

EG-2102 / EH-2901-2, EH-2950-1

Epoxy Gelcoat Resin

Abrasion resistant, room temperature curing

Key Properties

- Good mechanical properties
- Excellent abrasion resistance
- Good chemical resistance
- Good temperature resistance

Applications

- Foundry patterns
- Foam molds
- UP forming tools
- Tools
- Tooling aids

Processing Properties

		Unit	EG-2102	EH-2901-2	EH-2950-1
Color	visual		blue	yellowish	yellowish
Mix ratio		pbw	100	10	-
Mix ratio		pbw	100	-	8
Density	ISO 1183	g/cm ³	ca. 1.90	ca. 1.07	ca. 1.01

		Unit	EG-2102 / EH-2901-2	EG-2102 / EH-2950-1
Pot life at 25 °C	250 ml	min	25 - 30	50 - 60
Demold time		h	12	16

Cured / Mechanical Properties

		Unit	EG-2102 / EH-2901-2 7 days at RT or 14h at 40°C	EG-2102 / EH-2950-1 16h at RT + 14h at 80°C
Cure				
Color		visual	blue	blue
Density	ISO 1183	g/cm ³	ca. 1.80	ca. 1.80
Hardness	ISO 868	Shore D	90 - 95	90 - 95
Deflection temperature, HDT	ISO 75	°C	60 - 65	95 - 100
Glass transition temperature, Tg	DSC	°C	60 - 65	100 - 105
Abrasion	Taber	mm ³ /100R	15 - 20	5 - 10



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Processing

The processing temperature 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 the gelcoat has gelled, but ensure that it is still slightly tacky before proceeding.

EG-2102 / EH-2950-1

The mechanical properties and temperature resistance are only obtained through a post cure according to the recommended cure schedule.

Recommended cure schedule

Recommended cure schedule (EG-2102 / EH-2950-1)

After initial curing at room temperature for 12-24 hours depending on the size and thickness of the parts, the parts must be heated up to 80°C in steps and post cured for 14 hours at 80°C, then cooled down gradually. The curing time at room temperature, heating and cooling rate depend on the size and thickness of the parts.

Packaging

RAKU® TOOL EG-2102	5 kg
RAKU® TOOL EH-2901-2	6 x 1 kg
RAKU® TOOL EH-2950-1	2 kg, 6 x 1 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.