

**Advanced Materials****RenGel<sup>®</sup> SW 419 / Ren<sup>®</sup> HV 2419**GELCOAT RESIN  
METAL-FILLED, BLACK EPOXY SYSTEM**KEY  
PROPERTIES**

- **Abrasion resistant**
- **Non-draining on vertical surfaces**
- **Low sedimentation**
- **Hard, but easy-to-machine surfaces**

**APPLICATIONS**

- Sheet metal forming tools
- Foundry patterns
- General pattern making applications

**PRODUCT DATA**

Property	Unit	RenGel <sup>®</sup> SW 419-1	Ren <sup>®</sup> HV 2419
Appearance Colour	visual	Paste Black	Transparent paste Yellow
Viscosity at 25°C (ISO 2555)	mPa s	100'000 - 280'000**	3400 - 5000**
Density	g/cm <sup>3</sup>	2.8	1.0

\*\* Specified data are on a regular basis analysed. Data which is described in this document as 'typical' is not analysed on a regular basis and is given for information purpose only. Data values are not guaranteed or warranted unless if specifically mentioned.

**TYPICAL SYSTEM DATAS****PROCESSING**

Mix ratio	Parts by weight
RenGel <sup>®</sup> SW 419-1	100
Ren <sup>®</sup> HV 2419	13

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 419-1 HV 2419
Appearance			Black
Pot life at 25°C	250 ml	min	15-20
Demoulding time		h	12

*After cure: 7 days RT / 14 hours at 40°C*

Density	ISO 1183	g/cm <sup>3</sup>	2.3
Hardness	ISO 868	Shore D	85-90
Deflection temperature	ISO 75	°C	60-70
Abrasion	Taber	mm <sup>3</sup> /100U	45-50

**STORAGE**

Provided that RenGel<sup>®</sup> SW 419 and Ren<sup>®</sup> HV 2419 are stored in a dry place in their original, properly closed containers at the storage temperatures mentioned in the MSDS they will have the shelf lives indicated on the labels. Partly emptied containers should be closed immediately after use.

**WORKING  
CONDITION**

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

**PACKAGING**

System	SW 419-1	HV 2419
Quantity and Weight	2 x 13.5kg	2 x 1.8kg
Quantity and Weight	6 x 500gr	6 x 65gr

**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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