

NEUKADUR VG 3
Epoxy Casting Compound
Metal-filled

altropol

Main features

- hard
- abrasion-resistant
- machinable
- solid edges

Applications

- tool and gauge manufacture
- metal pressing tools
- Deep-drawing and swagers
- Foundry facilities and moulds

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

				NEUKADUR VG 3	NEUKADUR Hardener VG 3
Colour				black	amber
Density 20 °C	g/cm ³			2.7	0.95
Viscosity 20°C	mPas			150,000	4,000

Properties of the mixture (approx. values)

Mixing ratio	p.b.w.			100	20
Mixed viscosity	mPas				17,000
Pot life	(1000g) Minutes				130
Curing time	Hours				20 - 26
Density	g/cm ³				2.4
Hardness	Shore D				80
Heat resistance	Martens °C				50
Tensile strength	N/mm ²				75 - 80
Elongation at break	%				0.7 – 0.8
Modulus in tension	N/mm ²				6,500
Compressive strength	N/mm ²				80 - 90
Ball indentation hardness “	N/mm ²				160 - 170
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 before adding the hardener as otherwise the fillers might deposit. The fillers, however, can be stirred up well in any case. After having added and mixed the hardener with the resin, let the reaction compound still rest for 5 to 15 minutes prior to casting to allow the possibly enclosed air to escape.

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When it deals with moulding fine contours, we recommend applying a first coat of the casting/hardener compound by means of a short-bristled paint brush before filling the mould. Always pour the casting compound slowly into the deepest point of the mould. By pouring out the compound evenly, you can prevent air inclusions. In one operation, the following layer thicknesses can be cast:

- in case of metallic substrates with a good heat removal (z.B. face casting on metal cores): 20 - 25 mm
- in case of substrates with a less heat removal: max. 15 mm

Form of delivery

NEUKADUR VG 3	12 kg
NEUKADUR Hardener VG 3	2.4 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.