BÜFA®-Conductive-Tooling GC-S Nature

Prod. No. 7200100

VE Tooling Gelcoat, spraying quality

Technical Data Sheet

Product description

BÜFA®-Conductive-Tooling GC-S nature is a pre-accelerated tooling gelcoat in a spraying consistency with electrical conductive properties. The base resin is a bisphenol A based vinyl ester-urethane-hybrid resin dissolved in styrene.

Applications

BÜFA®-Conductive-Tooling GC-S nature was especially developed for the production of GRP moulds. The product is particularly suitable for moulds that are subjected to high chemical and thermal loads. When properly earthed, electro-static charging can be counteracted due to its conductive properties.

Specifications / technical data

Property	Test method	Value	Unit
Density at 20 °C	DIN 53 217/2	1,0-1,2	g/ml
Viscosity at 20 °C Brookfield RV/DV-II Spl 4. 4 rpm.	ISO 2555	19000-28000	mPas
Styrene content		45-55	%
Flash point	DIN 51758	33,5	°C

Curing Reactivity

Reactivity TM 2626:
(100 g gelcoat + 2 ml Curox M-303)

20 - 30 °C	12 - 18 min
20 °C – Tmax	25 - 35 min
Tmax	180 - 210 °C

Gel time at 20 °C in a 100 g cup
with 2.0 ml Curox M-303: 12 - 18 min

Attention!
The information given above refers exclusively to the use of the catalyst named and the quantity specified. The use of different products or differing quantities may yield different results.

Colouring

Along with the unpigmented formulation described here, the following tinted versions are available.

Art. No. 720-0101 BÜFA®-Conductive-Tooling GC-S nature
Art. No. 520-0101 BÜFA®-Conductive-Tooling GC-S black
Art. No. 520-0102 BÜFA®-Conductive-Tooling GC-S green

Since the ability to pigment this class of resin is limited, it is essential that only the pigmentations we offer are used. Never tint with untested pigments on your own.

Directions for use

This product is supplied pre-accelerated and ready to use. It can be cured with a standard MEKP hardener such as Curox M-303 without the foam formation typical for vinyl ester resins. The gelcoat has excellent working parameters with BÜFA®-Standard spraying equipment such as the BÜFA®-Tec GSU Delta5.5 or the BÜFA®-Tec Spritzpistole Polycon.

We recommend the following settings:

BÜFA®-Tec GSU Delta5.5:
Nozzle: 4/18
Pressure: 4 bar
Supporting air: 1.6 bar

BÜFA®-Tec Spritzpistole Polycon
Nozzle: 8
Pressure: 3.5 bar

The best results are achieved by observing the following notes:

- The thickness of the gelcoat in the liquid state should be 700 -900 µm
- The gelcoat should be applied in 3-4 spraying operations to ensure optimal venting
- A venting time of 1-2 minutes should be observed between the spraying operations.

Notes on release agents

Before the release agent is applied, make sure that the surface finish of the model is completely cured. For release, we recommend the application of 6-7 layers of BF 700 Carnauba Wax. Each layer of wax that is applied should dry for at least an hour before the next layer is applied. The completely treated model should be stored best overnight before mould-making is

begun. To ensure reliable release, the release wax should be tested on a separate sheet first.

Storage/Handling

This product must be stored cool in closed containers, protected from sunlight. Shelf-life is at least 3 months in unopened, original containers stored up to a temperature of 20 °C. Gel and curing times may change with increasing duration of storage.

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