

BÜFA[®]-VE-Tooling-Gelcoat-S natural

VE tooling gelcoat, spraying quality - Prod. No. 7201000

PRODUCT DESCRIPTION

BÜFA[®]-VE-Tooling-Gelcoat-S is an unpigmented gelcoat in a spraying consistency. It is pre-accelerated and based on epoxy-bisphenol A-vinyl ester-urethane resin dissolved in styrene.

APPLICATIONS

BÜFA[®]-VE-Tooling-Gelcoat-S 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.

SPECIFICATIONS / TECHNICAL DATA

Property	Test method	Value	Unit
Density at 20 °C	DIN 53 217/2	1,1	g/ml
Viscosity at 20°C Brookfield RV/DV-II spl 4. 2 rpm.	ISO 2555	30 000 - 36 000	mPas
Styrene content		39 - 42	%
Flash point	DIN 51 758	+ 32	°C

CURING

REACTIVITY		
BÜFA method in accordance with DIN 16 945 6.2.2.1 (100 g resin + 2 % by weight Butanox M-50)	20 - 30 °C 20 °C - Tmax Tmax	12 - 16 min 25 - 30 min 175 - 195 °C
Gel time at 20 °C in a 100 g cup with 2.0 g Butanox M-50		12 - 16 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.

Product No. 520-1104 BÜFA®-VE-Tooling-Gelcoat-S black
Product No. 520-1108 BÜFA®-VE-Tooling-Gelcoat-S light green
Product No. 520-1110 BÜFA®-VE-Tooling-Gelcoat-S orange
Product No. 520-1112 BÜFA®-VE-Tooling-Gelcoat-S grey

Viscosity of the pigmented versions may vary in the range of: Viscosity ISO 2555 at 20 °C with Brookfield RV/DV-II Spl 4. 2 rpm: 24000 - 36000 mPas

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

DIRECTIONS FOR USE

BÜFA®-VE-Tooling-Gelcoat-S comes pre-accelerated and ready to use. The gelcoat can be cured with standard MEK peroxides without having to worry about the formation of foam typical for normal vinyl ester resins. The gelcoat has excellent working properties in standard spraying units.

We recommend the following settings.

- Spray application: nozzle 4-5 mm, pressure 4-5 bar
- Airless: nozzle 17/40 to 19/40, pressure 3.5-4.0 bar
- Supporting air: max 6 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 3 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.

Note: The Information given above is based on our current state of knowledge and experience. In view of the many factors that may influence working conditions and the application of our products, the user is not relieved from carrying out his own tests and experiments. No legally binding warranty of certain properties or suitability for a particular purpose can be derived from this information. It is the responsibility of the receiver or user of our products to observe proprietary rights as well as existing laws and regulations. The latest version of the corresponding EU Safety Data Sheet must also be observed.