

GEL COAT

Resin Characteristics
Orthophthalic gelcoat
Medium Reactivity

Versions
Spray-Up (P)
Brush (F)

Molding Technique
Spray-Up
Brush

End Products
Industrial equipments, sanitary

Remarks
Good hydrolytic resistance
Good weatherability
Excellent pigmentation

Liquid Properties

Viscosity ¹ (Brush)	4000-6000	cp
Viscosity ¹ (Spray)	1500-2500	cp
Thix Index	min. 3.5	
Solid Content	60-65	%
Acid Value	max. 20	mgKOH/g
Gel Time ²	10-20	minutes
Peak Exotherm	160-180	°C

¹ 20°C, Brookfield, sp4 50/5rpm

² 20°C, 1ml Co (1% soln.), 1ml Curox M300 per 100g resin

Mechanical Properties of Non Reinforced Clear Castings of Base Resin³

Tensile Strength	65	Mpa	ISO 527
Elongation at Break	2.5	%	ISO 527
Tensile Modulus	3700	Mpa	ISO 527
Flexural Strength	110	Mpa	ISO 178
Flexural Modulus	3900	Mpa	ISO 178
HDT	65	°C	ISO 75A
Hardness	42	Barcol 934-1	

³ Samples post cured 3 hours at 80°C and 1 hour at 100°C.

Stability
The resin is stable for at least 6 months if stored in original packaging in a dry, well ventilated area away from direct sunlight. The storage temperature must not exceed 25°C.

Packaging
Available in
1000kg Shutz containers
220kg Drums
20 kg Buckets

(11/2004E-R01)



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