

ICOM GELCOAT SPRAY 4835 B/9376 WHITE

PRELIMINARY PRODUCT INFORMATION

TYPE

Gelcoat based on isophthalic acid/neopentylglycol
highly thixotropic, preaccelerated

APPLICATION

Gelcoat for spray application

DEVELOPMENT PRODUCT

This product is serving for trial purposes only. Deviations which might occur during transfer into manufacturing in a commercial scale are possible and do not constitute any material defect.

SPECIAL PROPERTIES

very good air release, rapid curing, good color stability also in different layer thicknesses, increased Barcol hardness.

TENTATIVE PRODUCT DATA

Determined per batch:

Non-Volatile Matter DIN 55671

non-volatile matter [] 62 - 66
(120 °C; 5 min)

Thixotropic Strength (UP-Resins) VLN 236

dynamic viscosity 50 [mPa.s] 2700 - 3300
(23 °C; 5)

dynamic viscosity 1 [mPa.s] 71000 - 86000
(23 °C; 5)

Gel Time (UP-Resins) DIN 16945 / 6.3.1.2

gel time [min] 11 - 19
2 % Butanox M50
(20 °C)

Not continually determined:

Density (Liquids) DIN EN ISO 2811-2

density [g/cm³] 1,22
approx.
(20 °C)

Flash Point DIN EN ISO 1523

flash point [°C] 29
approx.

TENTATIVE PRODUCT DATA OF CURED BASIC RESIN

Not continually determined:

Tensile Test (Unreinforced Plastics) DIN EN ISO 527-2

tensile strength [MPa] 45
breaking elongation [] 1,5

Hardness (BARCOL) DIN EN 59

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Barcol-hardness 934-1 37 - 41

Water Absorption (Plastics) DIN EN ISO 62

water absorption [%] 0,21

(7 d)

Not continually determined data do not constitute a quality description, but correspond to single values, determined on a random sample.

Deviations caused by production are possible.

USE

Fine layers of UP-FRP moulded parts that have to resist water and chemicals even at elevated temperatures; e. g. for sanitary articles

CURING

Curing is possible at room temperature by addition of keton peroxide, e.g. MethylEthylKetonPeroxide. Do not catalyze at levels below 1 % or above 3 % as this may cause curing problems. Two percent is recommended. Take care that the water content of the chosen peroxide is as low as possible. The water content of the peroxide should be below 3 %. During processing room temperature and temperature of Gelcoat and mould should be not less than 20 °C.

PROCESSING

The Gelcoat has to be well homogenised in the original packing shortly before processing, either by stirring or by rolling the drums. The Gelcoat should be applied in a thickness of 0.4 - 0.6 mm (about 600 - 700 g Gelcoat per m²) by gelcoat-spray-equipments or overhead spray gun (nozzle diameter 2 - 3 mm, spray pressure 1 - 3 bar, air quantity about 250 l/min.). Apply in several thin overlapping coats rather than a single thick coat. This will help avoid sagging and porosity. Make sure the air pressure is adjusted properly, and the spray gun and lines are free of solvent, water and oil. Observe that the gelcoat as well as the mould should have temperature of at least 20 °C. Laminating should start as soon as the gelcoat layer has cured. Sufficient curing is achieved if after dabbing with a finger no gelcoat adheres to the finger although the surface may be sticky.

PROCESSING TIME

The processing time may be varied with a suitable choice of peroxide concentration.

HUE

For optimal appearance it is recommended to use only one batch per moulded part. Please blend and homogenise several batches if the use of only one batch is not possible.

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STORAGE

At temperatures up to 25 °C storage stability packed in original containers amounts to at least 210 days.

The product should be stored under exclusion of direct sunlight in the original, undamaged and closed packaging in a dry and cool place. Geltime and curing time can change during progressive storage. Shelf life is reduced at higher storage temperatures.

PRECAUTIONS

Please notice the information in the material safety data sheet (MSDS).

ACCELERATOR

The Gelcoat contains Co-accelerator. Prolonged storage can reduce the effect of the accelerator. An addition of 0.5 - 1.0 % accelerator Co 1 may be necessary to restore the original potlife.

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All information is given, based upon our best knowledge, but without liability to us. Data has been obtained by laboratory experiments made by our supplier. Since the conditions under which the product is consumed are outside of our control, the product should be tested before use.