

RAKU-DPRGI®
EA-2810 & EH-2810



Epoxy Adhesive

General Purpose Board Adhesive

Key Properties

- Color indicated mixing
- Easy to spread
- High heat resistance

Applications

- General tooling board bonding
- Thermoform tooling

Processing Properties

			Resin	Hardener
Aspect	visual		Green	Amber
Mix Ratio		pbw	100	25
		pbv	100	32
Density	ASTM D-792	g/ml	1.18	0.91
Viscosity at 25°C (77°F)	ASTM D-2393	cP	80,000	200

				Mixture
Mix Viscosity at 25°C (77°F)	ASTM D-2393	cP		18,000
Working Life		min		40-50

Cured / Mechanical Properties

Cure 1: 16hr @ Room Temperature			Cure 1	Cure 2
Cure 2: 4hr @77°F(25°C) + 4hr @				
Aspect	visual		Grey	Grey
Density	ASTM D-792	g/ml	1.05	1.05
Shore D Hardness	ASTM D-2240		70-75	75-80
DSC Tg	ASTM D-7426	°C	86	105

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Processing

The processing and material temperature should be between 68-77°F (20-25°C). Mix both parts together until the color changes to grey. Apply in a thin coating to parts that need to be bonded. Higher temperature resistance can be achieved through a short post cure.

Packaging

Quart Kit	2.75	lbs.	1.2	kg
1 Gal. Kit	11	lbs.	5.0	kg

Storage

Original containers should be kept tightly sealed and stored at ambient temperatures 59-86°F (15-30°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 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.

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Our recommendations on the use of the material are based on many years of experience and current scientific and practical knowledge. They are, however, provided without any obligation on our part and do not relieve the buyer of the need for suitability tests. They do not constitute a legal relationship, nor are any protected third party rights whatsoever affected thereby.