

Main features

- hard
- abrasion-resistant
- difficult to machine
- heat-resistant

Applications

- tool manufacture in the face casting
- vacuum deep-drawing moulds
- foaming moulds
- foundry facilities

Properties in the non-crosslinked state (approx. values)

				NEUKADUR VG	NEUKADUR Hardener VG
Colour				black	amber
Density 20 °C	g/cm ³			2.9	0.95
Viscosity 20°C	mPas			250.000	200

Properties of the mixture (approx. values)

Mixing ratio	p.b.w			100	5
Mixed viscosity	mPas				30,000
Pot life	(1000g) Minutes				100
Curing time	Hours				14 - 24
Density	g/cm ³				2,8
Hardness	Shore D				87
Heat resistance	Martens °C				90 - 95
Tensile strength	N/mm ²				45 - 50
Elongation at break	%				0.3 – 0.4
Modulus in tension	N/mm ²				9.800
Compressive strength	N/mm ²				155
Ball indentation hardness 30"	N/mm ²				290
Thermal conductivity	W/K • m				0.6 – 0.7
Coefficient of linear thermal expansion	10 ⁻⁶ K ⁻¹				35 - 40
linear shrinkage	mm/m				0.1

How to process the material

Before every use, stir up the resin component thoroughly as otherwise the fillers might deposit. Mix in the hardener component with care but intensively to ensure an optimal wetting and to prevent air inclusions. We recommend to let the mixed casting resin compound rest for 10 to 15 minutes before casting it in order to allow the possibly incorporated air to escape. The pot life depends on the temperature and batch sized involved.

Form of delivery

NEUKADUR VG	10 kg
NEUKADUR Hardener VG	0.5 kg

Storage

The material should be kept in tightly closed original receptacles at temperatures of 15 - 25 °C. When duly stored, the materials can be used within the shelf life indicated on the labels.

Measure of precaution

Users should make use of the current safety data sheets, which contain physical, ecological, toxicological and other data relating to safety, to inform themselves on the safe handling and storage of products.
