

CRYSTIC GELCOAT 42PA

General Purpose Sandable Brush Gelcoat

Introduction

Crystic Gelcoat 42PA is a pre-accelerated, orthophthalic, filled, sandable brush gelcoat. It has been specially designed for applications that are to be post-painted. The gelcoat, is available in a limited range of colours and the information contained in this leaflet also applies to pigmented versions.

Formulation

Crystic Gelcoat 42PA 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. The product 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
25°C	10

Curing should not be carried out at temperatures below 15°C. The gelcoat, mould and workshop should all be at, or above, this temperature.

Additives

Crystic Gelcoat 42PA is supplied in a limited range of colours. This eliminates the potential for mixing errors with small quantities of pigment paste. The gelcoat is filled, so the addition of further quantities of filler, or pigments, may adversely affect the properties of both liquid and 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.

Post Curing

Satisfactory laminates for many applications can be made with this gelcoat by curing at workshop temperature (20°C).

Typical Properties

The following tables give typical properties of Crystic Gelcoat 42PA when tested in accordance with SB, BS, EN or BS, EN, ISO test methods.

Property		Liquid Gelcoat
Viscosity @ 25°C		thixotropic
Specific Gravity @ 25°C		1.3
Stability @ 20°C	months	3
Gel time @ 25°C using 2% Butanox M50 (or other equivalent catalyst)	minutes	10

Property		Fully cured *Gelcoat
Barcol Hardness (model GYZJ 934-1)		37
Water Absorption 24 hrs @ 23°C	mg	20
Deflection Temperature under load† (1.80 MPa)	°C	54
Elongation at Break	%	2.1
Tensile Strength	MPa	46
Tensile Modulus	MPa	3658

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

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

Storage

Crystic Gelcoat 42PA 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 42PA is supplied in 25 kg and 225 kg containers.

Health and Safety

Please see separate Material Safety Data Sheet