

BÜFA®-Conductive-Tooling GC-S nature

VE Tooling Gelcoat, spraying quality

Prod. No. 7200100

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
		ISO 2555		mPas
	Styrene content		45-55	%
	Flash point	DIN 51 758	33,5	°C

Curing	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.

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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.

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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.

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