

# CRYSTIC GELCOAT 32PA

## Chemical Resistant Iso - NPG Brush Gelcoat with very low porosity

### Introduction

Crystic Gelcoat 32PA is a chemical resistant pre-accelerated Iso - NPG brush gelcoat with very low porosity. It is available in a full range of colours. The information contained in this leaflet also applies to pigmented versions.

### Applications

Crystic Gelcoat 32PA is designed for use in the manufacture of FRP composite components where very low porosity is required. It is suitable for use in sanitary ware applications, particularly in the manufacture of sinks, shower trays and baths.

### Features and Benefits

Crystic Gelcoat 32PA is resilient and heat resistant and can be polished to a high gloss.

### Formulation

Crystic Gelcoat 32PA should be allowed to attain workshop temperature (18° - 20°C) before use. Stir well by hand, or with a low shear mixer to avoid aeration, and then allow to stand to regain thixotropy. Crystic Gelcoat 32PA requires only the addition of catalyst to start the curing reaction. The recommended catalyst is Butanox M50 (or other equivalent catalyst) which should be added at 2% into the gelcoat (please consult our Technical Service department if other catalysts are to be used). The catalyst should be thoroughly incorporated into the gelcoat, with a low shear mechanical stirrer where possible.

### Pot Life

Temperature	Pot Life in Minutes
15°C	15
20°C	11
25°C	9

The gelcoat, mould and workshop should all be at, or above, 15°C before curing is carried out.

### Application

The application of Crystic Gelcoat 32PA should be controlled at 0.5-0.6mm wet film thickness. As a guide, approximately 500-750g/m<sup>2</sup> of gelcoat mixture (depending on pigment) will give the required thickness when evenly applied.

### Additives

Crystic Gelcoat 32PA is supplied in a full range of colours. This eliminates the potential for mixing errors with small quantities of pigment paste. The addition of fillers or pigments can adversely affect the performance of the cured gelcoat.

### Recommended Testing

It is recommended that customers test all pigmented gelcoats before use under their own conditions of application to ensure the required surface finish is achieved.

## Typical Properties

The following tables give typical properties of Crystic Gelcoat 32PA when tested in accordance with SB, BS EN or BS EN ISO test methods.

Property		Liquid Gelcoat
Appearance		Mauvish, cloudy
Viscosity @ 25°C		thixotropic
Specific Gravity @ 25°C		1.1
Acid Value	mgKOH /g	16
Volatile Content	%	34
Stability @ 20°C	months	3
Gel time @ 25°C using 2% Butanox M50 (or other equivalent catalyst)	minutes	9

Property		Fully cured *Gelcoat (unfilled casting)
Barcol Hardness (model GYZJ 934-1)		46
Water Absorption 24 hrs @ 23°C	mg	17
Deflection Temperature under load† (1.80 MPa)	°C	83
Elongation at Break	%	2.0
Tensile Strength	MPa	64
Tensile Modulus	MPa	3800

\* Curing Schedule - 24 hrs @ 20°C, 3 hrs @ 80°C

† Curing Schedule - 24 hrs @ 20°C, 5 hrs @ 80°C, 3 hrs @ 120°C

## Post Curing

Satisfactory laminates for many applications can be made with Crystic Gelcoat 32PA by curing at workshop temperature (20°C). However, for optimum properties, laminates must be post-cured before being put into service. The moulding should be allowed to cure for 24 hours at 20°C, and then be oven-cured for 3 hours at 80°C.

## Storage

Crystic Gelcoat 32PA should be stored in its original container and out of direct sunlight. It is recommended that the storage temperature should be less than 20°C where practical, but should not exceed 30°C. Ideally, containers should be opened only immediately prior to use.

## Packaging

Crystic Gelcoat 32PA is supplied in 25 kg and 225 kg containers.

## Health and Safety

Please see separate Material Safety Data Sheet.