

**Advanced Materials****XD 4615 / Ren<sup>®</sup> 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 <sup>®</sup> HY 5159
Appearance Colour	visual	Thixotropic paste Black	Liquid Light yellow
Density at 20 °C (ISO 2811-2)	g/cm <sup>3</sup>	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 DATAS****PROCESSING**

Mix ratio	Parts by weight
XD 4615	100
Ren <sup>®</sup> 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**

<b>Resin/Hardener mix:</b>	<b>Volume</b>	<b>Unit</b>	<b>XD 4615 HY 5159</b>
<b>Appearance</b>			Black
<b>Pot life at 25°C</b>	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)**

<b>Density</b>	<b>ISO 1183</b>	g/cm <sup>3</sup>	1.2
<b>Hardness</b>	<b>ISO 868</b>	Shore D	80 - 90
<b>Deflection temperature</b>	<b>ISO 75</b>	°C	120

**STORAGE**

Provided that XD 4615 and Ren<sup>®</sup> HY 5159 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**

Normal workshop conditions.

**PACKAGING**

<b>System</b>	<b>XD 4615</b>	<b>HY 5159</b>
<b>Quantity and Weight</b>	2 x 5 kg	6 x 0.8 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.

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XD4615 HY5159

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