

(Also known in Europe as GH 754 Resin + Hardener)

Basis	Temperature resistant casting resin
Resin	VF 2000
Hardener	VF 2000
Colour	alu grey

## Applications

- Vacuum forming tools
- PU-foaming tools
- RIM foam tools
- Casting mould for thermoplastic
- Heatable foundry patterns

## Properties

- heat resistant
- very thick castable
- well workable
- aluminium-like

## Processing data

Product		Mixture VF 2000 Resin + Hardener	Resin VF 2000	Hardener VF 2000
Colour		alu grey	alu grey	yellow
<b>Mixing ratio</b>	<b>p. b. w.</b>		<b>100</b>	<b>7</b>
Viscosity at 25°C	mPas	11000 ± 2000	35000 ± 5000	70 ± 15
Density at 20°C	g / cm <sup>3</sup>	1,75 ± 0,05	1,95 ± 0,05	1,00 ± 0,02
Pot life 200 g / 20°C	min.	100 - 120	-	-
Curing time at RT	hrs.	18 - 24	-	-
Post curing	Time in h/ Temperature in °C	12 - 15 / 80 - 100	-	-

## Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	100 ± 10
Flexural modulus	EN ISO 178	MPa	8850 ± 800
Flexural strength at breakage	EN ISO 178	%	1,6 ± 0,2
Compressive strength	EN ISO 604	MPa	120 ± 10
Impact resistance (Charpy)	EN ISO 179	kJ/m <sup>2</sup>	11 ± 3
Heat resistance (HDT)	DIN EN ISO 75 B	°C	101 ± 3
Shore hardness	DIN 53505	Shore D	89 ± 3
Coefficient of linear expansion	DIN 53752	10 <sup>-6</sup> K <sup>-1</sup>	ca. 47 - 50

## Sales units (packages)

Units	Resin / Hardener	VF 2000	5 kg , 10 kg, 15 kg Supplied in ratio matched kits
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## Processing instructions

The temperature of material and processing should be between 18 and 25° C.

Filled systems should be stirred thoroughly before use.

After each use the containers have to be closed again.

Porous mould surfaces should be sealed before ( **ebalta** sealant ).

For an optimum mould release we recommend a suitable release agent (e.g. T 1-1) which can be easily applied with a brush.

The mould should be treated 2 or 3 times with release agent and allowed to evaporate for approx. 20 min after every application.

Mixing ratio resin/hardener according to instructions!

To get a clean component part , we recommend upward flow casting and to take care of sufficient venting.

Resin residues at stirring rods and so on can be easily cleaned with our cleaning agent.

## In General

**ebalta** VF 2000 is a very thick -castable aluminium-filled heat resistant two-components epoxy resin, which shows aluminium-like properties after curing at room temperature.

Due to its high aluminium content, VF 2000 has a good thermal conductivity, is well workable and has a low thermal expansion coefficient. Castable thickness of more than 50 mm. By adding massive round aluminium granules even stronger thicknesses can be casted.

After curing at room temperature, for thin wall thicknesses the maximum thermal stability is reached by thermal treatment for about 12-15 hrs. at 80-100°C .

Thermal treatment can also be made by slow heating-up to working temperature.

Due to arising heat of reaction, for thicknesses of more than 80 mm, no postcuring necessary to reach the mentioned mechanical and thermal values.

## Storing

Storage at room temperature (18-25 °C) in closed original container 9 months.

Already opened containers should be closed immediately after use and should be used as soon as possible.

## Safety measure

Please follow the precaution instructions of the Government Safety Organisation of the chemical industry when working with this material. Please follow safety advices !

## Waste Disposal

According to arrangement with local authorities cured material can be disposed as domestic or commercial waste.

Non-cured products are waste which is subject to inspection and has to be disposed accordingly.

In case of further questions please do not hesitate to contact our Department for Product Safety.

The instructions and recommendations are given in good faith and are based on long experience and careful tests. Since the conditions of use are beyond our control, and due to versatility of applications and working methods, we can't give any guarantee. All information are non-binding and are no guarantee for special characteristics or properties of the product. Despite information given from **ebalta** the customer has to make his own tests regarding applications and processing. If any special warranty is requested, written agreement on this subject is essential.

**ebalta** UK Limited . B2 Langham Park, Trent Lane . Castle Donington . Derbyshire DE74 2UT  
t: +44 1332 814700 . f: +44 1332 814775 . e: info@**ebalta**.co.uk . w: www.**ebalta**.co.uk