Technical Data Sheet

Gelcoat Plus

BÜFA® PROTECTION LAYER-LEO-R - 6500

FR Protective Layer, brushing quality Prod. No. 714-6500

Product description

BÜFA® Protection Layer LEO-R 6500 is an unaccelerated, pigmented, protective layer in a brushing consistence. The resin is halogen-free and based on a VE resin dissolved in styrene. Thanks to a precisely coordinated combination of special flame retarding additives, outstanding fire protection properties are achieved with this protective layer. BÜFA® Protection Layer LEO-R 6500 is a protective layer that reliably protects the VE-FR resin behind the laminates from flames. This product is a component in the **LEO Rail System**.

We recommend using BÜFA® Protection Layer LEO-R 6500 only in a system with BÜFA® Injection Resin LEO- 6500 and Saertex Reinforcement LEO-R to best utilise the synergies of products that are coordinated to each other.

Applications

BÜFA® Protection Layer LEO-R 6500 was especially developed for use in rail vehicle construction. The components are ideally produced in an injection process and have not only excellent fire protection properties but also very high mechanical values in the static as well as dynamic area.

Specifications / technical data

Property	Test method	Value	Unit
Density at 20 °C	DIN 53 217/2	1,36 - 1,40	g/ml
Viscosity at 20 °C Brookfield RV/DV-II Spl . rpm .	ISO 2555	27000 - 33000	mPas
Monomer content		25 - 28	%
Flash point	DIN 53 213	32	°C

Curing

Reactivity:
BÜFA method in accordance with DIN 16 945 6.2.2.1
(100 g BÜFA® Protection Layer LEO-R 6500 + 1.50 g Accelerator 0399 (742-0399)
+ 2 g Butanox LPT-IN)

20 - 30 °C	22 - 29 min
20 °C - Tmax	53 - 60 min
Tmax	73 - 79 °C

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Gel time at 20 °C in a 100 g cup with 1.5 g Accelerator 0399 (742-0399) and 2.0 ml Butanox LPT-IN: 22 - 29 min

The quantity of accelerator added should not be less than 1.0 g per 100 g material.

Attention!
The information given above refers exclusively to the use of the catalyst named and the quantity specified. The use of different products or differing quantities may yield different results.

Colouring

Other tinted versions are not available.

Directions for use

Our release agent system Chemlease 41-90 has been tested and successfully used with BÜFA® Protection Layer LEO-R 6500. Before using other release agents, they should be tested for suitability under practical conditions. Stir BÜFA® Protection Layer LEO-R 6500 gently before using.

The thickness of the wet film should range between 900 - 1200 µm and may not be less than 900 µm. After approx. 60 minutes, laminating can be carried out with a sound bond. To ensure a sound bond, laminating work must take place after 4 hours at the latest.

If circumstances permit, we recommend post-curing the moulded part for 6 hours at approx. + 80 °C to achieve optimal final properties. We generally recommend a suitable protective varnish, particularly when the parts are used outdoors. If you have any questions concerning this, get in touch with our Technical Service Department.

Note:

Attention!
BÜFA® Protection Layer LEO-R 6500 is an experimental product the composition and specifications of which may change at any time without prior notice.

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Fire protection properties	Results of orientation tests: Construction of test laminate: 1000 µm BÜFA® Protection Layer LEO-R 6500 2 layers SAERTEX Reinforcement LEO-R Bidiagonal Glass Fabric S32EX010-01211-01270-250000 [50 % by volume] BÜFA® Injection Resin LEO-R 6500 NFF 16-101: M1 / F1 TS EN 45545: HL 3 UNE 23721: M1 / F1 DIN 5510: S4 / ST2 / SR2 + Tox. according to ISO 5659 NFPA 130: passed BS 476: Class 1
Storage/Handling	This product must be stored cool in closed containers, protected from sunlight. Shelf-life is at least 3 months in unopened, original containers stored at a temperature between 5 and 20 °C. Avoid frost. Higher temperatures reduce shelf-life. Gel and curing times may change with increasing duration of storage.
Former product name	FRCS-X5 Protection Layer Rail.

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A company of BÜFA and DSM Composite Resins