

TECHNIREZ R2529 is a solvent free, thixotropic epoxy resin specifically designed for use with H2429 hardener that will cure at ambient temperature for tooling and pattern making applications.

R2529 and H2429 is used when an abrasion-resistant thixotropic gelcoat is required.

**MIX RATIO**

10 parts H2429 hardener to 100 parts resin by weight

*Note: Care should be taken when dispensing and mixing. Do not attempt to control the cure time by altering the hardener ratio. Contact ATL Composites for specific information.*

UNCURED PROPERTIES		
	R2529	H2429
Physical State	Blue thixotropic paste	Amber low viscosity liquid
Viscosity mPas@25°C	250,000-300,000	3000-5000
Specific Gravity g/ml@25°C	1.6-1.8	1.06-1.07

CURE CHARACTERISTICS	
	H2429
Pot Life - 100g @25°C (in air)	10-15 minutes
Demold Time	8 hours
Mix viscosity mPas@25°C	96,000
Shore D Hardness	88
HDT 7 days@25°C	60-65°C

**COVERAGE**

A film build 1mm thick will require the application of 1.7 kg of resin R2529/H2429 mixture per square metre.

**APPLICATION**

The resin and hardener must be accurately measured, and mixed carefully to avoid air entrapment.

Apply TECHNIREZ gelcoat with a short bristle paint brush to a thickness of 1.5mm or as specified on the tool making drawing. Work coating into sharp corners to ensure that no air is entrapped.

Sharp corners should be filleted with a mixture of TECHNIREZ R2517 resin and H2431 hardener and WEST SYSTEM® 413 Microfibre Blend.

Apply a coupling layer of TECHNIREZ R2517 resin and H2431 hardener to the firm gelcoat, before proceeding with the laminating or casting phase.

**MOULD PREPARATION AND RELEASE COMPOUNDS**

Metal and plastic surfaces do not require sealing, but gypsum, cement, wood and plaster surfaces should be coated with lacquer before applying polyvinyl alcohol film. PVA is soluble in water - a wet or damp gypsum, or plaster, mould may prevent the film from thoroughly drying. Lacquer serves as a moisture barrier.

Before applying the PVA, wax the lacquered surface to assist the removal of the epoxy casting from the mould.

**PACK SIZES**

Order Code		Order Code	
Resin		Hardener	
RC 2529	5kg	HC 2429	0.5 kg
RD 2529	25 kg	HD 2429	2.5 kg

**STORAGE**

TECHNIREZ R2529 resin and H2429 hardener will keep for 2 years if kept in original containers at room temperature (15°C to 32°C), and out of direct sunlight. Containers should be tightly sealed to prevent moisture absorption.

**HEALTH AND SAFETY**

TECHNIREZ R2529 resin and H2429 hardener have moderate sensitising potential, and should be kept out of the eyes and off the skin.

- Use with good ventilation and adequate safety equipment including impervious gloves and safety glasses.
- If skin contact occurs, remove contaminated clothing immediately, and wash the affected area thoroughly with water, avoiding the use of solvents except in the case of massive contamination.
- If eye contact occurs, immediately flush with running water for at least 15 (fifteen) minutes and seek medical advice.
- If swallowed:  
**Resins** - DO NOT induce vomiting, and contact a doctor or the Poisons Information Centre.  
**Hardeners** - DO NOT induce vomiting, give plenty of milk or water and contact a doctor or the Poisons Information Centre.

NOTE Our products are intended for sale to industrial and commercial customers. We request that customers inspect and test our products before use and satisfy themselves as to contents and suitability. Nothing herein shall constitute a warranty, express or implied, including any warranty or merchantability or fitness, nor is protection from law or patent to be inferred. All patent rights are reserved. The exclusive remedy for all proven claims is replacement of our materials and in no event shall we be liable for special or consequential damages. 13.07.18

