

NEUKADUR VG 3

Epoxy Casting Compound
Metal-filled

altropol

Main features

- hard
- abrasion-resistant
- workable
- solid edges

Applications

- tool and gauge manufacture
- metal pressing tools
- thermoforming moulds and stretch-forming moulds
- foundry facilities and patterns

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

		NEUKADUR VG 3	NEUKADUR Hardener VG 3
Colour		black	amber
Mixing ratio	p.b.w.	100	20
Density (20 °C)	g/cm ³	2.7	0.95
Viscosity (20 °C)	mPa·s	150,000	4,000

Properties of the mixture (approx. values)

Mixed viscosity (25 °C)	mPa·s		17,000
Pot life (RT) (100 g)	minutes		130
Curing time	hours		24
Density	g/cm ³	DIN 53479	2.4
Hardness	Shore D	DIN 53505	80

Mechanical values of the cured product (approx. values)

Dimensional stability under heat	Martens °C	DIN 53458	50
Tensile strength	N/mm ²	DIN 53455	80
Elongation at break	%	DIN 53455	0.8
Modulus in tension	N/mm ²	DIN 53457	6,500
Compressive strength	N/mm ²	DIN 53454	90
Ball indentation hardness 30"	N/mm ²	DIN 53456	170
Thermal conductivity	W/K • m	DIN 52612	0.6
Coefficient of linear thermal expansion	10 ⁻⁶ K ⁻¹	VDE	38
Linear dimensional change	mm/m		0.1

*RT = room temperature

How to process the material

Prior to use, stir up the resin component thoroughly before adding the hardener as the fillers may deposit in case of a longer storage. The fillers can however always be stirred up easily. After having added and mixed the hardener with the resin, let the reaction compound still rest for 5 - 15 minutes prior to casting. This is to allow the enclosed air to escape.

As far as fine contours shall be cast, we recommend applying a first coat of casting resin/hardener compound by means of a short-haired brush prior to casting. Always pour the casting resin slowly into the deepest point of the mould. By and even casting, you can avoid air inclusions. In one operation, you can cast the following layer thicknesses:

- When the substrate is metallic and has a good heat removal (e.g. face casting on metal cores): 20 - 25 mm
- When the substrate is less heat-dissipating: max. 15 mm

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Form of delivery

NEUKADUR VG 3	1 kg	12 kg
NEUKADUR Hardener VG 3	0,2 kg	2,4 kg

Storage

We recommend keeping the material in tightly closed original receptacles at temperatures of 20 - 25 °C. When duly stored, the material can be used within the shelf life indicated on the labels (the first 2 digits of the batch number indicate the week, the 3rd digit indicates the year).

Measure of precaution

With the aid of the current safety data sheets, which contain physical, ecological, toxicological and other data relating to safety, the user can inform himself on the safe handling and storage of the products.

Our technical service - in words, in writing or by trials - is given according to the current state of our knowledge. It does however not relieve the customer/user from the duty to check by himself if the products supplied by us are suitable for the intended processes and purposes. Application, use and processing of the products take place beyond our control possibilities and lie therefore exclusively in the area of responsibility of the processor. Any existing property rights of third parties are to be considered. We guarantee the perfect quality of our products in accordance with our general terms and conditions of business. When handling our products you have to observe the legal rules and the rules for the industrial hygiene. As for the rest, we refer to the corresponding safety data sheets.

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