

Technical Data Sheet

Viapal UP 935 BE

CHARACTERISTICS

Polyester resin - VIAPAL UP 935 BE, a submerged resin accelerated thixotropic

HOW TO USE

The polyester resin is ideally suited for the production of fine coatings for GF-UP molds.

CHARACTERISTICS

Features in delivery condition

Features		Unit	Test Method
Density at 20°C	1,12	g/cm ³	DIN EN ISO 2811-2
Flash point	approx. 34	°C	DIN EN ISO 1523
Storage stability at max. 25°C protected from light	6	Months	
Gelling time at 20°C with 2%	18-25	Min.	DIN16945/6.3.1.2

Properties in the cured state*

Features		Unit	Test Method
Barcol hardness (934-1)	31-35		DIN EN59
Tensile strength	70	N/mm ²	DIN EN ISO 527
Elongation at break	4	%	DIN EN ISO 527
Flexural strength	130	N/mm ²	DIN EN ISO 178
Modulus of elasticity from bending test	2500	N/mm ²	DIN EN ISO 178
Glass transition temperature	94	°C	DIN EN 61006

Processing

Mixing ratio	100 parts resin / 1.5-2 parts hardener (volume or weight)	at 20°C
Processing Time	18-25 min.	
Demouldable	24h	
Final	48h	
Overlaminatable	12h	
Processing Temperature	18-25°C	

Homogenize the product well before removal. Apply gelcoat with a brush. The brush must be completely dry before starting work (must not contain solvents). To achieve an even surface, it makes sense to coat twice, whereby the first one is allowed to harden up to the finger test. The finger test is achieved when no gelcoat sticks to the finger after dabbing, although the surface may still be sticky. Recommended application quantity: 500-850g/m² for a gelcoat layer thickness of 0.4-0.7 mm (in the hardened state). As soon as the gelcoat layer has hardened, lamination should begin. However, no later than 3 hours after adding the peroxide (MEKP hardener) to the gelcoat, lamination must be started to prevent the pre-release effect and reduced laminate adhesion.

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Post-curing

In order to achieve better properties of the molded parts during curing, thermal post-treatment is required depending on temperature and time. Molded parts should be hardened for 24 hours at 20°C and another 2 hours at 70°C.

Storage

Only close opened containers tightly with the original lid. Store in a cool, dry place. With optimal storage, shelf life of at least 6 months.

Work Equipment Cleaning

Hardened resins can only be cleaned mechanically, such as by grinding! Acetone can be used to remove non-hardened resin residues from the tool, which must then air out sufficiently to prevent the cleaner from entering new containers!

Precautions

When processing unsaturated polyester resins, the information in the safety data sheet must be observed!

More information

If you have any further questions, for example about the processing or the product, please do not hesitate to contact us by phone.

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