

**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	mPa s	160,000 -360,000	-
Density	g/cm <sup>3</sup>	2.8	1.0

**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**

The resin and hardeners described in this instruction sheet have the shelf lives shown provided they are stored at 6 - 28°C 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 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.

---

**IMPORTANT LEGAL NOTICE**

Huntsman Advanced Materials warrants only that its products meet the specifications agreed with the user. Typical properties, where stated, are to be considered as representative of current production and should not be treated as specifications.

The manufacture of materials is the subject of granted patents and patent applications; freedom to operate patented processes is not implied by this publication.

While all the information and recommendations in this publication are, to the best of Huntsman Advanced Material's knowledge, information and belief, accurate at the date of publication, NOTHING HEREIN IS TO BE CONSTRUED AS A WARRANTY, WHETHER EXPRESS OR IMPLIED, INCLUDING BUT WITHOUT LIMITATION, AS TO MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. IN ALL CASES, IT IS THE RESPONSIBILITY OF THE USER TO DETERMINE THE APPLICABILITY OF SUCH INFORMATION AND RECOMMENDATIONS AND THE SUITABILITY OF ANY PRODUCT FOR ITS OWN PARTICULAR PURPOSE.

The behaviour of the products referred to in this publication in manufacturing processes and their suitability in any given end-use environment are dependent upon various conditions such as chemical compatibility, temperature, and other variables, which are not known to Huntsman Advanced Materials. It is the responsibility of the user to evaluate the manufacturing circumstances and the final product under actual end-use requirements and to adequately advise and warn purchasers and users thereof.

Products may be toxic and require special precautions in handling. The user should obtain Safety Data Sheets from Huntsman Advanced Materials containing detailed information on toxicity, together with proper shipping, handling and storage procedures, and should comply with all applicable safety and environmental standards.

Hazards, toxicity and behaviour of the products may differ when used with other materials and are dependent on manufacturing circumstances or other processes. Such hazards, toxicity and behaviour should be determined by the user and made known to handlers, processors and end users.

Except where explicitly agreed otherwise, the sale of products referred to in this publication is subject to the general terms and conditions of sale of Huntsman Advanced Materials LLC or of its affiliated companies including without limitation, Huntsman Advanced Materials (Europe) BVBA, Huntsman Advanced Materials Americas Inc., and Huntsman Advanced Materials (Hong Kong) Ltd.

Huntsman Advanced Materials is an international business unit of Huntsman Corporation. Huntsman Advanced Materials trades through Huntsman affiliated companies in different countries including but not limited to Huntsman Advanced Materials LLC in the USA and Huntsman Advanced Materials (Europe) BVBA in Europe.

Ren and RenGel are registered trademarks of Huntsman Corporation or an affiliate thereof.

Copyright © 2007 Huntsman Corporation or an affiliate thereof. All rights reserved.

Main Office :  
**Huntsman Advanced Materials (Switzerland) GmbH**  
Klybeckstrasse 200  
CH-4057 BASEL  
Switzerland  
+41 61 966 3333