

NEOGEL®-VE 8394-I-1

VE Tooling Gelcoat, brushing quality

Prod. No. 6520001

Product description Neogel®-VE 8394-I-1 is an unpigmented, pre-accelerated gelcoat in a brushing consistence based on an epoxy bisphenol A vinyl ester-urethane resin dissolved in styrene.

Applications Neogel®-VE 8394-I-1 was especially developed for the production of GRP moulds. The product is particularly suitable for the production of 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	50000-56000	mPas
	Viscosity at 20 °C Brookfield RV/DV-II Spl . rpm .	ISO 2555	8000-10000	mPas
	Styrene content		39-42	%
	Flash point	DIN 51 758	+32	°C

Curing

Reactivity TM 2526:
(100 g gelcoat + 2 ml Butanox M-50)

25 - 35 °C	10 - 14 min
Tmax	170 - 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 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 also presently available:

Art. No. 500-0107 Neogel®-VE 8394-W-0100 Black VE Brush Tooling
Art. No. 500-0111 Neogel®-VE 8394-W-0520 Orange VE Brush Tooling
Art. No. 500-0109 Neogel®-VE 8394-W-9617 Light Green VE Brush Tooling
Art. No. 500-0113 Neogel®-VE 8394-W-0100 Grey VE Brush Tooling

Due to the limited ability to pigment this class of resins, only the pigmentations that we offer should be used. Never use untested pigmentations on your own.

Directions for use

Neogel®-VE 8394-I-1 is supplied in a pre-accelerated form proper for working. The gelcoat can be cured with standard MEK peroxides without the formation of foam typical for normal vinyl ester resins. The first layer of gelcoat is applied by brush roller in a layer 400 - 500 µm thick. After curing, a second coat 300 - 400 µ thick is applied to even thin areas and ensure a uniform layer.

Notes on release agents

Before applying the release agent, make sure that the finished surface of the model has completely cured. For release, we recommend the application of 6 - 7 layers of BF 700 Carnuba Wax. Allow the layers of release agent to dry for at least 1 hour between waxing operations. The completely waxed model should be stored overnight before making moulds. To ensure reliable release, the release wax should be tested in advance on a separate sheet.

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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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 Looge 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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