



NECUMER® - BOARD, BLOCK AND CUSTOM-CAST MATERIAL FOR
MODELING, TOOLING, PATTERNS, FIXTURES AND JIGS

SOLID SOLUTIONS





Bottle rack made of NECURON® 1020

LIST OF CONTENTS

03	Foreword
04	The four basic principles of NECUMER GmbH
05	Application areas and physical properties of NECURON®

APPLICATION AREAS – MODELING

06	Large volume models
07	Styling- and design models
08	Architectural models
	Substructure for hard styling clay
09	Master and copy models
	Wind tunnel and water channel models

APPLICATION AREAS – TOOLING

10	Fixtures and gauges
11	Laminating tools
12	Foundry patterns and core boxes
13	Vacuum forming tools
14	Metal bending and hammerforming tools
15	RIM tools

16 CUSTOM-CAST MATERIAL

Custom-cast material - NECURON® 750FG & 1400FG

17 SPECIAL BOARDS

ACCESSORIES

18	Sealer
19	Adhesive

LEGEND

 **SUITABLE PRODUCTS**

 **QUESTIONS**

 **OUR STRENGTHS – YOUR ADVANTAGES**

NOTE

With this guide we intend to help you find the right NECURON® product for your application. Please note, that due to the multiple application possibilities, these recommendations are not necessarily confined to a specific product. Please also consider other NECURON® types. We always advise to conduct your own tests to optimize results when using NECURON® products. NECUMER GmbH takes no responsibility for any technical advice or recommendations given either in written or in verbal form.

FOREWORD

“SOLID SOLUTIONS” – this philosophy is the essence of all our NECURON® products. It is a promise to our customers and simultaneously also reflects our dedication, motivation and identification. Our customers can be sure that the commitment of the whole NECUMER Team is behind every NECURON® product and customer order.

“SOLID SOLUTIONS” for us means making sure that our customers get for them the most economical and optimum product available in the area of board and block materials. Our work is based on four fundamental principles – constant quality, excellent service, unique flexibility and long-term partnership. Based on these principles we consequently pursue consistent improvement.



Read on to discover what we stand for and the difference that NECUMER and NECURON® makes. With this catalogue we aim to give guidance for using NECURON® and help in choosing the right material for the job. The NECUMER team is always at your disposal for suggestions and any further questions.

With best regards from Bohmte

A handwritten signature in black ink that reads "Dirk Nedderhoff". The signature is stylized and cursive, written over a light blue horizontal line.

Dirk Nedderhoff

OUR STRENGTHS

- Independent family owned company with secured succession
 - Worldwide presence through reliable and competent partners
 - High level of service through long standing experienced employees
 - Constant high quality standards
 - In-house development and production
-



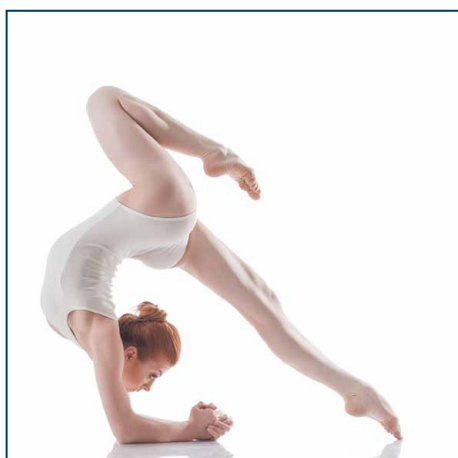
CONSTANT QUALITY

Our customers must have confidence that every NECURON® board is as good as the next when creating a work piece. More than a quarter of a century of manufacturing experience is inherent in NECURON® materials "Made in Germany". NECUMER GmbH has also adopted a superior quality management which controls values and tolerances at every stage of their production process – from inspection of raw materials through to visual or ultra-sonic final control before shipment. Nothing is left to chance and our customers can relax in the knowledge that the next board from the pallet will give him the constant quality he deserves.



EXCELLENT SERVICE

According to the yearly audit, NECUMER GmbH always scores close to 100% on service. This is maintained through friendly, courteous staff, competent sales partners and effective logistics. Our modern SAP software supports and controls the smooth running of all departments within the company allowing our staff to respond quickly and effectively to all inquiries.



UNIQUE FLEXIBILITY

Apart from the largest choice of standard board types and dimensions available on the market, NECUMER GmbH can also offer their customers exactly what they want in terms of colour, shape and formats as well as special physical values for specific applications within the framework of their product formulations. This flexibility is unique to the modeling board business and aimed to save customers purchasing power, machining time, waste disposal and improve performance in the specific application areas.



LONG-TERM PARTNERSHIP

After more than 25 years of manufacturing and marketing the NECURON® brand the products are well known in the modeling and tooling departments of most multi-national companies in the automotive, aerospace, domestic appliance and other major industries. This could only be achieved through our loyal and long-term relationships with all of our customers and distributors worldwide. NECUMER GmbH has constantly invested and built on these partnerships under the motto "fair play" to become one of the world's most successful producers of modeling and tooling materials.

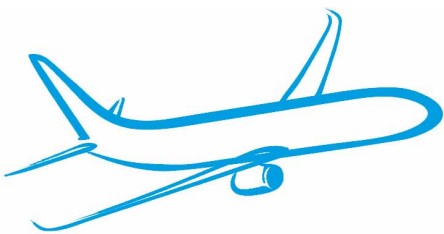


© Art-Design, Andrea Fasch & Lukas Hodiamont

Wall decoration "mermaid" for bathrooms. Contour milled from NECURON®. Dimensions X 780mm, Y 500mm, Z 50mm

APPLICATION AREAS

The extensive NECURON® assortment offers the appropriate material for every area of modeling and prototyping, jig and fixture production as well as for making tools, patterns and moulds. Typical modeling applications include for example architectural models, cubing



and data control models, program test milling models, styling and design models as well as master and copy models. In tool making, NECURON® can be applied to make metal bending and stretch tools, foundry patterns, core

boxes, laminate moulds, jigs and fixtures.

PHYSICAL PROPERTIES

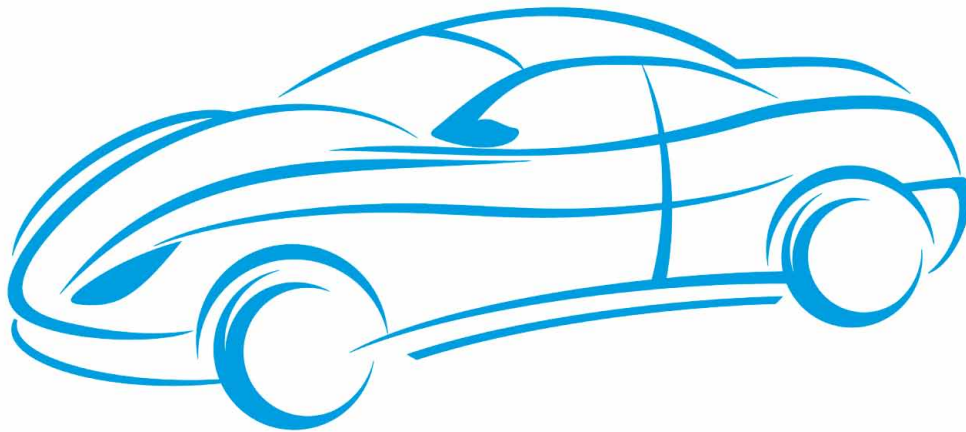
NECURON® products have been developed to leave an extremely homogenous high quality surface structure after machining. The products are dimensionally stable, have high edge stability and absorb very little moisture. When stored dry and flat the boards can be warehoused for years without any shrinkage.



✓ YOUR ADVANTAGES

- Excellent chipping whilst machining
- Low dust emission
- Pleasant machining properties with ordinary cutters
- Splitter-free machining
- Low odour emission
- Non-hazardous
- Contains no abrasive fillers therefore low wear on cutting tools
- Suitable for high speed machining

MODELING



LARGE VOLUME MODELS



*1:1 scale design
model made from
NECURON® 100*

The light foams (NECURON® 100, 160 and 250) and our custom cast products (NECURON® 750FG and 1400FG) are especially available for large volume models and tools.

The light foams differentiate themselves in terms of price, stability and surface structure. A smooth paintable surface can be obtained by using polyester spray filler. It should be noted that the lower the material density is, the more filler will be required.

NECURON® 750FG and 1400FG have far more compressive and flexural strength but also a smooth surface structure and more edge stability compared to the light foams.

? QUESTIONS

- Is there any hand finishing to be made or will the model be CNC-machined?
- What is the model/tool being used for?
- Are glue lines an issue?
- Is the surface structure important?
- How stable should the edges and surface of the model be?
- How much work would the customer invest in the surface?
- Are there any process parameters required from the material (heat, pressure, abrasion, chemical resistance)?
- Is the weight important?



SUITABLE PRODUCTS

- NECURON® 100
- NECURON® 160
- NECURON® 250
- NECURON® 750FG
- NECURON® 1400FG



YOUR ADVANTAGES

- Large choice of product types from lightweight design materials to tooling materials (density 0.10 g/cm³ - 1.35 g/cm³)
- Large choice of board dimensions (up to a length of 2 metres)
- Light foams (NECURON® 100, 160 and 250) have a relatively high temperature resistance (120°C)
- Light foams have a large choice of standard formats and additionally custom cast blocks are available up to a size of 2000 x 1000 x 500 mm

STYLING- AND DESIGN MODELS

An extremely wide range of NECURON® materials are available for making design and styling models (NECURON® 100, 160, 250, 270, 301, 400, 480, 540, 600, 620, 640 and 651). The choice of product here depends on which product properties are of most importance. Generally, the higher the density is, the less needs to be invested in time and work to achieve a smooth class A paintable surface. Also higher densities have more mechanical strength and edge stability.

NECURON® 480 deserves special mention due to its excellent surface struc-



ture despite its low density. To achieve a perfect paint surface we recommend using polyester or 2-component acrylic spray filler for the lower density products and/or a sealer to close the micro pores on the surface. Additional coats

of paint will provide a class A paint finish.

SUITABLE PRODUCTS

- NECURON® 100
- NECURON® 160
- NECURON® 250
- NECURON® 270
- NECURON® 301
- NECURON® 400
- NECURON® 480
- NECURON® 540
- NECURON® 600
- NECURON® 620
- NECURON® 640
- NECURON® 651

YOUR ADVANTAGES

- Excellent choice of materials from light foams to materials which have a smooth surface structure and need little preparation to achieve an A-class paint finish
- The right product for any requirement on any model
- Good dimensional stability

QUESTIONS

- How important is the surface?
- How much work would the customer invest in the surface?
- Is the weight important?
- How stable should the edges be?
- Are any process parameters required from the material (heat – especially when drying paint, pressure, abrasion, chemical resistance)?
- Are glue lines an issue?
- Does the model have a function or is it purely a show piece?



Design model made from NECURON® 400



Design model made from NECURON® 651

ARCHITECTURAL MODELS



Architectural model made from NECURON® 600

These five NECURON® types are commonly used for architectural modeling. Because they are easy to work by hand. NECURON® 600 was especially designed for architectural modellers to provide a material which suits their easy-to-mill requirements, needs little preparation before painting and due to its brilliant white colour only needs one or two coats of paint.

? QUESTIONS

- Should the colour of the material be white to save excessive painting?
- Is the weight of the model important?
- How stable should the edges of the material be?

⚙️ SUITABLE PRODUCTS

- NECURON® 301
- NECURON® 400
- NECURON® 480
- NECURON® 600
- NECURITE® 630

✓ YOUR ADVANTAGES

- Densities up to 0.7 g/cm³ can be cut and shaped easily with hand tools
- Many types available in almost white colour, NECURON® 600 in titan white, for easy painting

SUBSTRUCTURE FOR HARD STYLING CLAY



Clay model: substructure NECURON® 100, other parts (wheel and radiator grill) NECURON® 1300

NECURON® 100, 160, 250 are often used as a substructure for hard styling clay. These materials do not distort after applying and shaping the previously heated clay due to their elevated temperature resistance. NECURON® 100 is most cost-effective and adequate in both dimensional stability and surface quality.

Finely detailed filigree parts are usually

impossible to model or mill in clay. NECURON® 1300 has been proven successful for this type of work due to its dimensional accuracy, strength, fine surface finish and excellent milling properties.

The picture shows a clay model with wheels, radiator and exhaust made of NECURON® 1300.

⚙️ SUITABLE PRODUCTS

- NECURON® 100
- NECURON® 160
- NECURON® 250

? QUESTIONS

- Is temperature resistance an issue?
- Is the weight of the material important?

MASTER AND COPY MODELS

NECURON® 301, 480, 540, 620, 651 and 770 boards are above all suitable for making master models. All these types offer an excellent surface finish compared to other similar products. They are especially stable and keep their original form years later due to our extensive post-curing process.

Due to the compressive strength required by copy models we recommend using NECURON® 651. This type offers especially high compressive strength at a comparatively low density and a super smooth surface.



Tire master model made from NECURON® 651

? QUESTIONS

- How important is the surface structure?
- Is good edge stability required?
- Are any other chemicals involved in the process (chemical resistance, compatibility)?
- Are any process parameters required (pressure, heat, abrasion etc.)?
- Is an especially low coefficient of thermal expansion required?

⚙️ SUITABLE PRODUCTS

- NECURON® 301
- NECURON® 480
- NECURON® 540
- NECURON® 620
- NECURON® 651
- NECURON® 770

✓ YOUR ADVANTAGES

- Excellent surface quality
- NECURON® is especially dimensionally stable
- NECURON® boards keep their dimensions after years of storage
- Cost/benefit alternatives in densities between 0.3 and 0.77 g/cm³

WIND TUNNEL AND WATER CHANNEL MODELS

High performance and low energy consumption are optimized by testing models in a wind tunnel or water channel. NECURON offers optimum material for the application – from modern jet fighters to F1 racing cars or massive oil tankers.



Wind tunnel & model made using NECURON®

? QUESTIONS

- How fine should the surface be?
- Are there any weight restrictions?
- Are pressures involved?
- Can glue lines be accepted?

✓ YOUR ADVANTAGES

- Choice of densities and physical properties in the NECURON® range which will cover speeds of between Mach 1 and a few knots/hour.

⚙️ SUITABLE PRODUCTS

FOR WATER CHANNEL MODELS:

- NECURON® 301
- NECURON® 480
- NECURON® 640
- NECURON® 651

FOR WIND TUNNEL MODELS:

- NECURON® 651
- NECURON® 1001
- NECURON® 1020
- NECURON® 1300

TOOLING



FIXTURES AND GAUGES



Checking fixture with measuring points made from NECURON® 1007

NECURON® 400, 540, 651, 770, 800, 1001 and 1007 are used extensively in the automotive industry for gauges and production jigs. Our checking fixture program offers a wide choice of materials which renders the desired properties concerning thermal expansion, stability and wear resistance for a cost effective solution according to your requirements. Due to years of optimized formulation, NECURON® types are substantially lighter than comparable products yet they possess the physical properties required for fixtures and jigs.

✓ YOUR ADVANTAGES

- Many cost/benefit alternatives in the NECURON® range
- Materials approved for fixtures by most OEM's
- Very low coefficient of thermal expansion
- High abrasion resistance
- High edge stability

⚙️ SUITABLE PRODUCTS

- NECURON® 400
- NECURON® 540
- NECURON® 651
- NECURON® 770
- NECURON® 800
- NECURON® 1001
- NECURON® 1007

? QUESTIONS

- What type of part is being checked or held (e. g. metal, glass, plastic)?
- How high is the abrasion?
- Any heat involved? (welding jigs, gluing jigs)
- Are tolerances comparatively high? (e. g. car carpet CF's or metal part CF's)

LAMINATING TOOLS

The NECURON® assortment offers a choice of polyurethane and epoxy boards which achieve a temperature resistance of over 170°C. The epoxy boards NECURON® 700 and NECURON® 702 are especially suitable for high performance CFRP laminates mainly due to the fact that they do not outgas at high temperature. Polyurethane boards can be used for CFRP laminates which cure at room temperature. PU-boards are also

suitable for GRP laminates, are easier and more pleasant to machine and offer an excellent surface structure.

SUITABLE PRODUCTS

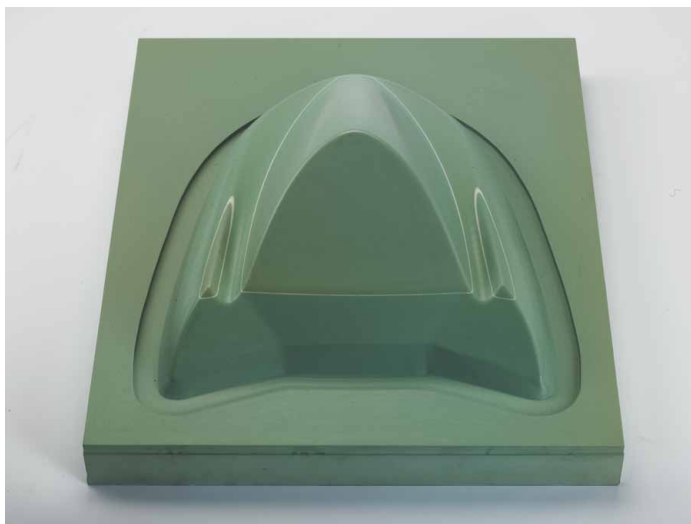
- NECURON® 301
- NECURON® 651
- NECURON® 690
- NECURON® 700
- NECURON® 702
- NECURON® 840
- NECURON® 1007
- NECURON® 750FG
- NECURON® 1400FG

YOUR ADVANTAGES

- Large choice of various material types and formats for many laminate types and processes
- High dimensional stability and accuracy due to low thermal expansion

QUESTIONS

- Are glue lines acceptable?
- How smooth should the surface be?
- How much should be invested in surface preparation to achieve a smooth surface?
- What degree of accuracy is required (coefficient of thermal expansion)?
- Is a sealer or release agent required and are they compatible with NECURON®?
- How many parts are expected from the tool?
- What type of laminate is used in the tool?
- Is temperature involved in the process?
- Is the laminate cured in the mould? If so, for how long and at which temperature?
- Is oven curing involved in the process?
- Is pressure involved in the process (autoclave curing)?



Laminating tool made from NECURON® 702



Laminated carbon part from a NECURON® mould

FOUNDRY PATTERNS AND CORE BOXES

Patterns and core boxes used in the sand forming process are increasingly being made from NECURON® boards. Due to the abrasion of the sand in the various sand forming processes, it is important to identify the degree of abrasion resistance and the number of castings required from the pattern or core box. Sand forming by hand hardly has an abrasive effect; vibration sand forming machines are less abrasive than machines that shoot sand at the pattern or core box at high pressure. For these and other reasons, NECUMER offers a comprehensive range of materials with more or less mechanical strength and abrasion resistance. NECURON® 301 can for example withstand one or two sand form cycles and is suitable for prototype castings. NECURON® 651 is capable of withstanding 50 to 200 sand form cycles, 10,000 cycles are possible with NECURON® 1020 at pressures of up to 4 bar and NECURON® 1300 can cope with several thousand more without significant signs of wear. Other factors to consider are the type of sand used (more or less aggressive),

the geometry of the casting (thin parts wear down quicker), the chemicals involved in the process (compatibility), the accuracy required (thermal expansion) and the surface structure.



Foundry model made from NECURON® 1300

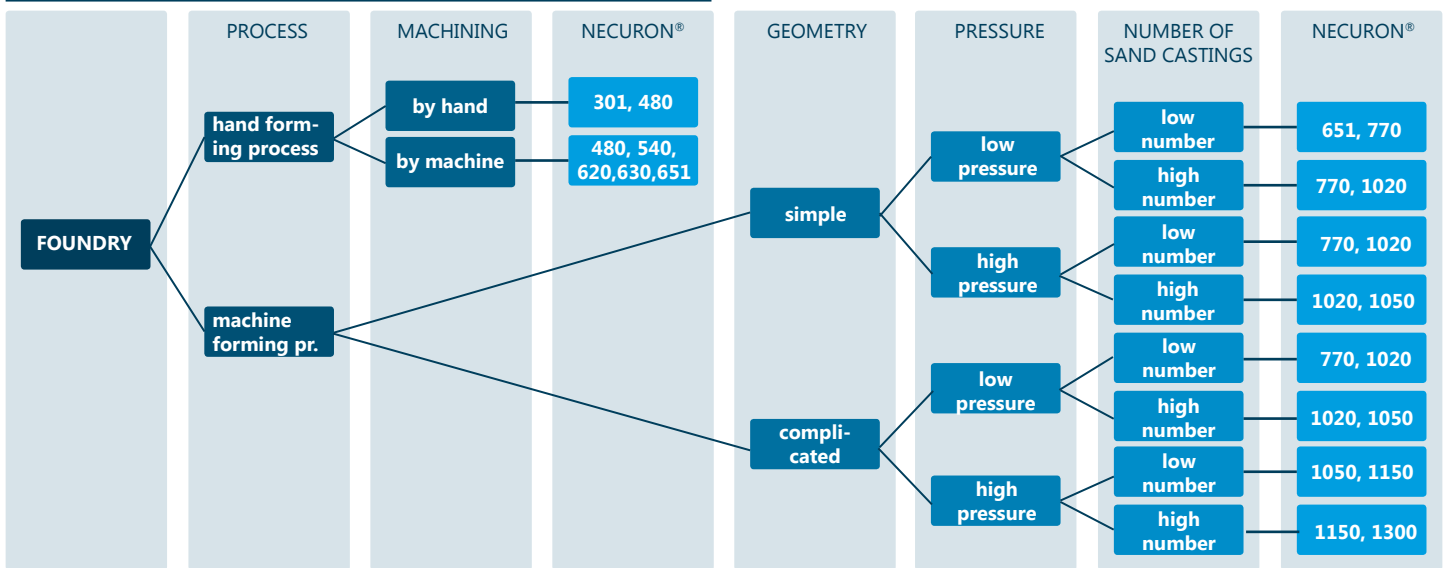
? QUESTIONS

- Is the sand formed manually or by machine and what are the parameters involved (pressure, heat)?
- How many sand forming cycles are required from the pattern or core box?
- What type of sand is used (more or less aggressive)?
- Which chemicals are involved (sand binder, release agent) and are they compatible with NECURON®?
- Is the geometry of the part complicated or have thin areas?

⚙️ SUITABLE PRODUCTS

- NECURON® 301
- NECURON® 480
- NECURON® 540
- NECURON® 620
- NECURITE® 630
- NECURON® 651
- NECURON® 770
- NECURON® 1020
- NECURON® 1050
- NECURON® 1150
- NECURON® 1300

Determine the right product for your foundry application

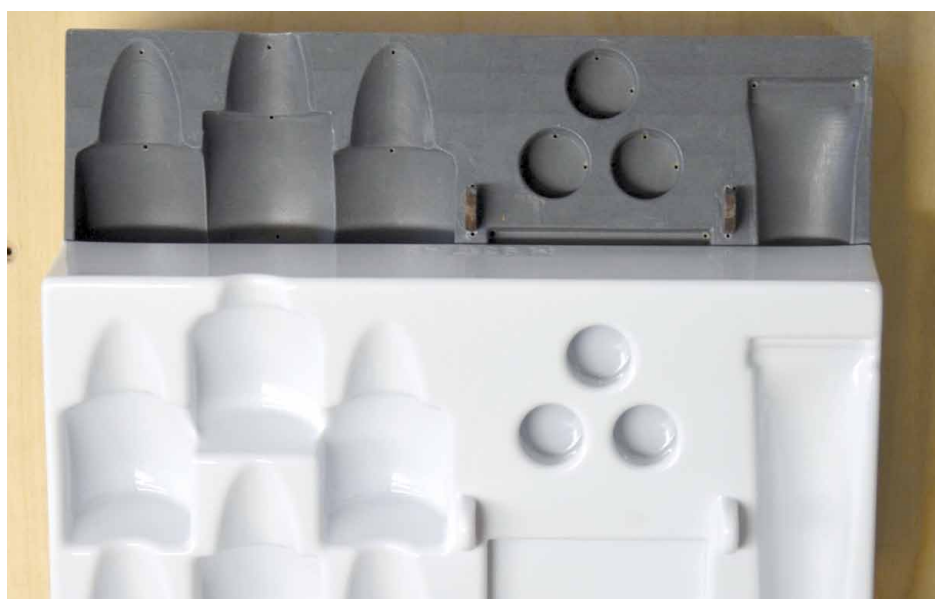


VACUUM FORMING TOOLS

A vacuum forming tool should have a smooth surface to ensure that the part being formed is also perfectly smooth. Consequently we recommend that the tool is sanded smooth, sealed and if required, a release agent applied to ensure good de-moulding. Polyurethane boards are ideal tooling materials for short series and prototype production. Important criteria for the choice of board type are the accuracy (low thermal expansion) and the heat resistance required. Especially suited for this type of application are NECURON® 651, 690, 1007, 700, 702 and 840. NECURON® 840 is market leader in this application area which, as polyurethane, has an impressive temperature resistance of up to 130°C. NECURON® 1007 (extra smooth for transparent parts), 700 and 702 are also good choices depending on the temperature requirement. A well-known customer in the cosmetic industry for example, could produce approx. 14,000 displays in 2 mm poly-

propylene foil from a NECURON® 840 tool. The tool was not sealed due to its smooth milled surface. Other customers have vac-formed 6 mm thick ABS sheets using NECURON® 840. NECURON® 651 is also widely used for vacuum forming tools mainly in the prototyping area or for short series production using thin foils. Lower density boards (NECURON® 651, 690, 700 and 702)

are micro porous and surfaces should be smoothed and sealed. Clear nitro lacquer is often used as a sealer.



Vacuum forming tool made from NECURON® 840

✓ YOUR ADVANTAGES

- Large choice of alternatives under one brand name
- Excellent cost/benefit ratio
- Materials for prototypes, small and short series production available
- Unique products such as NECURON® 690 and 840
- Custom casted products available to avoid glue lines

? QUESTIONS

- How thick is the foil or plate to be formed?
- How many parts are expected from the tool?
- What temperatures are involved?
- How long is the temperature applied per cycle?
- How long is the cooling time between cycles?
- Are thin walls in the geometry of the tool?
- Are glue lines accepted?

⚙️ SUITABLE PRODUCTS

- NECURON® 651
- NECURON® 690
- NECURON® 700
- NECURON® 702
- NECURON® 840
- NECURON® 1007
- NECURON® 750FG
- NECURON® 1400FG

METAL BENDING AND HAMMERFORMING TOOLS

NECURON® polyurethane boards are particularly suited to make press and hammer forming prototype tooling due to the astonishingly short production time. Also, changes in the geometry of the tool can be quickly and easily changed by cutting out the unwanted part, bonding in a piece of board and re-milling the contour. High compressive and flexural strength as well as good processing properties are the main criteria for choosing the right material

for press and hammer forming tools. Elasticity may be a further requirement for press tooling, as found with NECURON® 1300, but is not acceptable for hammer forming (hammer bounce back). NECURON® 1020, 1050 and 1150 are successful for bending steel and aluminum sheet in a thickness of up to 2 mm. For hardened steel we recommend the use of NECURON® 1300 which can press hardened steel into the most complicated shape. To improve

the flow of the metal over the tool we recommend using a lubricant. Careful use (e. g. slow press speed) will prolong tool life and increase the number of parts which can be made. Apart from the excellent physical values concerning compressive and flexural strength, NECURON® has a certain structure and elasticity which makes it a superb choice for prototype press tooling.

✓ YOUR ADVANTAGES

- High physical values with relative low density allow fast and pleasant machining
- Proven success: NECURON® 1300 is able to bend hardened steel in 3 mm thickness

? QUESTIONS

- Which type of material is to be formed?
- How thick is the metal sheet?
- Are thin parts in the tool geometry? How exactly are the contours of the tool?
- How many parts are expected from the tool?
- How deep is the tool draw?
- Can the press speed be slowed down or controlled?
- How high is the pressure when pressing the part?



Metal bending tool made from NECURON® 1300

⚙️ SUITABLE PRODUCTS

- NECURON® 1020
- NECURON® 1050
- NECURON® 1150
- NECURON® 1300

RIM TOOLS

RIM tools require elevated compressive strength, temperature resistance and dimensional stability. The tool material must also have a smooth surface structure. For these reasons we recommend NECURON® 651, 1020, 1050, 1150 or 1300.

✓ YOUR ADVANTAGES

- Cost effective alternative to metal tooling
- Excellent properties especially regarding dimensional stability
- Excellent surface structure quality

⚙️ SUITABLE PRODUCTS

- NECURON® 651
- NECURON® 1020
- NECURON® 1050
- NECURON® 1150
- NECURON® 1300

? QUESTIONS

- How important is the surface structure of the tool?
- How much pressure must the tool withstand?
- Which temperatures are involved in the RIM process and for how long?



RIM tool made from NECURON® 1020



RIM tool made from NECURON® 1020

CUSTOM-CAST MATERIAL - NECURON® 750FG AND 1400FG



NECUMER can produce these two products in blocks of up to a size 2000 x 1000 x 500 mm, or under certain circumstances even larger, according to your specifications.

Additionally, radius boards and cylindrical boards (standard diameters: 420 / 450 / 500 / 550 and 600 mm) are produced but also blocks can be cast according to a drawing or into a pre supplied mould.

The castings are supplied slightly over-size and can be immediately CNC-Machined.

NECURON® 750FG and NECURON 1400FG are above all used where glue lines are not acceptable. Main areas of application are master and copy models, be-leathering models and also vacuum forming tools.

? QUESTIONS

- What is the product being used for?
- What physical properties are required (temperature, mechanical strength, abrasion resistance)?
- Are there any weight limits?

⚙️ SUITABLE PRODUCTS

- NECURON® 750FG
- NECURON® 1400FG



Dashboard

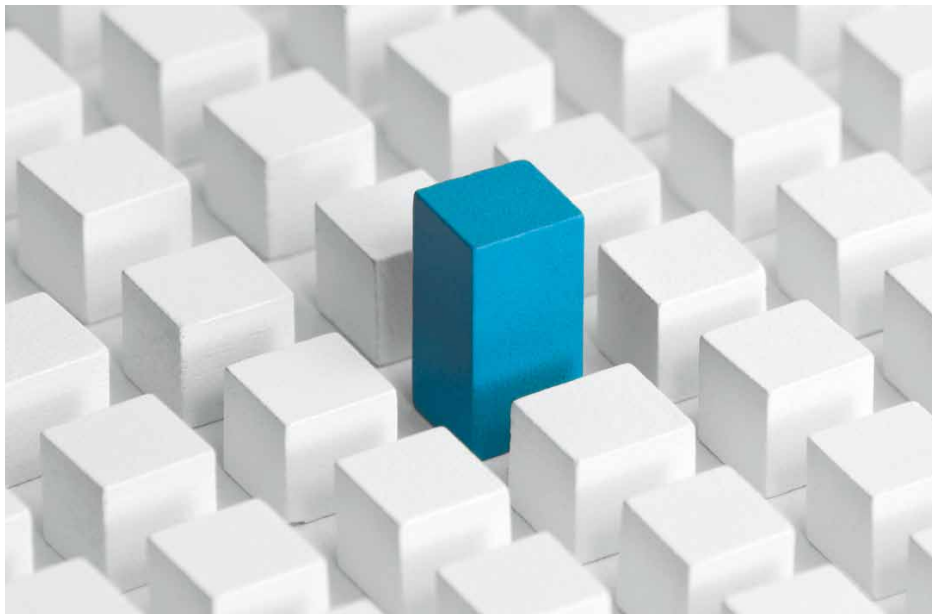
✓ YOUR ADVANTAGES

- Saves work and time bonding boards together
- Saves waste
- Saves machining time
- Avoids glue lines

SPECIAL BOARDS

For prototypes and tooling, certain industrial branches always require the same format and basic shape for their products or production process. Many companies in the tire industry for example, prefer a certain board format with a defined radius along the top of the board. This special board has the optimum format for making passenger car tire moulds and adds enormous value for the customer compared to standard board dimensions. Additionally we permanently manufacture cylindrical formats for producing aluminum wheel rim prototypes. We

keep these “cylindrical boards” in various diameters on stock to enable a quick reaction for every order. The savings advantages with regard to time, material and waste are enormous. Please contact us if special formats or shapes are required. Our production facilities are conceived for flexibility which gives us the ability to integrate custom made products into our production process to find a speedy solution and quick supply.



✓ YOUR ADVANTAGES

- The ability to include custom made products into our production process leads to enormous cost reduction
- Per agreement, special formats can be produced and warehoused to guarantee just-in-time delivery
- Saves material, work, machining time and waste

? QUESTIONS

- Is always approximately the same format required?
- How many models, tools or moulds are required per year?
- What is the process for which the material is used for?
- Which physical properties are required from the material?

⚙️ SUITABLE PRODUCTS

- NECURON® 100
- NECURON® 160
- NECURON® 250
- NECURON® 270
- NECURON® 301
- NECURON® 400
- NECURON® 480
- NECURON® 490
- NECURON® 540
- NECURON® 600
- NECURON® 601
- NECURON® 620
- NECURON® 640
- NECURON® 651
- NECURON® 690
- NECURON® 702
- NECURON® 770
- NECURON® 800
- NECURON® 840
- NECURON® 1001
- NECURON® 1007
- NECURON® 1020
- NECURON® 1050
- NECURON® 1150
- NECURON® 1300
- NECURON® 750FG
- NECURON® 1400FG

ACCESSORIES



SEALER



NECURON® 702, sealed with NECURON® V7

NECURON® V7 is a mould sealer which has been developed for sealing various materials, especially for epoxy and polyurethane modeling and tooling boards, MDF, polyester and epoxy composite materials with or without gel coat coating.

NECURON® V7 cures by absorbing moisture from the air to become a high tensile sealer, consisting of a hydrocarbon-alcohol-solvent mixture which enables a mirror finish surface. NECURON® V7 can be applied with

a cloth or spray gun. Rubbing or polishing is not required. The quick drying formulation is also suitable as a semi-permeable mould release for priming moulds and can be used to re-condition older mould surfaces.

 **YOUR ADVANTAGES**

- High sealing ability
- Mirror finish without polishing
- Easy and quick to apply
- Quick drying
- No mould contamination
- Does not contain aromatic solvents
- Almost odourless

ADHESIVE

For making larger models, patterns and tools, NECUMER offers you various adhesives which, regarding their characteristics and colour, match the various NECURON® board material types. Our assortment includes single and 2-component adhesives which are either polyurethane (PU) or epoxy (EP) based. For every NECURON® board there is a matching adhesive. Choose

the correct adhesive from the table below!



NECURON®	Colour	Brief description	EP/ PU	Pot Life	Curing Time	suitable NECURON® products
K2	transparent/ light yellow	Single component adhesive for bonding light foams and modeling board	PU	~ 90 min (at 20 °C)	~ 5 - 6 hrs (at 20 °C)	100, 160, 250, 301
K4	orange	2-component adhesive, properties similar to NECURON® 480	PU	~ 7 - 12 min (for 100-300 g mix, at 25 °C)	~ 12 - 18 hrs (at 25 °C)	480
K6	brown	2-component adhesive, specially formulated for quick curing, properties similar to NECURON® 651	PU	~ 140 - 160 sec (for 200 g mix, at 20 °C)	~ 15 - 30 min (at 20 °C)	400, 540, 620, 640, 651
K7L	translucent	2-component adhesive developed especially for NECURON® 702 and for applications up to 140°C. L = long pot life, slow curing	EP	~ 40 - 60 min (for 200 g mix, at 25 °C)	~ 12 - 16 hrs (at 20 °C)	690, 702, 840
K7S	translucent	2-component adhesive developed especially for NECURON® 702 and for applications up to 140°C. S = short pot life, quick curing	EP	~ 20 - 30 min (for 200 g mix, at 25 °C)	~ 4 - 5 hrs (at 20 °C)	690, 702, 840
K8N	translucent	2-component adhesive for general modeling and tooling with excellent bonding properties	EP	~ 10 min (for 100 g mix, at 20 °C)	~ 4 - 6 hrs (at 20 °C)	400, 480, 540, 600, 620, 630, 640, 651, 770, 800, 1001, 1020, 1050, 1300
K8T	translucent	2 component adhesive, temperature resistance up to 110°C, especially for making laminating moulds and vacuum forming tools	EP	~ 30 min (for 100 g mix, at 20 °C)	~ 18 hrs (at 20 °C)	690, 702, 840, 1007
K11	green	2-component adhesive, specially formulated for quick curing, properties similar to NECURON® 1050 and NECURON® 1150	PU	~ 140 - 160 sec (for 100-300 g mix, at 25 °C)	~ 25 - 35 min (at 25 °C)	1050, 1150
K13	red	2-component adhesive, specially formulated for quick curing, properties similar to NECURON® 1300	PU	~ 140 - 160 sec (for 200 g mix, at 20 °C)	~ 25 - 30 min (at 20 °C)	1150, 1300



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