

RAKU-TOOL[®] EL-2207 / EH-2907

Epoxy Laminating Paste

Laminating system replacement for models, molds and tooling aids

PC - Rev.-Status: 01- 2006/06/15

Page 1 of 2

Key Properties

- Room temperature curing
- Can be used with a layer thickness of up to 15-25 mm
- Easy application by hand

Applications

- Reinforcement of molds and tooling aids
- Backing structures
- Jigs and Fixtures

Processing Properties

			EL-2207	EH-2907
Color	visual		Gray	Blue
Mix ratio		pbw	100	10
Density	ISO 1183	g/cm ³	1.32	0.98
			EL-2207 EH-2907	
Mix viscosity at 25 °C	ISO 2555	m Pa.s	fibrous paste	
Pot life at 25 °C	500 ml	min	90	
Max. layer thickness		mm	15-25	
Demold time		h	18	

Cured / Mechanical Properties

Cure: 7 days at RT or 14h at 40°C			EL-2207 EH-2907
Appearance	visual		Gray/Blue
Density	ISO 1183	g/cm ³	1.2
Glass Transition Temperature, Tg	DSC	°C	45-50
Flexural strength	ISO 178	MPa	50-60
Flexural modulus	ISO 178	MPa	6500-7000

RAKU-TOOL[®] EL-2207 / EH-2907

Epoxy Laminating Paste

Laminating system replacement for models, molds and tooling aids

PC - Rev.-Status: 01- 2006/06/15

Page 2 of 2

Processing

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

Small quantities can be mixed by hand (wearing protective rubber gloves) until a homogeneous color is obtained. For larger quantities it is necessary to use a mixing machine. When a mixing machine is used the mixing time should be kept short (under 2 minutes).

The paste can be applied by hand (wearing protective rubber gloves) layer by layer, slightly overlapping and pushed together or it is rolled out in the desired layer thickness using spacing layers. With easy shapes the paste can be evened out and compressed by hand (wearing protective rubber gloves) or using a roller. With more complicated shapes it is recommended to use pressing with steel wool to even out and compress the paste.

Packaging

RAKU-TOOL [®] EL-2207	20 kg
RAKU-TOOL [®] EH-2907	2 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.