# RAKU<sup>®</sup> TOOL

## EP-2309 / EH-2939



Adhesive for epoxy boards High temperature resistant

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Key Properties
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• 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/cm³	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

Cure		Unit	EP-2309 / EH-2939 16h at RT + 14h at 180°C
Color		visual	brown
Density	ISO 1183	g/cm³	ca. 1.10
Hardness	ISO 868	Shore D	82 - 87
Coefficient of thermal expansion	ISO 11359	10^-6K^-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.

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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. The technical data sheet is not a specification, but contains only approximate values.