HUNTSMAN

Enriching lives through innovation

Advanced Materials

RenGel© SW 404 / Ren© HY 2404 or HY 5159

GELCOAT RESIN
FILLED EPOXY SYSTEM, WITH OUTSTANDING ABRASION RESISTANCE

KEY PROPERTIES

- **Outstanding mechanical strength and qualities**
- **Good chemical resistance**
- **Very hard, abrasion-resistant surfaces**

APPLICATIONS

- Foundry patterns
- Copy-milling models
- Foaming and concrete-casting moulds
- Tools and tooling aids

PRODUCT DATA

Property	Unit	RenGel© SW 404	Ren© HY 2404	Ren© HY 5159
Appearance Colour	visual	Paste Blue	Clear liquid Pale yellow	Clear liquid Pale yellow
Viscosity at 25ºC	mPas	55,000-80,000	3,500-5,500	150-250
Density	g/cm^3	1.85-1.95	1.0-1.05	0.98

PROCESSING

Mix ratio	Parts by weight	
RenGel© SW 404	100	100
Ren© HY 2404	10	-
Ren© HY 5159	-	8

Mix the two components thoroughly in the ratio indicated.
Apply in thin layers with a brush or spatula, wait until gelcoat has gelled, but ensure that it is still slightly tacky before proceeding.
Post-curing will improve final properties.

PROPERTIES

Resin/Hardener mix:	Volume	Unit	SW 404 HY 2404	SW 404 HY 5159
Appearance			Blue	Blue
Pot life at 25ºC	**250 ml**	min	15	50
Demoulding time		h	12	12

After cure: with HY 2404: 14 hours at 60°C
with HY 5159: 14 hours gradually to 80°C

Density	**ISO 1183**	g/cm^3	1.8	1.8
Hardness	**ISO 868**	Shore D	85-90	85-90
Deflection temperature	**ISO 75**	°C	80	100
Abrasion	**Taber**	mm^3/100U	4-6	4-6

STORAGE

The resin and hardeners described in this instruction sheet have the shelf lives shown provided they are stored at 6 - 28ºC in a dry place and sealed containers, preferably those in which they are supplied.

WORKING CONDITION

The products should be handled when in the temperature range of 20 - 25°C.

PACKAGING

System	SW 404	HY 2404	HY 5159
Quantity and Weight	2 x 10kg	6 x 1kg	6 x .800gr
Quantity and Weight	2 x 3kg	6 x 300gr	6 x 240gr
Quantity and Weight	6 x 500gr	6 x 50gr	6 x 40gr

HANDLING PRECAUTIONS

Caution

Our products are generally quite harmless to handle provided that certain precautions normally taken when handling chemicals are observed. The uncured materials must not, for instance, be allowed to come into contact with foodstuffs or food utensils, and measures should be taken to prevent the uncured materials from coming in contact with the skin, since people with particularly sensitive skin may be affected. The wearing of impervious rubber or plastic gloves will normally be necessary; likewise the use of eye protection. The skin should be thoroughly cleansed at the end of each working period by washing with soap and warm water. The use of solvents is to be avoided. Disposable paper - not cloth towels - should be used to dry the skin. Adequate ventilation of the working area is recommended. These precautions are described in greater detail in the Material Safety Data sheets for the individual products and should be referred to for fuller information.

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