

GCI Serie S

Polyester gelcoat, isophtalic

Description

- Polyester gelcoat, pure isophtalic.
- Perfectly suited to the production of polyester parts requiring high resistance to environmental exposure.

Properties

- Substantial resistance to UV and weather
- Good resistance to hydrolysis
- Good resistance to a wide range of chemicals
- Good gloss retention

Non-polymerised gelcoat physical properties

	Test method	Product type		Metric unit
Density	DEV MOP 02-09		1.18 – 1.24	
Viscosity	DEV MOP 02-02	Machine Reference – VM	11 000 – 18 000	mPa.s
		Brush Reference – VB	35 000 – 43 000	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	65 – 70	%
		Manual References – VB/VS	70 – 75	%
Gel time	DEV MOP 02-01		5 – 9	min
Lamination time	DEV MOP 02-13		45 – 60	min

Base resin mechanical properties

	Test method		Metric unit
Tensile strength	ISO 527-2	80	MPa
Tensile modulus	ISO 527-2	3 500	MPa
Elongation at break	ISO 527-2	4.30	%
HDT	ISO 75/A	89	°C

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

Uses

- Marine
- Industrial body – vehicle bodies
- Flat panels
- Industrial and plastic boilermaking
- Urban furniture
- Industrial parts

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
- Adjusted gel time – FCI = Fast Curing Injection = shorter gel time for RTM
- Internal release agent – in order to ease de-moulding and to prevent moulds clogging
- 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		<u>Spray gun</u> Nozzle: 2.5 to 3mm Pressure: 3 to 4bars Mould distance: 30 to 50cm	<u>Airless</u> 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.