



Product Data

The Use of Ren[®] 6444 AS THICKENING AGENT FOR RenCast[™] 6400-1, RenCast[™] 6401-1, RenCast[™] 6402-1, RenCast[™] 6403-1, RenCast[™] 6405, RenCast[™] 6410-1, RenCast[™] 6434, RenCast[™] 178-59-1

PROCEDURE:

Step 1.

Determine the required amount of Ren 6444(Hardener) to be used by multiplying the amount of Ren 6400-1, Ren 6401-1, Ren 6402-1, Ren 6403-1, Ren 6405, Ren 6410-1, Ren 6434, or Ren178-59-1 hardener being used by 0.005 (if you want a thin gel coat consistency) or by 0.03 (if you want a buttery consistency)

Example:

If you want a thin gel coat consistency, you would add 0.5 grams of Ren 6444 hardener to 100 grams of the hardener side of one of the products mentioned above.

If you want a thicker, buttery consistency, you would add 3.0 grams Ren 6444 hardener to 100 grams of the hardener side of one of the products mentioned above.

Note:

The consistency of the mixed compound can be controlled by increasing or decreasing the amount of Ren 6444.

Step 2.

Add the required amount of Ren 6444 determined in Step 1 to the hardener side of the compound selected above and mix together thoroughly, making sure there are no unmixed areas. If this is not done, you will get a lumpy final product.

Step 3.

Weigh out the amount of resin you would normally use plus an additional amount of hardener indicated in Table 1.

TABLE 1.	
Product	Additional parts hardener to be added
RenCast 6400-1	Equal amount of Ren 6444 hardener added
RenCast 6401-1	Equal amount of Ren 6444 hardener added
RenCast 6402-1	Equal amount of Ren 6444 hardener added
RenCast 6403-1	Equal amount of Ren 6444 hardener added
RenCast 6405	Equal amount of Ren 6444 hardener added
RenCast 6410-1	Three times the amount of Ren 6444 added
RenCast 6434	Equal amount of Ren 6444 added
RenCast 178-59-1	Equal amount of Ren 6444 added

Example: 100 grams Ren 6400-1 hardener) blended
3 grams Ren 6444 hardener)

The required amount of RenCast 6400-1 resin would be the normally required 10 grams plus equal amount of Ren 6444 hardener used which would be 3 grams for a total of 13 grams of Ren 6400-1 hardener.

Step 4.

Mix the blended resin and the hardener together thoroughly and without hesitation. Try not to blend in air. This mixture will quickly begin to thicken and will be ready for application after two or three minutes.

STORAGE/HANDLING INFORMATION:**Ren 6444**

Store at 60-100°F in a dry place. After use tightly reseal.

Work in a well ventilated area and use clean, dry tools for mixing and applying. For two component system, combine the resin and hardener according to mix ratio. Mix together thoroughly and use immediately after mixing. Material temperature should not be below 65°F (18°C) when mixing.

SHELF LIFE: Provided materials are stored under the recommended storage conditions in their original containers, they will remain in useable condition for six months from date of shipping.

SAFETY/HANDLING PRECAUTIONS: Do not use or handle this product until the Material Safety Data Sheet has been read and understood.

Ren 6444

WARNING! Causes eye, skin, and respiratory irritation. May cause allergic skin reaction.

- Avoid contact with eyes, skin, and clothing
- Avoid breathing vapor or mist.
- Avoid prolonged or repeated contact with skin.
- Keep container closed
- Use with adequate ventilation.
- Wash thoroughly after handling.

NOTICE! Overexposure may cause liver damage.

NOTE: Refer to RenCast 6400-1, RenCast 6401-1, RenCast 6402-1, RenCast 6403-1, RenCast 6405, RenCast 6410-1, RenCast 6434, and RenCast 178-59-1 data sheets for storage, handling and safety precautions.

FIRST AID: In case of contact with:

Skin: Immediately wash with soap and water. Remove contaminated clothing and launder before reuse. Destroy contaminated shoes.

Eyes: Immediately flush with water for at least 15 minutes. Call a physician.

Ingestion: If conscious, give plenty of water to drink. Do not induce vomiting. Call a physician.

Inhalation: Remove to fresh air. Administer oxygen or artificial respiration if necessary. Call a physician.

Other: Referral to physician is recommended if there is any question about the seriousness of any injury.

PRECAUTIONARY NOTE: Thermosetting systems generate heat when curing. The amount of heat and the period of time in which heat is released vary significantly between systems. Additionally, ambient or compound temperature, amount of material mixed, and construction and shape of the mold or container can also be factors in the temperature profile of a mixed system. In some cases, the thermosetting reaction can be vigorous, generating heat sufficient to cause decomposition of the system with subsequent liberation of large volumes of acrid smoke.

A good rule of thumb is never mix more material than can be applied during the stated pot life or gel time. Also take care when using materials in applications other than stated on the Product Data Sheet, i.e., a laminating resin for casting.

Please feel welcome to call our Product Information Department or your local Ren representative for instructions before you start your job.

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Vantico A&T US, Inc.
RenShape Solutions
4917 Dawn Avenue
East Lansing, MI 48823 USA

Tel 517 351 5900
800 375 1363
www.renshape.com

Customer Service Hotline: 800 367 8793
Technical Inquiries: 800 759 7165
Product Literature: 800 955 5509