



Epoxy Casting System

Three component system with synthetic filler combination

Key Properties

- Excellent stability
- No crack formation a low exotherm during cure
- Thermal coefficient of expansion adapted to steel

Applications

- Foaming tools
- Blow molds
- Metal forming tools
- Rolls, spindles and similar

Processing Properties

			EC-2461	EH-2961	AC-9061
Color	visual		Clear	Yellowish	Dark gray
Mix ratio		parts by weight	100	33.3	1117
Density	ISO 1183	g/cm ³	ca. 1.1	ca. 1.0	ca. 2.7
Viscosity at 25 °C	DIN 53019-1	mPa·s	-	-	-

			EC-2461 / EH-2961 / AC-9061		
Mix viscosity at 25 °C	DIN 53019-1	mPa·s	-		
Pot life at 25 °C	1000 ml	min	120 - 180		
Max. layer thickness		mm	15 - 300		
Demold time		h	24		

Cured / Mechanical Properties

Cure: 16h at RT + 14h at 80°C			EC-2461 / EH-2961 / AC-9061		
Appearance	visual		Dark gray		
Density	ISO 1183	g/cm ³	ca. 2.5		
Coefficient of thermal expansion	ISO 11359	10 ⁻⁶ K ⁻¹	10		
Deflection temperature, HDT	ISO 75	°C	95 -100		
Compressive strength	ISO 604	MPa	150		
Flexural strength	ISO 178	MPa	50		
Flexural modulus	ISO 178	MPa	35000		

Processing

The processing and material temperature should be between 20-25 °C.

Mix the two components thoroughly in the ratio indicated. Degassing is recommended.

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

Recommended cure schedule

After initial curing at room temperature for 12-24 hours depending on the size and thickness of the parts, the parts must be heated up to 80°C in steps and post cured for 14 hours at 80°C, then cooled down gradually. The curing time at room temperature, heating and cooling rate depend on the size and thickness of the parts.

Packaging

RAKU-TOOL®

EC-2461 / EH-2961 / AC-9061

2,4 kg / 0,8 kg / 26,8 kg = 30 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.
