

Date sheet n°

GEL COAT

2911

POLYCOR M1 PA

GUN

I. DESCRIPTION

A pre-accelerated unsaturated polyester Gel-Coat with improved fire retardence. It is cured with MEKP peroxide to form a protective and decorative layer for GRP (Glass Reinforced Polyester) composites.

II. PROPERTIES / ADVANTAGES

Its rheological properties are controlled to give well, resistance to sagging, curing characteristics and hence this product is easy to use.
In association with layer of fire-retarded polyester resin M1, the composit is classified M1 (a certificate is available upon request).

III. USE AREAS

Product is recommended for the manufacture of industrial pieces requiring additional fire retardence.
The product was designed for INTERNAL pieces ONLY.

IV. PRESENTATION

Product is available in a wide range of colours and can be colour matched according to a particular demand.

V. PACKAGING

Packaging : 25 Kg

Packaging : 250 Kg

VI. STORAGE / CONSERVATION

Keep the product at ambient temperature between 15°C and 25°C .
Shelf life : 4 months .

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VII. CHARACTERISTICS*** LIQUID**

. Flash point NFT 30050 :.....	31 °C
. Density :.....	1,52 - 1,58
. Viscosity (mPa.s) :..... [25°C - Brookfield - Spindle 4 - 4 rpm]	16000 - 19500
. Thixotropic index :..... [2/20 rpm]	6,0 - 7,5
. Solid content (%) :..... [1h at 150°C]	71 - 76
. Sag resistance (wet) :.....	500µm
. Hide :.....	300µm
. Colour :.....	Depends colour

*** CURING**

. Catalyst : MEKP	
. Gel time (mn) (200g - 25°C - 1,8% MEKP) :.....	10 - 14
. Peak time (mn) :.....	30 - 40
. Peak exotherm (°C) :.....	100 - 140
. Film cure (mn) : (500µ - 20°C - 2% MEKP).....	40 - 50

*** MECHANICAL PROPERTIES AFTER CURING (On the base resins)**

. H.D.T NFT ISO 75 :.....	57 °C
. Tensile : ISO 527	
- Strength :.....	55 MPa
- Elongation at break :.....	2,2 %

VIII. APPLICATION

This gel coat is ready to use by application with airless spray equipment. Mix the product slowly but thoroughly before use and apply the correct film thickness. A wet film thickness between 450 to 600 microns is the optimum.

Check that the correct level of MEKP is added. A level of 1,8% is recommended. Do not use more than 3% or lower than 1,2% MEKP catalyst.

Minimum application temperature : 15°C.

Never applied using a roller or a brush.

For all additional information, refer to the Safety Data Sheet n°2911 available at our website address www.crayvalley.com.