

## EP-2305 / EH-2903-1, EH-2904-1

### Adhesive for styling boards

Room temperature curing, two component epoxy

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#### Key Properties

- Similar color, density and hardness to board material
- Room temperature curing
- Thixotropic or low viscosity depending on choice of hardener

#### Applications

- For bonding of styling boards with a density < 0.50 g/cm<sup>3</sup>

#### Processing Properties

		Unit	EP-2305	EH-2903-1	EH-2904-1
Color	visual		apricot	orange	yellowish
Mix ratio		pbw	100	25	-
Mix ratio		pbw	100	-	30
Density	ISO 1183	g/cm <sup>3</sup>	ca. 0.60	ca. 1.10	ca. 1.00

		Unit	EP-2305 / EH-2903-1	EP-2305 / EH-2904-1
Pot life at 25 °C	500 ml	min	10 - 20	25 - 35
Minimum curing time	25°C	h	16	16

#### Cured / Mechanical Properties

Cure		Unit	EP-2305 / EH-2903-1 7 days at RT or 14h at 40°C	EP-2305 / EH-2904-1 7 days at RT or 14h at 40°C
Color		visual	apricot	apricot
Density	ISO 1183	g/cm <sup>3</sup>	ca. 0.66	ca. 0.68
Hardness	ISO 868	Shore D	58 - 63	55 - 60
Coefficient of thermal expansion	ISO 11359	10 <sup>-6</sup> K <sup>-1</sup>	50 - 60	50 - 60
Deflection temperature, HDT	ISO 75	°C	45 - 50	45 - 50
Glass transition temperature, Tg	DSC	°C	50 - 55	50 - 55
Compressive strength	ISO 604	MPa	18 - 23	15 - 20
Compressive modulus	ISO 604	MPa	1,000 - 1,500	800 - 1,300
Flexural strength	ISO 178	MPa	20 - 25	18 - 23
Flexural modulus	ISO 178	MPa	1,000 - 1,500	800 - 1,300



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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 and apply to both sides of the surface to be bonded.

### Packaging

RAKU® TOOL EP-2305	3 kg
RAKU® TOOL EH-2903-1	6 x 0,75 kg
RAKU® TOOL EH-2904-1	2 kg, 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.