

**Main features**

- hard
- machinable
- medium viscous

**Applications**

- Production of small patterns in the full casting
- universally usable back casting compound

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

		<b>NEUKADUR VG F</b>	<b>NEUKADUR Hardener VG F</b>	<b>NEUKADUR Hardener 179</b>
Colour		black	amber	amber
Density 20 °C	g/cm <sup>3</sup>	1.7	0.95	0.95
Viscosity 20°C	mPas	15,000	200	170

**Properties of the mixture (approx. values)**

Mixing ratio	p.b.w.	100	10	10
Mixed viscosity	mPas		6,000	5,000
Pot life	(100g) Minutes		160 - 180	160 - 180
Pot life	(1000g) Minutes		90	120
Curing time	Hours		14 – 20	20 - 24
Hardness	Shore D		83	83
Heat resistance	Martens °C		50	50
Tensile strength	N/mm <sup>2</sup>		45 – 50	45 - 50
Elongation at break	%		0.5 – 0.6	0.5 – 0.6
Modulus in tension	N/mm <sup>2</sup>		10,000	10,000
Flexural strength	N/mm <sup>2</sup>		75	75
Compressive strength	N/mm <sup>2</sup>		110	110
Bll indentation hardness	N/mm <sup>2</sup>		185	185
Impact strength	kJ/m <sup>2</sup>		3.5	3.5
Thermal conductivity	W/K • m		0,4 – 0,5	0,4 – 0,5
Coefficient of linear Thermal expansion	10 <sup>-6</sup> K <sup>-1</sup>		30 – 36	30 - 36
linear shrinkage	mm/m		0.3	0.3

**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.

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**Form of delivery**

NEUKADUR VG F	10 kg and 1 kg
NEUKADUR Hardener VG F	1 kg and 100 g
NEUKADUR Hardener 179	1 kg and 100 g

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**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.

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**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.

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