

VINYLESTER TOOLING GELCOAT PA

GEL COAT

SPRAY



Technical data sheet

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DESCRIPTION

A pre-accelerated gel coat based on Vinyl Ester unsaturated polyester resin.
Cured using MEKP peroxide.

APPEARANCE

Product is available in orange, green and black colours.
The product is formulated to assure complete hide in wet film thickness at 500µm. However some bright shades may have a hide slightly lower opacity.

PROPERTIES / ADVANTAGES

This product has chemical resistance properties
This product has heat resistance properties.
This product has good resistance to thermal shock caused by variation in temperature.
This product has improved impact resistance properties
This product offers improved scratch resistance properties.
This product has excellent gloss retention properties.

APPLICATION

This gel coat is ready to be applied using airless spray equipment.
Mix the product slowly but thoroughly for 10 minutes prior to each shift start up. Apply the correct film thickness. A wet film thickness between 300 to 600µm is required ideally applied in 3 even passes.
Check that the correct level of MEKP is added. A level of 1,8% w/w is recommended. Do not use more than 3% w/w or lower than 1,2% w/w of MEKP catalyst.
Minimum application temperature : 18°C
This product is not designed for use with a roller or brush.

USE AREAS

This product is recommended for mould manufacturing process and provide durable surfaces to withstand the repeated mouldings of GRP laminates.

STORAGE / SHELF LIFE

Shelf-life : 4 Months .
When the product is sealed in its original packing, stored indoors away from direct sunlight and direct heat sources and ideally at ambient temperature between 15°C and 25°C .

TYPICAL CHARACTERISTICS

LIQUID		CURING	
Density.....	1,11 - 1,15	Catalyst : Low activity catalyst	
Viscosity..... [25°C - Spindle 4 - 4 rpm]	10000 - 14000	Gel time (200g - 25°C - 1,8% MEKP) :.....	12 - 18
Thixotropic index..... [2/20 rpm]	6,0 - 7,5	Peak time (200g - 25°C - 1,8% MEKP) :.....	18 - 35
Solid content..... [15mn at 150°C]	56 - 60	Peak exotherm (200g - 25°C - 1,8% MEKP) :.....	180 - 220
Sag resistance (µm - wet)	500	Film cure (500µ - 20°C - 2% MEKP) :.....	30 - 50
Hide	700 - 900	MECHANICAL PROPERTIES AFTER CURING (On the base resins - Post Cure 16h at 40°C)	
Colour	Depends colour	. H.D.T (NFT ISO 75) :(2h at 120°C).....	116 °C
		. Strength :(Tensile : ISO 527) :.....	45 MPa
		. Elongation at break(Tensile : ISO 527) :.....	3,0 %

For all additional information, refer to the Safety Data Sheet n° FP17576 available on our website address www.polynt.com.

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