

Advanced Materials**RenGel[®] SV 412 / Ren[®] HY 2404**

GELCOAT RESIN
THIXOTROPIC, FILLED EPOXY SYSTEM

KEY PROPERTIES

- Easy to apply with brush or spatula
- Easily pigmented with Araldite[®] Colouring Pastes DW 0131 - DW 0137
- Tough, flexible films with good strength over sharp edges
- Can be machined and polished

APPLICATIONS

- Construction of foundry patterns
- Construction of jigs

PRODUCT DATA

| Property | Unit | RenGel [®] SV 412 | Ren [®] HY 2404 |
|-----------------------------------|-------------------|-------------------------------|------------------------------|
| Appearance Colour | visual | thixotropic paste white | transparent liquid yellow |
| Viscosity at 25°C ** (ISO2555) | mPa s | 10'000 - 15'000** | 3400 - 5000** |
| Density | g/cm ³ | 1.25 - 1.35 | 1.05 - 1.08 |

** Specified data are on a regular basis analysed. Data which is described in this document as 'typical' is not analysed on a regular basis and is given for information purpose only. Data values are not guaranteed or warranted unless if specifically mentioned.

TYPICAL SYSTEM DATA**PROCESSING**

| Mix ratio | Parts by weight |
|----------------------------|-----------------|
| RenGel [®] SV 412 | 100 |
| Ren [®] HY 2404 | 16 |

Mix the two components thoroughly in the ratio indicated.
Apply in thin layers with a brush or spatula, wait until gelcoat has gelled, but ensure that it is still slightly tacky before proceeding.
Post-curing will improve final properties.

PROPERTIES

| Resin/Hardener mix: | Volume | Unit | SV 412 HY 2404 |
|---------------------|--------|------|--------------------------|
| Appearance | | | white, thixotropic paste |
| Pot life at 25°C | 250 ml | min | 15-25 |
| Demoulding time | | h | 8 - 12 |

After cure: 7 days at RT or 14 hours at 40 °C

| | | | |
|------------------------|----------|-------------------|---------|
| Density | ISO 1183 | g/cm ³ | 1.3 |
| Hardness | ISO 868 | Shore D | 80 - 85 |
| Deflection temperature | ISO 75 | °C | 60 - 65 |
| Abrasion | Taber | mg/100u | 100-105 |

STORAGE

Provided that RenGel® SV 412 and Ren® HY 2404 are stored in a dry place in their original, properly closed containers at the storage temperatures mentioned in the MSDS they will have the shelf lives indicated on the labels. Partly emptied containers should be closed immediately after use.

**WORKING
CONDITION**

The products should be handled when in the temperature range of 20 - 25°C.

PACKAGING

| System | RenGel® SV 412 | Ren® HY 2404 |
|---------------------|----------------|--------------|
| Quantity and Weight | 2 x 6.25 kg | 6 x 1 kg |
| Quantity and Weight | | 6 x 50 g |

**HANDLING
PRECAUTIONS****Caution**

Our products are generally quite harmless to handle provided that certain precautions normally taken when handling chemicals are observed. The uncured materials must not, for instance, be allowed to come into contact with foodstuffs or food utensils, and measures should be taken to prevent the uncured materials from coming in contact with the skin, since people with particularly sensitive skin may be affected. The wearing of impervious rubber or plastic gloves will normally be necessary; likewise the use of eye protection. The skin should be thoroughly cleansed at the end of each working period by washing with soap and warm water. The use of solvents is to be avoided. Disposable paper - not cloth towels - should be used to dry the skin. Adequate ventilation of the working area is recommended. These precautions are described in greater detail in the Material Safety Data sheets for the individual products and should be referred to for fuller information.

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