

POLYCOR TOOLING PA

GEL COAT

SPRAY



Technical data sheet

Date sheet n° : 7700

Updated : 07.12.15

DESCRIPTION

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

APPEARANCE

Product is available in orange, green and black.
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

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
It has excellent gloss retention properties.

APPLICATION

This gel coat is ready to use by application with air atomised 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 400 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

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

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.....	1,11 - 1,15
. Viscosity (dPa.s)..... [25°C - Spindle 4 - 4 rpm]	100 - 150
. Thixotropic index..... [2/20 rpm]	6,0 - 7,5
. Solid content (%)..... [15mn at 150°C]	51 - 55
. Sag resistance : (µm - wet)	500
. Hide depends colour : (µm - wet)	700 - 900
. Colour :	Depends colour

CURING

. Catalyst : Low activity catalyst	
. Gel time (mn) (200g - 25°C - 1,8% MEKP) :.....	22 - 28
. Peak time (mn) (200g - 25°C - 1,8% MEKP) :.....	30 - 40
. Peak exotherm (°C) (200g - 25°C - 1,8% MEKP) :.....	200 - 240
. Film cure (mn) (500µ - 20°C - 2% MEKP) :.....	70 - 80

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

. H.D.T (NFT ISO 75) :(3h at 80°C + 2h at 120°C).....	79 °C
. Strength : (Tensile : ISO 527) :.....	45 MPa
. Elongation at break (Tensile : ISO 527) :.....	3,9 %

For all additional information, refer to the Safety Data Sheet n° FP11265 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.