

# BÜFA®- Resin VE 6520 RTM

## VE-RTM-Resin

Prod. No. 700-6520

### Technical Data Sheet

#### Product description

BÜFA®-Resin VE 6520 RTM is a filled, pre-accelerated resin system with reduced monomer content based on a vinyl ester resin and low profi leadditive dissolved in styrene. BÜFA®-Resin VE 6520 has low reactivity and viscosity and cures with virtually no shrinkage when used correctly.

#### Applications

BÜFA®-Resin VE 6520 RTM is used to produce RTM parts which are subject to heavy mechanical and thermal loads. The very good curing in thin layers combined with reduced exothermicity where layer thicknesses are greater, as well as the dimensional tolerance of the system make

BÜFA®-Resin VE 6520 RTM an ideal resin for parts where the highest quality standards are applied to the surface.

#### Specifications / technical data

Property	Test Method	Value	Unit
Density at 20 °C	Din 53 217/2	1.31	g/ml
Viscosity at 25°C Brookfield RV/DV-II Spl 4 rpm 100	ISO 2555	320-440	mPas
Flash point	EN ISO 3679:2014 Verfahren B	33.5	°C
Styrene content		28-30	%

#### Curing

<b>Reactivity</b>		
<b>BÜFA-Method in conformity with DIN 16 945 6.2.2.1</b> (100 g resin + 2 ml Curox M-102)	20 - 30 °C 20 °C - Tmax Tmax	30-40 min 50-65 min 125-155°C
<b>Gelling point at 20 °C in a 100 g beaker with 2 ml Curox M-102</b>		35 min

<b>Reactivity, Geltimer</b>	
<b>Gelling point at 20 °C on 1 kg sample with 2 Vol% Curox M-102</b>	Approx. 38 min.
<b>Gelling point at 20 °C on 1 kg sample with 1.5 Vol% Curox M-102</b>	Approx. 45 min.

**Caution!**

The above details refer exclusively to the use of the reactant named here at the indicated dose. The results may be different if other products are used or if used at different doses.

**Directions for use**

BÜFA®-Resin VE 6520 RTM has been developed for processing in the RTM and RTMlight processes.

The resin should be brought to processing temperatures of between 18 and 28 °C before use. The resin must be stirred thoroughly before processing. Inadequate homogeneity can result in failure to cure. For processing, we recommend a combination of continuous strandmats as well as so-called core glasses which are particularly suitable for preventing an additive filtering effect due to their high permeability. If the use of fabric or core is required, our product 7000911 BÜFA® -

Resin VE 0911 RTM is quite likely to be the right product. Please contact us!

We recommend post-curing of the parts at 80 °C for 8 hours to achieve the optimal mechanical properties.

**Storage / Handling**

The product must be stored closed, cool and protected from sunlight. It can be stored for at least 4 months in its unopened and undamaged original packaging at a temperature of up to 20 °C. The gelling and curing times may change with increasing storage time.

**Former product name**

7916520 BÜFA®-Resin VE 6520 RTM

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.

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