

Adhesive for epoxy boards

Key Properties

- Similar density, hardness, temperature resistance and coefficient of thermal expansion to epoxy board material

Applications

- Bonding of epoxy boards

Processing properties Adhesive

			EP-2304	EH-2934-1
Color	visual		Green	Yellowish
Mix ratio		pb weight	100	20
		pb volume	100	10
Density	ISO 1183	g/cm ³	ca. 0.88	ca. 1.02
			EP-2304 / EH-2934-1	
Pot life at 25 °C	500 ml	min	50 – 60	
Max. layer thickness		mm	–	
Minimal curing time at 25 °C		h	16	

Cured / Mechanical Properties

Cure: 16h at RT + 14h at 120°C			EP-2304 / EH-2934-1	
Aspect	visual		Light green	
Density	ISO 1183	g/cm ³	ca. 0.9	
Shore hardness D	ISO 868		75 – 80	
Coefficient of thermal expansion	ISO 11359	10 ⁻⁶ K ⁻¹	35 – 45	
Deflection temperature, HDT	ISO 75	°C	115 – 120	
Glass Transition Temperature, Tg	DSC	°C	115 – 120	
Compressive strength	ISO 604	MPa	65 – 70	
Compressive modulus	ISO 604	MPa	3,000 – 3,500	
Flexural strength	ISO 178	MPa	45 – 50	
Flexural modulus	ISO 178	MPa	3,000 – 3,500	

Processing

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

Recommended cure schedule

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 120°C in steps and post cured for 14 hours at 120°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 EP-2304	5 kg
RAKU® TOOL EH-2934-1	1 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.
