

BÜFA® -Tooling-Gelcoat-VE-S-A-BF-60625-light green

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BÜFA®-Tooling-Gelcoat-VE are pigmented, thixotropic and pre-accelerated gelcoats based on an epoxy-bisphenol A-vinyl ester urethane resin dissolved in styrene.

Profile

Product family	TOOLING
Product type	Gelcoat
Processing method	Spray quality
Pre-accelerated product	Yes
Resin base	VEU
Colour	green
BF-Number	BF-60625
Odour	like styrene

Application Range

BÜFA®-Gelcoat-VE-U500 products have been specifically for the manufacture of GFRP moulds. The product is particularly suitable for the manufacture of moulds that are exposed to high chemical and thermal stress.

Specification / Technical Data

Density (BM D01) approx.	1,14 g/mL
Flashpoint (BPV FP 02) approx.	32°C
Styrene content approx.	39.2 %
Viscosity (BM V01) Viskosität bei 25°C mit Spindel 4 und 2 U/min	30,000 - 36,000 mPas

Viscosity (BM V01) Viskosität bei 25°C mit Spindel 4 und 20 U/min	4,000 - 5,500 mPas
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The BÜFA testing standards define the testing scenario after the values are determined in our facilities. They relate to generally accepted standards and are available under request.

Curing

Reactivity	BM R01
Sample size	100g sample
Peroxide addition	2.0 Vol% Curox M-303
Geltime (Reactivity 25°C-35°C)	11 - 13 min
T-Max (Reactivity Tmax at 25°C)	175 - 195 °C

ATTENTION! The above information refers exclusively to the use of the peroxides mentioned here in the indicated dosage. If other products are used or if the dosage differs, the results may vary.

BÜFA®-Tooling-Gelcoat-VE-S-A-BF-60625-I-light green can be cured with standard methyl ethyl ketone peroxides without worrying about the foaming typical for normal vinyl ester resins.

2xx- Batch production

The inspection and verification of the product quality (according to specification) is carried out within the framework of quality control directly after the production of the batch product.

3xx- InPlant- and 4xx- Tinting production

The base products used in the colouring process were inspected within the framework of quality control with regard to their product quality (according to specification).

The pigmented Gelcoats produced in the tinting process are not subjected to any further inspection.

To optimize the molding material properties, we recommend post-curing (tempering) the component for several hours at 80 °C. This achieves the optimal gelcoat properties.

Processing

The gelcoat should be stirred gently before processing.

For processing and curing, the instructions in our "Working with BÜFA®-Gelcoats" technical information leaflet must also be observed.

Before applying the release agent, it is essential to ensure that the surface finish of the model is completely hardened. For the separation, we recommend applying 6-7 layers of BF 700 Carnauba Wax. Between each waxing, the release coatings must be allowed to dry for at least 1 hour.

The completely released model should ideally be stored overnight before the start of mould construction. To ensure reliable release, the release wax should be tested in advance on a separate sheet.

Optimum results are achieved by observing the following instructions: The wet film thickness of the product should ideally be between 700 - 900 µm in the liquid state and should not fall below a film thickness of 900 µm wet.

This gelcoat can be processed with appropriate application systems from the BÜFA®-Tec range.

ATTENTION! Use only dried and de-oiled compressed air!

The fine layer should be applied in 3 - 4 coats to ensure optimal de-airing. A de-airing time of 3 mins. should be observed between sprayings.

Colouring

limited (green and black)

Storage and handling

As a result of the wide range of factors which may influence the operating conditions and the application of the product, the user must still carry out their own tests and trials.

The product must be stored closed, in a cool, dry place and protected from sunlight.

Higher temperatures reduce storage life.

The setting and curing times as well as the viscosities may vary with longer storage periods.

In unopened and undamaged original containers, at storage temperatures of up to 20°C the product can be used for at least 3 months.

The above details have been compiled to the best of our knowledge and are based on our current knowledge and experience. These details only constitute product descriptions. Under no circumstances do they constitute guarantees relating to quality or durability. The processor is obliged to carry out their own tests and investigations in order to take responsibility for any processing and application of our products in the processor's application area. The latest version of the corresponding EU safety data sheet must also be observed.