

## Epoxy Casting System

With metal fillers

### Key Properties

- Universally applicable
- Low sedimentation
- Good mechanical properties
- Easy to pour
- Workable, hard surface

### Applications

- Foundry patterns
- Copy models
- Metal forming
- General modeling

### Processing Properties

			EC-2402	EH-2902-1
Color	visual		Black	Clear
Mix ratio		parts by weight	100	15
Density	ISO 1183	g/cm <sup>3</sup>	ca. 2.84	ca. 0.96
Viscosity at 25 °C	DIN 53019-1	mPa·s	100000-200000	1000-2000

			EC-2402 / EH-2902-1
Mix viscosity at 25 °C	DIN 53019-1	mPa·s	25000-30000
Pot life at 25 °C	1000 ml	min	130 - 140
Max. layer thickness		mm	40
Demold time		h	18

### Cured / Mechanical Properties

Cure: 7 days at RT or 14h at 40°C			EC-2402 / EH-2902-1
Appearance	visual		Black
Density	ISO 1183	g/cm <sup>3</sup>	ca. 2.2
Shore hardness D	ISO 868		85-90
Coefficient of thermal expansion	ISO 11359	10 <sup>-6</sup> K <sup>-1</sup>	50 - 60
Deflection temperature, HDT	ISO 75	°C	55 - 60
Glass Transition Temperature, Tg	DSC	°C	55 - 60
Compressive strength	ISO 604	MPa	100-105
Compressive modulus	ISO 604	MPa	5500-6000
Flexural strength	ISO 178	MPa	75-80
Flexural modulus	ISO 178	MPa	5000 - 5500
Linear shrinkage*		mm / m	0.6

\*measured on maximum layer thickness as stated above

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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.

Degassing is recommended.

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### Packaging

RAKU-TOOL® EC-2402	6 x 1.86 kg / 13.5 kg
RAKU-TOOL® EH-2902-1	2.02 kg / 22 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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