

Advanced Materials**XD 4615 / Ren[®] HY 5159****GELCOAT
THIXOTROPIC EPOXY SYSTEM****KEY
PROPERTIES**

- High surface quality
- Resistance to polyester and polyurethane materials
- Heat resistance up to 120°C
- Highly polishable

APPLICATIONS

- Moulds for parts made from PUR
- Moulds for parts made from Polyester resins
- Vacuum forming/thermo forming tools

PRODUCT DATA

Property	Unit	XD 4615	Ren [®] HY 5159
Appearance Colour	visual	Thixotropic paste Black	Liquid Light yellow
Density	g/cm ³	1.25	1.01

PROCESSING

Mix ratio	Parts by weight
XD 4615	100
Ren [®] HY 5159	15

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 5159
Appearance			Black
Pot life at 25°C	250 ml	min	25-30

After cure: 14 hours gradually to 120°C (in all cases the rate of heating and cooling should be gradual)

Density	ISO 1183	g/cm ³	1.3
Hardness	ISO 868	Shore D	80 - 90
Deflection temperature	ISO 75	°C	120

STORAGE

The resin and hardeners described in this instruction sheet have the shelf lives shown, provided they are stored at 18 - 25°C in a dry place and in sealed containers, preferably those in which they are supplied.

WORKING CONDITIONS

Normal workshop conditions.

PACKAGING

System	XD 4615	HY 5159
Quantity and Weight	1 x 5kg	6 x 0.8kg
Quantity and Weight	6 x 250gr	6 x 40gr

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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