

## Adhesives for bonding styling boards

RT curing

### Key Properties

- Reduced hazard rating
- Color matched
- Similar density and hardness to board material
- RT curing
- Thixotropic or low viscosity depending on choice of hardener

### Applications

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

### Processing Properties

			EP-2305	EH-2903-1	EH-2904-1
Color	visual		Apricot	Orange	Clear
Mix ratio		parts by weight	100	25	
			100		30
Density	ISO 1183	g/cm <sup>3</sup>	ca. 0.60	ca. 1.09	ca. 1.00
Viscosity at 25 °C	DIN 53019-1	mPa·s	paste	thixotropic paste	90 -130

			EP-2305 / EH-2903-1	EP-2305 / EH-2904-1
Pot life at 25 °C	500 ml	min	15	25
Max. layer thickness		mm	-	-
Minimum curing time (at 25°C)		h	16	16

### Cured / Mechanical Properties

Cure: 7 days at RT or 14h at 40°C			EP-2305 / EH-2903-1	EP-2305 / EH-2904-1
Appearance	visual		Apricot	Apricot
Density	ISO 1183	g/cm <sup>3</sup>	ca. 0.66	ca. 0.68
Shore hardness D	ISO 868		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	1000-1500	800-1300
Flexural strength	ISO 178	MPa	20-25	18-23
Flexural modulus	ISO 178	MPa	1000-1500	800-1300

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### 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.

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### Packaging

RAKU-TOOL® EP-2305	3 kg
RAKU-TOOL® EH-2904-1	2 kg, 1 kg, 6 x 1 kg
RAKU-TOOL® EH-2903-1	6 x 0.75 kg

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### 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.

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### 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.

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