</sup> EL-2201 / EH-2904, EH-2905, EH2906

## Epoxy Laminating System

Unfilled epoxy with variable reactivity  
(fast / medium / slow)

Supplied by

**AMBERCOMPOSITES**

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### Key Properties

- Pot life and curing time can be adjusted through choice of hardener
- High mechanical properties at RT curing
- Excellent compatibility with fibres, fabrics and fillers
- Backing resin with mineral and metal fillers

### Applications

- Jigs and foundry patterns
- General tools and tooling aids
- UP Lay up tools
- Backing structures

### Processing Properties

			EL-2201	EH-2904	EH-2905	EH-2906
Color	visual		Clear	Clear	Clear	Clear
Mix ratio		pbw	100	50		
			100		50	
			100			50
Density	ISO 1183	g/cm <sup>3</sup>	1.17	1.00	1.01	1.01
Viscosity at 25 °C	ISO 2555	m Pa.s	7000-9000	60-110	50-100	50-100

			EL-2201 / EH-2904	EL-2201 / EH-2905	EL-2201 / EH-2906
Mix viscosity at 25 °C	ISO 2555	m Pa.s	800-900	700-800	600-700
Pot life at 25 °C	500 ml	min	35	65	145
Max. layer thickness		mm	8	8	8
Demold time		h	12	16	18

### Cured / Mechanical Properties

Cure: 7 days at RT or 14h at 40°C

			EL-2201 / EH-2904	EL-2201 / EH-2905	EL-2201 / EH-2906
Appearance	visual		Clear	Clear	Clear
Density	ISO 1183	g/cm <sup>3</sup>	1.1	1.1	1.1
Glass Transition Temperature, T <sub>g</sub>	DSC	°C	55-60	50-55	45-50
Flexural strength	ISO 178	MPa	90-100	90-100	90-100
Flexural modulus	ISO 178	MPa	2800-3200	2800-3200	2800-3200

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### Processing

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

Mix the two components thoroughly in the ratio indicated.

Impregnate each layer of cloths to construct the laminate layer by layer.

Post-curing will improve final properties.

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### Packaging

RAKU-TOOL <sup>®</sup> EL-2201	25 kg / 200 kg
RAKU-TOOL <sup>®</sup> EH-2904	6 x 0.28 / 2 kg / 25 kg
RAKU-TOOL <sup>®</sup> EH-2905	6 x 0.28 / 2 kg / 25 kg
RAKU-TOOL <sup>®</sup> EH-2906	6 x 0.28 / 2 kg / 25 kg

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### 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.

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### 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.