

Advanced Materials**XD 4615 / Ren[®] HY 5212**

HIGH TEMPERATURE GELCOAT SYSTEM

KEY PROPERTIES

- High surface quality
- Heat resistance up to 150°C
- Highly polishable
- Excellent inter layer adhesion to epoxy infusion systems

APPLICATIONS

- Tools requiring heat resistance up to 150°C
- Large tooling like wind rotor blades and marine applications
- Gelcoat in combination with infusion process

PRODUCT DATA

Property	Unit	XD 4615	Ren [®] HY 5212
Appearance Colour	visual	Thixotropic paste Black	Liquid Light yellow
Density at 20°C (ISO 2811-2)	g/cm ³	1.15 - 1.25**	1.01

** 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
XD 4615	100
Ren [®] HY 5212	24

Mix the two components thoroughly in the ratio indicated until the mixture has a homogenous colour. Apply a thin layer by brush.

PROPERTIES

Resin/Hardener mix:	Volume	Unit	XD 4615 HY 5212
Appearance			Black
Pot life at 25°C	100 ml	min	80 - 90

After cure: 14 hours gradually to 150°C (in all cases the rate of heating and cooling should be gradual)

Density	ISO 1183	g/cm ³	1.25
Hardness	ISO 868	Shore D	85 - 90
Deflection temperature	ISO 75	°C	150
Coefficient of Thermal Expansion (CTE)	ISO 11359	10-6K-1	60
Flexural Strength	ISO 178	MPa	120 - 130
Flexural Modulus	ISO 178	MPa	3400 - 3450
Ulzimate Elongation	ISO 178	MPa	4.0 - 4.5

STORAGE

Provided that XD 4615 and Ren[®] HY 5212 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 CONDITIONS

The product should be used when in the temperature range 20° to 25°C.

PACKAGING

System	XD 4615	Ren[®] HY 5212
Quantity and Weight	2 x 5 kg	20 kg
Quantity and Weight		165 kg

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.

Huntsman Advanced Materials
(Switzerland) GmbH
Klybeckstrasse 200
4057 Basel
Switzerland

Tel: +41 (0)61 299 11 11
Fax: +41 (0)61 299 11 12

www.huntsman.com/advanced_materials
Email: advanced_materials@huntsman.com



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