

POLYCOR M1 PA

GEL COAT

SPRAY



Technical data sheet

Date sheet n° : 6200

Updated : 28.04.15

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 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 in 3 even passes. 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 roller or brush.

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.....	1,52 - 1,58
. Viscosity (dPa.s)..... [25°C - Spindle 4 - 4 rpm]	160 - 190
. Thixotropic index..... [2/20 rpm]	6,5 - 8,0
. Solid content (%)..... [15mn at 150°C]	70 - 76
. 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.

The information given herein must be read in conjunction with the relevant health and safety data. Starting point formulations and suggestions for use are given for guidance only and are made without warranty. This document should not be construed as permission or inducement to practise any invention by patent without the authority of the owner.