

POLYCOR M1 BR

GEL COAT

BRUSH



Technical data sheet

Date sheet n° : 6100
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DESCRIPTION

A pre-accelerated gel coat base on unsaturated polyester resin. It is cured using MEKP peroxide.

APPEARANCE

Product is available in white, off-white and wide range of colours and can be colour matched according to a particular demand. The product is formulated to assure a hide in wet film thickness of 500µm. However some bright shades may have a hide slightly lower opacity.

PROPERTIES / ADVANTAGES

The product is easy to use with highly controlled rheological properties providing high resistance to sagging.

APPLICATION

This gel coat is ready to use by application with a brush. 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 working with a brush to ensure a level even thickness of 500 micron. Check that the correct level of MEKP is added. A level of 1,8% is recommended. Do not use more than 3% or lower than 1,2% MEKP catalyst. Minimum application temperature : 15°C. This product is not designed for use with a spray gun.

USE AREAS

Product is recommended for the manufacture of industrial pieces requiring additional fire retardance. The product was designed for INTERNAL pieces ONLY.

STORAGE / CONSERVATION

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

| | |
|--|----------------|
| . Density..... | 1,55 - 1,65 |
| . Viscosity (dPa.s)..... [25°C - Spindle 5 - 5 rpm] | 300 - 350 |
| . Thixotropic index..... [5/50 rpm] | 4,5 - 6,0 |
| . Solid content (%)..... [15mn at 150°C] | 72 - 78 |
| . Sag resistance : (µm - wet) | 500 |
| . Hide depends colour : (µm - wet) | 500 - 700 |
| . Colour : | Depends colour |

CURING

| | |
|---|-----------|
| . Catalyst : Low activity catalyst | |
| . Gel time (mn) (200g - 25°C - 1,8% MEKP) :..... | 10 - 14 |
| . Peak time (mn) (200g - 25°C - 1,8% MEKP) :..... | 30 - 40 |
| . Peak exotherm (°C) (200g - 25°C - 1,8% MEKP) :..... | 100 - 140 |
| . Film cure (mn) (500µ - 20°C - 2% MEKP) :..... | 40 - 50 |

MECHANICAL PROPERTIES AFTER CURING (On the base resins - Post Cure 16h at 40°C)

| | |
|--|--------|
| . H.D.T (NFT ISO 75) :..... | 57 °C |
| . Strength : (Tensile : ISO 527) :..... | 55 MPa |
| . Elongation at break (Tensile : ISO 527) :..... | 2,2 % |

For all additional information, refer to the Safety Data Sheet n° FP11767 available at our website address www.polynt.com.

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