

RAKU-TOOL® EL-2209 / EH-2950**Epoxy Coupling Coat****Prefabricated, two component coupling coat**

PC - Rev.-Status: 01- 2006/06/16

Page 1 of 2

Key Properties

- Universally applicable coupling coat
- Very good temperature resistance
- Excellent interlayer adhesion
- Consistent thixotropy

Applications

- Production of tools, molds and tooling aids with various systems like Epoxy and Polyurea Systems
- Coupling layer between gelcoat and backing structure (e.g. casting, laminating, tamping)

Processing Properties

			EL-2209	EH-2950
Color	visual		Gray	Clear
Mix ratio		pb weight	100	10
Density	ISO 1183	g/cm ³	1.79	1.01
Viscosity at 25 °C	ISO 2555	m Pa.s	100000-200000	200-400

			EL-2209 / EH-2950
Mix viscosity at 25 °C	ISO 2555	m Pa.s	100000-200000
Pot life at 25 °C	500 ml	min	30
Max. layer thickness		mm	
Demold time		h	16

Cured / Mechanical Properties

Cure: 7 days at RT or 14h at 40°C			EL-2209 / EH-2950
Appearance	visual		Gray
Density	ISO 1183	g/cm ³	1.6
Glass Transition Temperature, Tg	DSC	°C	110-115
Flexural strength	ISO 178	MPa	95-105
Flexural modulus	ISO 178	MPa	6700-7200

Processing

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

Mix the two components thoroughly in the ratio indicated.

Apply the coupling coat with a spatula/brush in thin, even layers.

Post-curing will improve final properties.

RAKU-TOOL[®] EL-2209 / EH-2950

Epoxy Coupling Coat

Prefabricated, two component coupling coat

Packaging

RAKU-TOOL [®] EL-2209	10 kg
RAKU-TOOL [®] EH-2950	1 kg / 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.

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.