

## Main features

- transparent
- high brilliance
- UV-stable
- quick drying
- excellent body
- grindable and polishable

## Applications

- coating of CFRP and GFRP component parts by the IMC (in-mould coating) -process
- spray coating (brushing and rolling are also possible)

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

		NEUKADUR IMC Varnish	NEUKADUR IMC Hardener	NEUKADUR IMC Diluent
Colour		colourless	colourless	colourless
Mixing ratio	p.b.w.	100	50	30
Density (20 °C)	g/cm <sup>3</sup>	1.0	1.0	1.0
Viscosity (20 °C, DIN 53211)	4 mm/sec	40	13	

## Properties of the mixture at 20 °C (approx. values)

Density	g/cm <sup>3</sup>	DIN 53479	1.00
Temperature stability	°C		120
Pot life at 65% rel. humidity of air	minutes		120
Pot life at 95% rel. humidity of air	minutes		60

## How to process the material

**Please do not use any semipermanent release agents having an elevated surface tension!**  
**(Avoidance of so-called fish-eyes)**

The substrate has to be dry and free from oil and grease.

Applicable with all conventional release agents based on wax as for example NEUKADUR release wax TW or NEUKADUR release agent SE New.

For release agents, please visit our homepage under <http://www.altropol.de/en/produkte/weitere-produkte/trennmittel>

Use as in-mould coating: **without** diluent

Use as varnish: **with** diluent

Processing temperature: between + 15 °C and + 25 °C

Application: spraying (air); nozzle: approx. 1.3 - 1.8 mm; pressure: approx. 3 bars

- Spray 1 to 2 times on the flow
- Intermediate evaporation for 10 to 15 minutes
- Apply 1 to 2 thick layers by spraying
- Before oven drying, let evaporate for at least 30 minutes at room temperature.

Theoretical spreading capacity at approx. 40 µm: approx. 11.25 m<sup>2</sup>/kg (approx. 90 g/m<sup>2</sup>)

## Use as in-mould casting

The material can be laminated and/or draped after approx. 60 minutes at 65 °C or after 6 hours at 23 °C. If you exceed the period of approx. 6 hours, you should treat the surface with an abrasive pad beforehand.

## Use as clear varnish

Grind between two or several varnish layers by means of abrasive paper, grain size 220 to 320.

The final layer can be polished. Beginn with a grain size of 800 and end with 1200.

## **Form of delivery**

NEUKADUR IMC Varnish	0,25 l	1 l	5 l
NEUKADUR IMC Hardener	0,125 l	0,5 l	2,5 l
NEUKADUR IMC Diluent	0,3 l		1 l

## **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 label (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.

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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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