

Product Data



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R-0537 VINYL ESTER HYBRID TOOLING RESIN

R-0537 VE Hybrid Tooling Resin combines the toughness, chemical resistance and high heat distortion temperature typical of the B-3030 & B-3040 Tooling Gel Coats with a low laminate exothermic temperature and low shrink characteristics. These properties provide this special tooling resin with the qualities required giving the FRP tool constructed from this resin a long, useful life.

TYPICAL PROPERTIES OF R-0537

Weight/Gallon, 77°F:	8.89 Pounds
Specific Gravity:	1.07
Viscosity, Brookfield, 77°F	
@ 6 rpm:	1400-1800 cp.
@ 60 rpm:	500-800 cp.
Acid Value:	< 10
Gel Time, 1.0% TBPB, and 77°F.	
100-Gram mass:	30-35 minutes
1/8" thick Laminate:	8-12 minutes
Barcol Hardness Development	
In 1/8" thick Laminate	
Time after Gel:	
2 Hours:	10-20
4 Hours:	30-40
24 Hours:	50+
Shelf Life Uncatalyzed:	2 Months minimum

1/8" THICK CLEAR CASTING

		<u>Test Method</u>
Barcol Hardness:	50-55	----
Heat Distortion Temp (264 psi):	200+°C.	ASTM D-648

CATALYZATION AND APPLICATION

Proper catalyzation is important to the cure of any good laminating resin. R-0537 Tooling Resin is formulated to provide a rapid gel and cure time at a nominal 2% tertiary-Butyl Peroxybenzoate. The tooling resin and catalyst should be mixed thoroughly and then carefully applied by spraying, brushing or rolling along with chopped fiberglass strands directly behind the properly applied and cured gel coat film. Instructions for the proper application of a laminate can be found in Technical Bulletin HKR055. Extreme care must be taken to assure that the glass reinforcement is thoroughly wet with resin and all entrapped air is worked out of the laminate.

Do not use standard MEKP Catalyst with this system.

SAFETY CONSIDERATIONS

HK Research's VE Hybrid Tooling Resins are based on a resin that contains styrene monomer, which is a flammable liquid. Keep away from sparks, heat and open flame (including pilot lights). Electrical equipment should be vapor-proof and protected from breakage.

Styrene vapors are heavier than air and will tend to concentrate in the low areas of molds and in pockets immediately above the floor area. To keep vapors within a safe limit in all areas, adequate ventilation or suction fans should be used that will remove these styrene monomer vapors.

All equipment must be grounded - including spray guns and molds.

Both the polyester gel coat and the catalyst may cause burns to eyes and skin. Do not get in the eyes! Avoid breathing vapors! Gel coat applicators should wear a NIOSH approved respirator effective for vapors, spray mist and dust. In case of accidental contact, remove contaminated clothing and wash affected skin areas with soap and copious quantities of water. Contact a physician if persistent skin irritation occurs. For eyes, immediately flush with plenty of water for at least 15 minutes; call a physician immediately. Wash contaminated clothing before reusing.