

## NEOGEL® VE 8393-I-1

VE Spray Tooling Gelcoat

Prod. No. 6510001

**Product description** Neogel® VE 8393-I-1 is an unpigmented gelcoat in a spraying consistence. The gelcoat is pre-accelerated and is based on an epoxy bisphenol A vinyl ester-urethane resin dissolved in styrene.

**Applications** Neogel® VE 8393-I-1 Gelcoat-S was especially developed for the production of GRP moulds. The product is particularly suitable for producing 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	30000-36000	mPas
	Viscosity at 20 °C Brookfield RV/DV-II Spl 4. 20 rpm	ISO 2555	4000-5500	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 gelcoat + 2 ml Butanox M-50)

25 - 35 °C	11 - 13 min
Tmax	175 - 195 °C

**Gel time at 20 °C in a 100 g cup with 2 ml Butanox M-50:** 11 - 13 min

**Attention!**

The information given above on reactivity 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.

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## Colouring

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

Art. No. 500-0104 Neogel® VE 8393-W-0100 Black VE Spray Tooling Gelcoat

Art. No. 500-0110 Neogel® VE 8393-W-0520 Orange VE Spray Tooling Gelcoat

Art. No. 500-0108 Neogel® VE 8393-W-9617 Light Green VE Spray Tooling Gelcoat

Art. No. 500-0112 Neogel® VE 8393-W-0100 Grey VE Spray Tooling Gelcoat

Because of the limited ability to pigment this class of resin, attention should be strictly paid to using only the pigmentations we offer. Untested tinting on your own should never be carried out.

## Directions for use

Neogel® VE 8393-I-1 is pre-accelerated and ready for use as packaged. The gelcoat can be cured with standard MEK peroxides without having to fear the formation of foam typical for vinyl ester resins. The gelcoat has excellent working properties with 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
- Auxiliary air: max. 6 bar

The best results are achieved if the following notes are observed:

- The thickness of the gelcoat in the liquid state should range between 700 - 900 µm.
- The gelcoat should be applied in 3 - 4 working operations to ensure the best possible de-airing
- A de-airing time of 3 minutes should be observed between the spraying operations.

## Notes on Release Agents

Before applying the release agent, make sure that the surface finish of the model has completely cured. We recommend the application of 6 - 7 layers of BF 700 Carnauba Wax for release. Between the individual waxing operations, allow each layer to dry for at least 1 hour.

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The completely treated model should be stored overnight before beginning mould construction. To ensure reliable release, the release wax should be tested on a separate plate 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.

BÜFA Composite Systems GmbH & Co. KG  
Hohe Loohe 2-8  
26180 Rastede  
GERMANY  
Phone +49 4402 975-0  
Fax +49 4402 975-300  
compositesystems@buefa.de  
www.buefa.de  
www.buefacompositesystems.com

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