

EP-2309 / EH-2939

Adhesive for epoxy boards

High temperature resistant

Key Properties

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

Applications

- Bonding of epoxy working board WB-0950

Processing Properties

		Unit	EP-2309	EH-2939
Color	visual		brown	yellowish
Mix ratio		pbw	100	40
Mix ratio		pbv	100	36
Density	ISO 1183	g/cm ³	ca. 1.00	ca. 1.10

		Unit	EP-2309 / EH-2939
Pot life at 25 °C	500 ml	min	120 - 150
Minimum curing time	25°C	h	12

Cured / Mechanical Properties

		Unit	EP-2309 / EH-2939 16h at RT + 14h at 180°C
Cure			
Color		visual	brown
Density	ISO 1183	g/cm ³	ca. 1.10
Hardness	ISO 868	Shore D	82 - 87
Coefficient of thermal expansion	ISO 11359	10 ⁻⁶ K ⁻¹	35 - 45
Glass transition temperature, Tg	DSC	°C	190 - 200
Compressive strength	ISO 604	MPa	100 - 120
Compressive modulus	ISO 604	MPa	4,200 - 4,700
Flexural strength	ISO 178	MPa	60 - 70
Flexural modulus	ISO 178	MPa	4,200 - 4,700

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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.

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

Recommended cure schedule

The material can be milled (rough milling) after pre curing of 12-24 hours at room temperature. After rough milling, the part and the adhesive need to be post cured according to the cure cycle provided for the selected prepreg.

Packaging

RAKU® TOOL EP-2309	5 kg
RAKU® TOOL EH-2939	2 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.