

# BÜFA® -Tooling-Gelcoat-VE-H-A-black

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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

<b>Product family</b>	TOOLING
<b>Product type</b>	Gelcoat
<b>Processing method</b>	Hand quality
<b>System</b>	Tooling
<b>Pre-accelerated product</b>	Yes
<b>Resin base</b>	VEU
<b>Colour</b>	black
<b>Odour</b>	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

<b>Density (BM D01) approx.</b>	1.15 g/mL
<b>Flashpoint (BPV FP 02) approx.</b>	32°C
<b>Styrene content approx.</b>	31.1 %
<b>Viscosity (BM V01) Viscosity at 25°C with spindle 4 and 2 rpm</b>	70,000 - 85,000 mPas

<b>Viscosity (BM V03) Viscosity at 23°C with measuring body Z3 and 600 rpm</b>	880 - 1,030 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

<b>Reactivity</b>	BM R07
<b>Sample size</b>	100g sample
<b>Peroxide addition</b>	2.0 vol% Curox M-303
<b>Geltime (Reactivity 25°C-35°C)</b>	10 - 14 min
<b>T-Max (Reactivity Tmax at 25°C)</b>	170 - 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-H-A-black 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 assurance of the product quality (goods conforming to specifications) is carried out as part of the quality assurance directly after the production of the product. 3xx- InPlant and 4xx- Tinting production - The base products used in the tinting process were checked for their product quality (in accordance with specifications) as part of the quality assurance process. The pigmented topcoat resins produced in the tinting process are not subject 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 only be processed manually as a result of the product composition.

The first fine layer is applied by brush or roller with a layer thickness of 400-500 µm. After curing, a second layer of 300-400 µm is applied to even out thinner areas and ensure an even thickness.

## 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.