
Technical data sheet**SW 404 Gel Coat / XB 5173 Hardener****A high temperature gel coat or face casting material with high wear and chemical resistance.**

Key properties

- Easy to apply with brush or by pouring for face casting.
- Very hard abrasion resistant surface.
- Very high chemical resistance.
- Suitable for face casting to 12mm thickness.
- High temperature resistance.

Applications

- Foundry Patterns.
- Foaming and concrete casting moulds.
- Applications where low water absorption is important.

Typical product data

Product	Appearance	Viscosity at 25 °C (mPa s)	Density at 25 °C (g/cm ³)	Shelf life* at 18 - 25 °C (years)
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Gel Coat : -

SW 404	Blue	60,000	1.9	1
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Hardener : -

XB 5173	Pale yellow liquid	10 - 40	0.92	1
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Processing method

The gel coat and hardener should be mixed thoroughly. Care should be taken to avoid trapping air when applying the gel coat mix. One thin even layer of gel coat mix is recommended (0.5mm) followed by a second similar layer. This can be backed with either a laminating, casting or compound system, once the applied gel coat layer has reached a gelled, but not hard stage of cure.

Processing

Mix ratio (parts by weight)	
SW 404	100
XB 5173	9

After mixing (at 23 °C)		
Appearance	Visual	Blue
Mix viscosity	mPas @ 23°C	5000
Tack time 0.5mm layer	min @ 23°C	200
Pot life (250g)	min @ 23°C	150
Demouldable	hours @ 40°C	24
Maximum face casting thickness	mm	12

Typical Properties

Post cure Schedule :-			8
hours at 60°C+2h @ 80°C+2h @ 100°C+2h @ 120°C+ 2h @ 140°C			
Hardness	ISO 868 Shore D		90
Density	g/cm ³		1.8
Coefficient linear thermal expansion	10-6K-1		45 - 50
Compressive Strength	ISO 604 Mpa.		179
E-Modulus	ISO 604		7200
Heat deflection temperature	ISO 75 °C		150

Handling precautions

Caution

Huntsman 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 Huntsman publication No. 24264/3/e Hygienic precautions for handling plastics products of Huntsman and in the Huntsman Material Safety Data sheets for the individual products. These publications are available on request and should be referred to for fuller information.

Huntsman limited Adhesives and Tooling

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