CRYSTIC GELCOAT 65PA RAPIDE

Brush Gelcoat (available in a wide range of RAL colours)

Introduction
Crystic Gelcoat 65PA Rapide is a pre-accelerated, isophthalic gelcoat. It has been formulated for brush application. Crystic Gelcoat 65PA Rapide is available in a wide range of RAL colours and the information contained in this leaflet applies to all colours.

Applications
Crystic Gelcoat 65PA Rapide is designed for use in the general industrial and building industries.

Approvals
When backed with Crystic 356PA, it is capable of obtaining a Class 1 certificate to BS476 Part 7 and of satisfying the requirements of the Building Regulations for a Class O structure. The same laminate can also achieve an M1 rating to the French Epiradiateur NFP 92-501 test.

Formulation
Crystic Gelcoat 65PA Rapide should be allowed to attain workshop temperature (18ºC-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 65PA Rapide requires only the addition of catalyst to start the curing reaction. The recommended catalyst is Catalyst M (or Butanox M50), 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 ºC	24
20ºC	15
25ºC	10

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

Application
For normal moulding, the application of Crystic Gelcoat 65PA Rapide should be controlled to 0.4-0.5 mm (0.015-0.020 inch) wet film thickness. As a guide, approximately 450-600 g/m^2 of gelcoat mixture (depending on colour) will give the required thickness when evenly applied.

Additives
Crystic Gelcoat 65PA Rapide is supplied in a wide range of RAL colours. The addition of fillers can adversely affect the quality of the surface achieved. Crystic Gelcoat 65PA Rapide can be used as a flowcoat provided that 2% Crystic Solution MW is added to overcome the normal tackiness.

Typical Properties

The following tables give typical properties of Crystic Gelcoat 65PA Rapide when tested in accordance with SB, BS, BS EN or BS EN ISO test methods.

Property		Liquid Gelcoat
Viscosity @ 25ºC		thixotropic
Specific Gravity @ 25ºC		1.1 – 1.2
Volatile Content	%	34
Geltime at 25ºC using 2% Catalyst M (Butanox M50)	minutes	10
Stability in the dark @ 20ºC	months	3

Property		Fully cured* (casting)
Barcol Hardness (Model GYZJ 934-1)		42
Water Absorption 24hrs @ 23ºC	mg	18
Deflection Temperature under load (1.80MPa)†	°C	75
Elongation at Break	%	3.0
Tensile Strength	MPa	75
Tensile Modulus	MPa	3500

* Curing schedule - 24 hrs @ 20ºC, 3 hrs @ 80ºC

† Curing schedule - 24 hrs @ 20ºC, 5 hrs @ 80º C, 3 hrs @ 120º C

Post-Curing

Satisfactory laminates for many applications can be made with Crystic Gelcoat 65PA Rapide by curing at workshop temperature (20ºC). However, for optimum properties, laminates should be post-cured before being put into service. The moulding should be allowed to cure for 24 hours at 20ºC, and then be oven-cured for 3 hours at 80ºC.

Storage

Crystic Gelcoat 65PA Rapide should be stored in the dark in suitable, closed containers. It is recommended that the storage temperature should be less than 20ºC where practical, and should not exceed 30ºC. Ideally, containers should be opened only immediately prior to use.

Packaging

Crystic Gelcoat 65PA Rapide is supplied in 25kg containers.

Health and Safety

See separate Material Safety Data Sheet.

January 2008

SCOTT BADER

Scott Bader Company Limited
Wollaston, Wellingborough,
Northamptonshire NN29 7RL
Telephone: +44 (0) 1933 663100
Facsimile: +44 (0) 1933 666139
www.scottbader.com

INVESTOR IN PEOPLE