



## Technical Data Sheet

### 21 X SERIES GELCOAT

#### **DESCRIPTION:**

21X series isophthalic gelcoats are high quality coatings developed for the fibreglass industry. These gelcoats provide quality finishes and deliver good water resistance, gloss retention and weathering. They are «shock proof» and can support moderated thermal variations.

These gelcoats are formulated to meet the requirements of transportation\*, truck cabs, sanitary applications and boating. For parts with a prolonged contact with water, we recommend an NPG/ISO base gelcoat.

21X series gel coats are ready to use, sag resistant, fast curing and require only the addition of a proper amount of methyl ethyl ketone peroxide to cure.

These gelcoats are available in a wide range of eye-appealing colours. Color matching is available on request.

\*Contact your Polynt Composites representative if a particular requirement or regulation is specified.

#### **PHYSIC CHARACTERISTICS (at 25°C or 77°F):**

These values may or may not be manufacturing control criteria; they are listed for a reference guide only. Particular batches may not conform exactly to the numbers listed because storage conditions, temperature changes, age, testing equipment (type and procedure) can each have a significant effect on the test results. Gel coats with properties outside of these ranges can perform acceptably.

<b><u>Test</u></b>	<b><u>Value</u></b>
Viscosity	
Brookfield RVF #4 Spindle @ 20 rpm	9000 - 15000 cps
Thixotropic Index (2/20)	> 4
Flash Point	27,8°C – 31,1°C (82 - 88°F)
Weight per Gallon	1,20 – 1,35 Kg / litre
Gel Time at 1.8% MEKP**	8 - 17 minutes
Lay-up Time**	45 - 60 minutes
Sag Resistance	Good at 20 mils
Hide (Most Formulations)	Complete at 12 mils.

\*\* tested @ 1,8% Norox MEKP 925 @ 25°C

Reds, yellows and dark blues may have low hiding power. Ask a Polynt Composites representative whether the red, yellow or blue selected requires a special application procedure (which would be increased film thickness in multiple applications).



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#### **APPLICATION:**

21X series gelcoats are generally formulated for brushing & rolling applications.

For best overall performance properties, a wet film thickness of  $18 \pm 2$  mils is recommended as ideal. Films less than 12 mils may not cure properly, may be hard to patch, have more print-through, and are more susceptible to water blisters. Films above 24 mils may pre-release, trap porosity, or crack, and are more subject to weathering discoloration. If water blisters are of a great concern (boat hulls), 20 to 24 mils would perform better than a thinner film, but resistance to sag, porosity and cracking could suffer. If weathering (yellowing from sunlight, decks) is of great concern, then thinner films (12 to 16 mils) would perform better, but patchability and resistance to print-through and blistering could suffer.

Proper mold maintenance is important. Although 21's have excellent patching properties, minimal repair work is always desirable. Sanding and compounding can hasten the chalking and loss of gloss of all gel coats.

#### **CURE:**

It is recommended that gel time be checked in the customer's plant because age, temperature, humidity and catalyst will produce varied gel times. All data referencing gel or cure refers specifically to NOROX MEKP-925 catalyst.

The catalyst level should not exceed 3.0% or fall below 1.2% for proper cure. Recommended range is 1.8% at 77°F being ideal. Normally, the gel coat film is ready for lamination in 45 to 60 minutes. This time element is dependent on material temperature, room temperature, humidity, air movement, and catalyst concentration.

This product should not be used when temperature conditions are below 60°F, as curing may be adversely affected.

#### **PRECAUTION:**

Isophthalic gel coats are not compatible in the liquid state with ISO/NPG gel coats or ISO/NPG resins. Equipments must be completely clean of these gel coats or resins before isophthalic's can be used.

Do not over-mix gel coats. Over-mixing breaks down gel coat viscosity, increasing tendencies to sag, and causes styrene loss, which could contribute to porosity. Gel coats should be mixed once a day for 10 minutes. The gel coat should be mixing to the sides and bottom of the container with the least amount of turbulence possible. Air bubbling should not be used for mixing. It is not effective and only serves as a potential for water or oil contamination.

Do not add any material, other than a recommended methyl ethyl ketone peroxide, to this product without the advice of a representative of Polynt Composites.



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#### **STORAGE LIMITATIONS:**

Uncatalyzed, standard cure gel coats have a usage life of 90 days from date of manufacture when stored at 73°F or below, in a closed, factory sealed, opaque container, and out of direct sunlight. Fast Cure gel coats are stable for 30 days.

#### **SHIPPING:**

Shipment is normally in open head, 55-gallon drums (204 litres) or 4,4 imperial gallons (20 litres).

#### POLYESTER SAFETY INFORMATION

All sales of products manufactured by Polynt Composites and described herein are made solely on condition that Polynt Composites's customers comply with applicable health and safety laws, regulations and orders relating to the handling of our products in the workplace. Before using, read the following information and both the product label and Material Safety Data Sheet pertaining to each product.

Most polyester products contain styrene. Styrene can cause eye, skin and respiratory tract irritation. Avoid contact with eyes, skin and clothing. Impermeable gloves, safety eyewear and protective clothing should be worn during use to avoid skin and eye contact. Wash thoroughly after use.

Styrene is a solvent and may be harmful if inhaled. Reports have associated repeated and prolonged occupational overexposure to solvents with permanent brain and nervous system damage. Extended exposure to styrene at concentrations above the recommended exposure limits may cause central nervous system depression causing dizziness, headaches or nausea and if overexposure is continued indefinitely, loss of consciousness, liver and kidney damage.

Do not ingest or breathe vapor, spray mists and dusts caused by applying, sanding, grinding and sawing polyester products. Wear an appropriate NIOSH/MSHA approved, properly fitted, respirator during application and use of these products until vapors, mists and dusts are exhausted, unless air monitoring demonstrates vapors, mists and dusts are below applicable exposure limits. Follow respirator manufacturer's directions for respirator use.

The International Agency for Research on Cancer (IARC) has reclassified styrene as Group 2B "possibly carcinogenic to humans." This new classification is not based on new health data relating to either humans or animals, but on a change in the IARC classification system. The Styrene Information and Research Center does not agree with the reclassification and has published the following statement: Recently published studies tracing 50,000 workers exposed to high occupational levels of styrene over a period of 45 years showed no association between styrene and cancer, no increase in cancer among styrene workers (as opposed to the average among all workers), and no increase in mortality related to styrene.

Styrene is classified by OSHA and the Department of Transportation as a flammable liquid. Flammable polyester products should be kept away from heat, sparks, and flame. Lighting and other electrical systems in the work place should be vapor-proof and protected from breakage.

Vapors from styrene may cause flash fire. Styrene vapors are heavier than air and may concentrate in the lower levels of molds and the work area. General clean air dilution or local exhaust ventilation should be provided in



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volume and pattern to keep vapors well below the lower explosion limit and all air contaminants (vapor, mists and dusts) below the current permissible exposure limits in the mixing, application, curing and repair areas.

If the label or Material Safety Data Sheet indicates lead or lead chromate is present, do not use on toys, furniture or surfaces that might be chewed by children. Wash hands thoroughly after using and before smoking or eating. Long-term overexposure by inhalation or ingestion of mists and dusts from products containing lead compounds and lead chromate can cause harmful effects to the urinary, blood, reproductive and nervous systems and may create risk of cancer. Use a respirator as explained in Paragraph 4 of this Information Sheet.

Some polyester products may contain additional hazardous ingredients. To determine the hazardous ingredients present, their applicable exposure limits and other safety information, read the Material Safety Data Sheet for each product (identified by product number) before using. If unavailable, these can be obtained, free of charge, from your Polynt Composites representative.

Polyester products have at least two components that must be mixed before use. Any mixture of components will have hazards of all components. Before opening the packages, read all warning labels. Observe all precautions.

Keep polyester containers closed when not in use. In case of spillage, absorb with inert material and dispose of in accordance with applicable regulations. Emptied containers may retain hazardous residue. Do not cut, puncture or weld on or near these containers. Follow container label warnings until containers are thoroughly cleaned or destroyed.

**FOR INDUSTRIAL USE AND PROFESSIONAL APPLICATION ONLY.  
KEEP OUT OF REACH OF CHILDREN.**



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The Buyer's sole and exclusive remedy against Seller shall be for the replacement of the product or refund of the purchase price in the event that a defective condition of the product should be found to exist by Seller. NO OTHER REMEDY (INCLUDING, BUT NOT LIMITED TO, INCIDENTAL OR CONSEQUENTIAL DAMAGES FOR LOST PROFITS, LOST SALES, INJURY TO PERSON OR PROPERTY, OR ANY OTHER INCIDENTAL OR CONSEQUENTIAL LOSS) SHALL BE AVAILABLE TO THE BUYER.

The sole purpose of this exclusive remedy shall be to provide Buyer with replacement of the product or refund of the purchase price of the product if any defect in material or workmanship is found to exist. This exclusive remedy shall not be deemed to have failed its essential purpose so long as Seller is willing and able to replace the defective products or refund the purchase price.

To the best of our knowledge, the information contained herein is accurate.

Final determination of the suitability of the material for the use contemplated, the manner of use and whether the suggested use infringes any patents is the sole responsibility of the buyer.