

GCVN Serie X

Vinylester gelcoat for tooling

Description

- Vinylester gelcoat, formulated from epoxy bisphenol A resin, urethane vinylester.
- Perfectly suited to the production of polyester moulds.

Properties

- Substantial gloss retention
- Easy to degas
- Good resistance to splitting
- Significant resistance to high temperatures together with good elongation strength.
- For production of technical areas such as release, trimming or gel-cutting areas, please use Ref. GCVN MOULDS EDGE, filled, particularly improving surface hardness.

Non-polymerised gelcoat physical properties

	Test method	Product type		Metric unit
Density	DEV MOP 02-09		1.25 – 1.30	
Viscosity	DEV MOP 02-02	Machine Reference – VM	11 000 – 18 000	mPa.s
		Brush Reference – VB	17 500 – 42 000	mPa.s
		Spatula Reference – VS	380 000 – 420 000	mPa.s
Thixo. index	DEV MOP 02-02		>5	
Solid content	DEV MOP 02-06	Machine Reference – VM	55 – 58	%
		Manual References – VB/VS	59 – 62	%
Gel time	DEV MOP 02-01		20 – 25	min
Lamination time	DEV MOP 02-13		120 – 180	min

Base resin mechanical properties

	Test method		Metric unit
Tensile strength	ISO 527-2	90	MPa
Tensile modulus	ISO 527-2	140	MPa
Elongation at break	ISO 527-2	4	%
HDT	ISO 75/A	145	°C

POLYPROCESS S.A.S






GCVN Serie X

Vinylester gelcoat for tooling

Complementary references

- Manual application with a brush – VB – or with a spatula – VS – or application with a dispensing unit – VM
- Casting reference or paraffin-waxed reference – TOP COAT
- RA Reference: abrasion high resistance for concrete mould production – alkaline – and production of mould technical areas
- All RAL colours or according to countertype

Product features

Colour control		Spectro-colorimetric analysis of each batch according to RAL certified chart or countertype. ΔL , Δa , Δb and ΔE according to colour.	
Equipment and settings		Spray gun Nozzle: 2.5 to 3mm Pressure: 3 to 4bars Mould distance: 30 to 50cm	Airless Assisted air nozzle: 419 1840 or 2140 Carbide nozzle – according to part dimensions Mould distance: 60 to 80cm
User instructions		<ul style="list-style-type: none"> - Slightly stir the gelcoat before use. - Use a Methyl Ethyl Ketone Peroxide – MEKP – catalyst between 1 and 2%. - Check the gelcoat/catalyst mix and homogeneity. 	
Thickness		<ul style="list-style-type: none"> - The applied gelcoat thickness should not exceed 400 to 800 microns – control to be done with a thickness gauge. 	
Storage		<ul style="list-style-type: none"> - This product should be stored no more than 3 months after the production date. - Store away from humidity. - Store in original sealed packaging at a temperature between 15°C to 25°C. 	
Health & Safety	RoHS compliant	<ul style="list-style-type: none"> - All our products comply with RoHS regulation. - All our products are heavy metals free, such as: lead, mercury, cadmium, chromium. - All our products are halogens free. - Please refer to the product Health & Safety Datasheet. 	

All information and suggestions given in this datasheet are based on personal work and we therefore considered them reliable. However we cannot be held responsible for the characteristics or outcomes achieved by the use of the above mentioned products.