

ICOM PO TOOLING GELCOAT VE F-272

CHARACTERISTICS

ICOM PO TOOLING GELCOAT VE F-272 is a special Vinyl ester based, thixotropic, preaccelerated gel-coat with high performance and easy application characteristics.

ICOM PO TOOLING GELCOAT VE F-272 is used for the production of corrosion resistant FRP parts which will be highly resistant to acids, bases, and many other chemicals.

Chemical resistant tanks, pipes and mould production are the major application areas, where high resistance to heat, chemicals, and other corrosives is needed.

Because of the nature of the vinyl ester polymer, applications requiring yellowing resistance is NOT advised. ICOM PO TOOLING GELCOAT VE F-272 is an advanced formula with good air release properties, but as vinyl esters still have some tendency to foaming, instead of a classical MEK-P, the use of a less foaming MEK-P like Butanox LPT is advised to be used. It is also possible to use Trigonox 239 which stops foaming but increases the curing time.

BASIC PROPERTIES	<input type="radio"/> OPTIONAL	<input checked="" type="radio"/> YES
Base	Vinyl ester	
Versions	Spray and Brush 272	
Acceleration	<input checked="" type="radio"/>	

PROPERTIES OF LIQUID FORM	METHOD	MARGIN	VALUE SPRAY VERSION	VALUE BRUSH VERSION
Viscosity* Brookfield®	ISO 2555	± 30 %	1600-1800 cp	5000-7000 cp
Thixotropy	-	-	Thixotropic	Thixotropic
Gel Time**	ISO 2535	± 40 %	12'-17'	12'-17'
Shelf life at 20 °C	-	-	4 mths.	4 mths

* Measured at 23 °C, 50 rpm with Spindle 4

** Measured at 23 °C added 2 % Mek-p (Butanox M 60)

PROPERTIES OF CURED RESIN***	METHOD	MARGIN	VALUE
Heat Deflection Temperature (HDT)	ISO 0075-A	± 10 %	110 °C
	ISO 0075-B		115 °C
Water Absorption	ISO 0062	± 10 %	0,150 %
Barcol Hardness (Barcol 934-1)	ASTM-D 2583	± 10 %	40
Total Volume Shrinkage	ISO 3521	± 10 %	7,4 %

MECHANICAL PROPERTIES OF CURED RESIN ***	METHOD	MARGIN	VALUE
Flexural Strength	ISO 0178	± 10 %	155 MPa
Flexural Modulus	ISO 0178	± 10 %	4100 Mpa
Elongation at Break	ISO 0178	± 10 %	4,90 %
Tensile Strength	ISO 0527	± 10 %	75 Mpa
Modulus of Elasticity in Tensile	ISO 0527	± 10 %	3600 Mpa
Elongation at Break	ISO 0527	± 10 %	3,8 %
Izod Impact Strength	ISO 0180	± 10 %	12 kJ/m ²

ICOM PO TOOLING GELCOAT VE F-272

STORAGE CONDITIONS AND HANDLING

The product should be stored in a dark and dry place at temperatures between 5 °C and 23 °C. Shelf life is reduced at higher temperatures. The shelf life of styrene containing unsaturated polyesters will be significantly reduced when exposed to light.

Keep away from ignition sources: flames, pilot lights, electrical sparks and sparking tools. No smoking. Stored separately from oxidizing materials, peroxides and metal salts.

Store in darkness and keep in 100% light tight containers and keep lid firmly closed.

This resin is subject to the Highly Flammable Liquids Regulations.

06/2016

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 condition under which the product is consumed is outside of our control, the product should be tested before use.