

Epoxy Casting System

Flame Retardant Epoxy System For Castings

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Key Properties

- Flame Retardant
- E-84 Class A certified
- Good flow
- Working Life is almost 2.5 hours

Applications

- Molded theme park castings

Processing Properties

			Resin	Hardener
Mix ratio		pbw	100	100
		pbv	100	87.5
Density	ASTM D-792	g/cm ³	ca. 1.5	ca. 1.6
Viscosity at 77°F (25°C)	ASTM D-2393	cP	28,000-33,000	18,000-23,000

			Resin / Hardener
Mix viscosity at 77°F (25°C)	ASTM D-2393	cP	48,000 – 55,000
Pot life at 77°F (25°C)	150 ml	min	30 – 45
Working life 77°F (25°C)	150 ml	hours	2 – 3
Demold time at 77°F (25°C)		hours	16

Cured / Mechanical Properties

Cure: 16 hours at 25°C

			Resin / Hardener
Aspect	visual		Grey
Density	ASTM D-792	g/cm ³	ca. 1.6
Shore hardness D	ASTM D-2240		80 – 85

Processing

The processing and material temperature should be between 77°F (25°C).

For best results, de-air the material prior to casting. Stir the two components separately and thoroughly prior to mixing in the ratio indicated. For large castings the product can be poured in layers within the working life period.

Recommended cure schedule

Cure schedule at room temperature is normally 16 hours. The curing time will vary depending upon the size of the casting material. At elevated temperatures (60°C) the curing cycle can be as low as 4 hours, but will depend upon the customer's requirements.

Packaging

RAKU®-TOOL EC-2406 Resin – Quart Kit	1.35 Kg
RAKU®-TOOL EH-2945 Hardener – Quart Kit	1.35 Kg
RAKU®-TOOL EC-2406 Resin – Gallon Kit	5.4 Kg
RAKU®-TOOL EH-2945 Hardener – Gallon Kit	5.4 Kg
RAKU®-TOOL EC-2406 Resin – Pail Kit	27 Kg
RAKU®-TOOL EH-2945 Hardener – Pail Kit	27 Kg

Storage

Original containers should be kept tightly sealed and stored at ambient temperatures 59-86°F (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.
